

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025593**Date Inspected:** 26-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

SHIP # 19, OBG SEGMENT 14W

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3020AJ-283

SEG3020E-006

SEG3020C-006

SEG3020F-067, 068

SEG3020AB-137

SEG3020AG-033

SEG3020AY-285

SHIP # 19, OBG SEGEMENT 13AE

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During random in process inspection this QA Inspector observed that ZPMC personnel were installing traveler rail bracket on Side Panel (SP) of OBG segment 13AE. See attached photograph for more details.

SHIP # 19, OBG SEGMENT 14W

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds and base metal of Side Panel, Bottom Panel, Edge Panel and Deck Panel located on OBG segment 14W. The following issue(s) have been noted.

Grinding marks (4) observed on SP 3135A at PP 128 cable side.

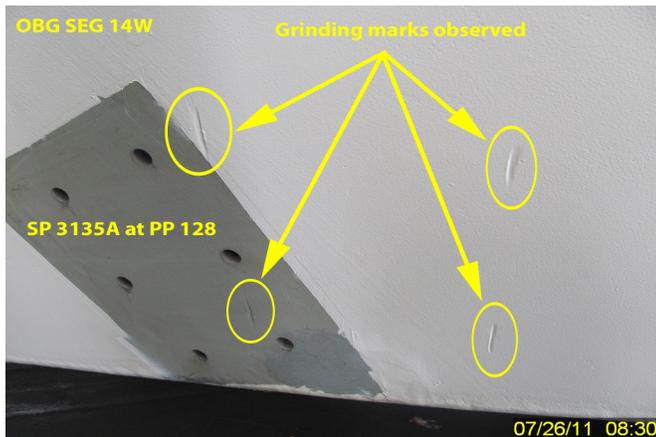
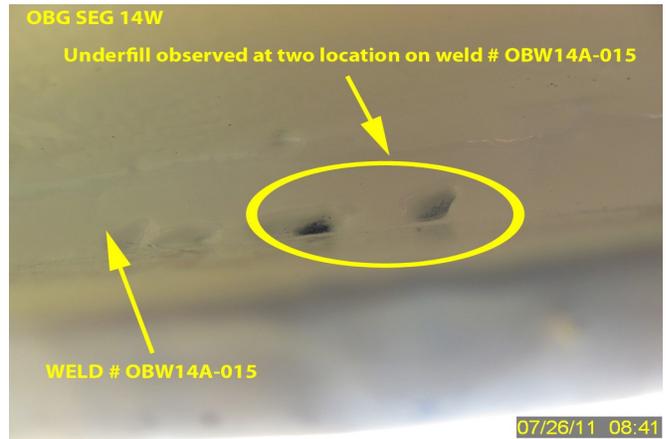
Arc strike observed on SP 3145B at PP 126 cable side.

Porosity observed on weld joint OBW14A-015 joining drip plate to SP 3131A at PP 125 cable side.

Underfill observed at two locations on weld joint OBW14A-015 joining drip plate to SP 3131A at PP 125.5 cable side.

See attached photograph for more details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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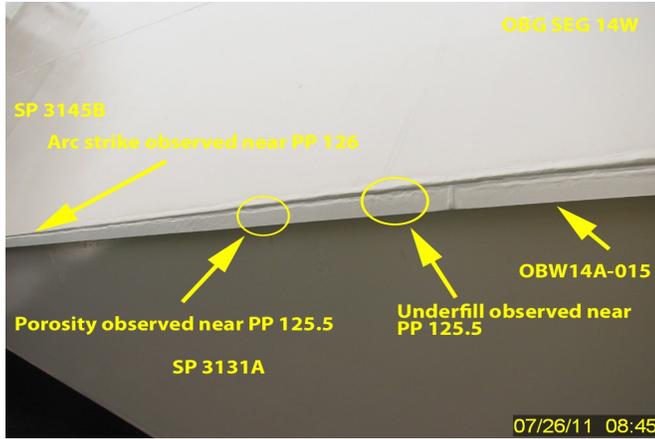
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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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