

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-021265**Date Inspected:** 30-Jun-2010**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:** Li Yan Hua**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 Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 11DW

Shielded Metal Arc Welding (SMAW) in the 3F position of Cross Beam side Corner Assembly, weld joint SEG071E-036. The welder is identified as 045204. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-4113-2. See attached photograph Pic_001

OBG Segment 12AW

During in process visual inspection of 12AW, this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Longitudinal Diaphragm weld attached to PP110. See attached photograph Pic_002

Bay 19 - Bike Path

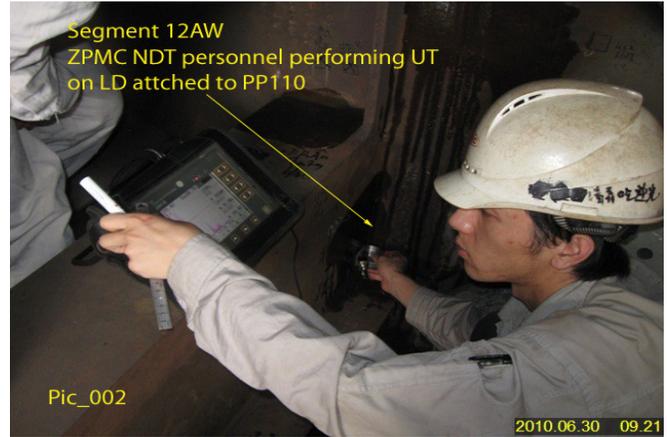
During in process inspection, this QA Inspector observed in progress fit up of BK4A-004. Plate BKPL6B was being installed. During Fit up ZPMC Quality Control (QC) Li Ming Yang was available at site.

WELDING INSPECTION REPORT

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Bay 19 – Suspender Brackets

This QA inspector performed Visual Testing (VT) after repair on the suspender Brackets that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The member is identified as Suspender Bracket SB48E, SB54W and SB60E as per notification #6091 item # 2.



Summary of Conversations:

No relevant conversations reported on this date.

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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
