

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-021268**Date Inspected:** 28-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:** Wu Zhi Cheng**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 9BE-9CE

Flux Core Metal Arc Welding (FCAW) in the 2F position of 8BE Bottom Panel Retro Plate attached to CB Side LD, weld # RETRO-8BE-B2-056. The welder is identified as 220066. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132. See attached photograph Pic_002

OBG Segment 11BE

Flux Core Metal Arc Welding (FCAW) in the 2F position of Cross beam side Corner Assembly, weld # RETRO-SEG068G-001. The welder is identified as 50242. ZPMC Quality Control (QC) is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of Side Panel at Cross beam side, weld joint

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OBE9B-007. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-BU2-FCM-1. See attached photograph Pic_001

OBG Segment 8CW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 8CW-LD Holdback area (Field Splice) as per notification #6071 item # 1

The weld designations reviewed are as follows:

SEG047D-035 and 036
SEG047F-035 and 036

OBG Segment 8CW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 8CW-LD Holdback area where Heat & Split (Field Splice) as per notification #6071 item # 2

The weld designations reviewed are as follows:

SEG047D-006, 032 and 034
SEG047F-006, 032 and 034

OBG Segment 8W

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 8BW-8CW Cross Beam side EP 'I' Rib as per notification #6074 item # 1, 2

The weld designations reviewed are as follows:

EP064-001-007/008
EP063-001-009/010

OBG Segment 8W

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT

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report for this date. The member is identified as 8CW – FL3 area Holdback & Corner Welds as per notification #6074 item # 3

The weld designations reviewed are as follows:

Bottom Stiffeners:-BP025-010-026, 027, 030, 31, 36, 37, 40 and 041

Deck Stiffeners:-SEG047J-16 and 017

SEG047H-068, 069, 022, 023, 113 and 114

Floor Beam Stiffeners:-FB019-002-PP68-003, 004, 013 and 014

FB023-003-PP69-001, 002, 011 and 012

FB027-003-PP70-003, 007, 013 and 014

SSD12A-PP70-172 and 173

Corner Weld Seams: - SSD10A-PP68-170

FB023-003-128

FB027-003-128



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