

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-021272**Date Inspected:** 22-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 Chang**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:

Trial Assembly Area

OBG Segment 8BW-8CW

VT repair with Shielded Metal Arc Welding (SMAW) in the 2F position of the Bottom & Side Panel 'T' Ribs holdback weld joint. The welder is identified as 45246. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1.

OBG Segment 9AE

Shielded Metal Arc Welding (SMAW) in the 3G position of the Crossbeam side Deck 'I' ribs built up using 9018 electrode was in progress as per ZPMC report # B-WR-13672. The welder is identified as 48800. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G-Repair

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OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 2G position of the Bottom Panel 'T' ribs holdback weld joints. Segment # BP125-001-53 & 54 of 9BE & BP126-001-41 & 42 of 9CE. The welder is identified as 222396. ZPMC Quality Control (QC) is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132

OBG Segment 7EW

This QA inspector performed Magnetic Particle Testing (MT) of the Base Metal Heat Straightening area as per notification # 006036 (Incident #1366) 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 the Side Panel of Bike Path Side closed to Bottom Panel (Punch list Item 640).

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
