

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-020419**Date Inspected:** 31-Jul-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:** Zhu Zhong Hai**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 9DE-9EE

This QA Inspector witnessed Magnetic Particle Testing (MT). All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Bike Path side EP to EP weld repaired area.

ABF notification # 07302010-01, item # 2

The weld designations reviewed are as follows:

OBE9A-010

OBG Segment 9DE-9EE

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

generates after performing a joint inspection. The members are identified as the Bike Path side EP to EP weld repaired area.

ABF notification # 07302010-01, item # 2

The weld designations reviewed are as follows:

OBE9A-010

OBG Segment 9DE-9EE

This QA Inspector witnessed Magnetic Particle Testing (MT). All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Bike Path side SP to SP weld repaired area.

ABF notification # 07312010-01, item # 2

The weld designations reviewed are as follows:

OBE9C-010 and 009

OBG Segment 9DE-9EE

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Bike Path side SP to SP weld repaired area.

ABF notification # 07312010-01, item # 2

The weld designations reviewed are as follows:

OBE9C-010 and 009

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 1G position of BP to BP splice weld repair area. Weld # OBW9B-008. The welder is identified as 047864. ZPMC CWI is identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F) FCM –Repair-1. See attached photograph Pic_001.

OBG Segment 13 CE – Bay14

Sub Arc Welding (SAW) in the 1G position of 13CE sub assembly section weld # SEG3011A-009. The welder is

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

identified as 044771. ZPMC Quality Control (QC) is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2. See attached photograph Pic_002.



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
