

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-020815**Date Inspected:** 09-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:** 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:

OBG Segment 9AW

During in process visual inspection of 9AW, This QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Side Panel 'T' Ribs holdback area of Counterweight side. See attached photograph Pic_001

OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 3G position of Bottom Panel 'T' Rib Splice weld joint, weld # BP072-001-024. The welder is identified as 067947. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS - B-T-2233T. See attached photograph Pic_002

OBG Segment 9AW-9BW

During in process visual inspection of 9AW-9BW, This QA Inspector observed ZPMC NDT personnel performing

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Magnetic Particle Testing (MT) on Counterweight side Edge Panel 'I' Ribs holdback area.

OBG SEGMENT 9BE-9CE

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 deck panel splice weld between OBG segment 9BE and 9CE. ABF Report No: UT-9E-050

The weld designations are as follows.

OBE9- 007 (OBG 9BE-9CE- D.P)

OBG Segment 9AW

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 9AW (8CW side) 'I' and 'T' Rib hold back weld as per ZPMC notification # 06161

The weld designations reviewed are as follows:

DP670-001-013, 014, 017 and 018

DP683-001-013, 014, 017 and 018

EP111-001-011 and 012

EP124-001-009 and 010

SP655-001-023 and 024

SP105-001-029, 030, 033, 034, 041 and 042

SP132-001-035 and 036

SP159-001-033 and 034

BP097-001-025, 026, 035 and 036

BP043-001-035 and 036

BP151-001-025, 026, 035 and 036

SP768-001-013, 014, 023 and 024

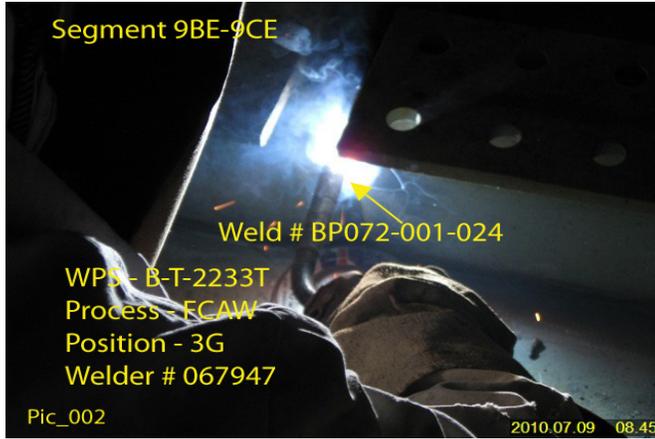
SP728-001-035 and 036

SP490-001-035 and 036

SP668-001-021, 022, 029 and 030

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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
