

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-021179**Date Inspected:** 25-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

During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on DP to DP splice weld.

OBG Segment 9DE-9EE

During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Bike Path side SP to SP splice weld.

OBG Segment 9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of LD flange attached to PP79E. Weld # SEG054C-001 as per repair report # B-WR-14103. The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Anqing Xiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1.

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OBG Segment 13E - Bay 11

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 13E-SP3067 sub assembly.

ZPMC notification # 06279

The weld designations reviewed are as follows:

SP3067-001-11, 12, 37, 38, 25, 26, 61, 62, 33, 34, 72, 75, 69, 70, 41 and 42

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 3G position of Deck Panel 'I' rib. Weld # DP684-001-021 as per repair report # B-CWR-1709. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair-1.

OBG Segment 9CW-9DW

Flux Core Arc Welding (FCAW) in the 3G position of SP to SP splice weld # OBW9C-004. The welder is identified as 070140. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2233T.

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
