

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-021184**Date Inspected:** 19-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 9CE-9DE

During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) of Cross beam side EP to DP holdback weld. See attached photograph Pic_001.

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Bottom Panel splice weld joint. Weld # OBW9B-008. The welder is identified as 066326 and 045196. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic_002.

OBG Segment 9BW-FL3

Flux Core Arc Welding (FCAW) in the 3F position of half diaphragm vertical web to PP076 weld. Weld #

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SSD25-PP075-149. The welder is identified as 207465. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

OBG Segment 9BW-FL3

Flux Core Arc Welding (FCAW) in the 2F position of half diaphragm Bottom web weld. Weld # SSD25-PP075-125. The welder is identified as 045280. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16 - 13AW Sub Assembly

Submerge Arc Welding (SAW) in the 1G position of 13AW counterweight side LD Panel Splice weld, weld # LD3031-001-003. The welder is identified as 045265. ZPMC Quality Control (QC) is identified as Tao Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

OBG Segment 9CE-9DE

Shielded Metal Arc Welding (SMAW) in the 4G position of 9CE-9DE Bottom splice weld # OBE9C-003. The welder is identified as 067571. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

OBG Segment 9CE-9DE

Shielded Metal Arc Welding (SMAW) in the 4G position of Bike Path side BP SP holdback weld # OBE9C-003. The welder is identified as 067829. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-T-C-U4b-FCM-1.

OBG Segment 9AE-9BE

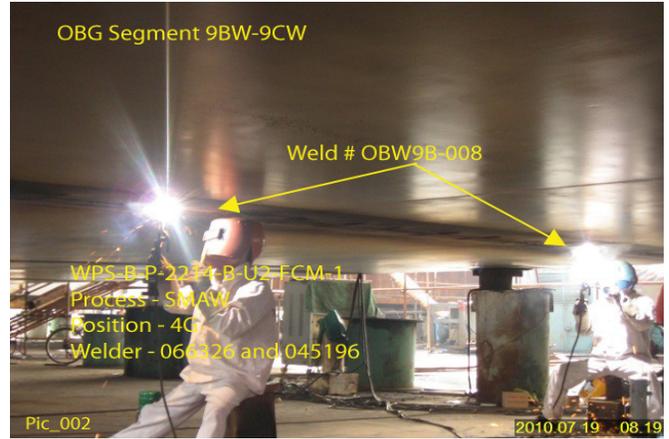
During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) of 9AE-9BE Bike Path side SP to SP splice weld.

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross beam side SP to SP splice weld # OBW9B-009. The welder is identified as 066413 and 037743. ZPMC CWI is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

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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
