

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-021256**Date Inspected:** 14-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:** Li Yang**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:

Cross Beam CB13

This QA Inspector performed verification 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 Deck Panel to Side Panel weld joint of CB13 East Side. ABF notification No: 07142010-1, Item # 1.

The weld designations reviewed are as follows:

CB202A-013-002

Result: Linear indication found as follows

1. Y= 1980 – Slag, Y=2010 – Transverse indication
2. Y= 4770 to 4810 - Slag

Cross Beam CB13

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification 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 Deck Panel to Side Panel weld joint of CB13West Side. ABF notification No: 07142010-1, Item # 2.

The weld designations reviewed are as follows:

CB202A-013-014

OBG Segment 9BW-9CW

During in process visual inspection of 9BW-9CW, This QA Inspector observed Shielded Metal Arc Welding (SMAW) in the 4G position of under deck temporary attachment for DP fit up was in progress. The welder is identified as 045426. ZPMC Quality Control (QC) is identified as Shi Lei. See attached photograph Pic_001

OBG Segment 9AW

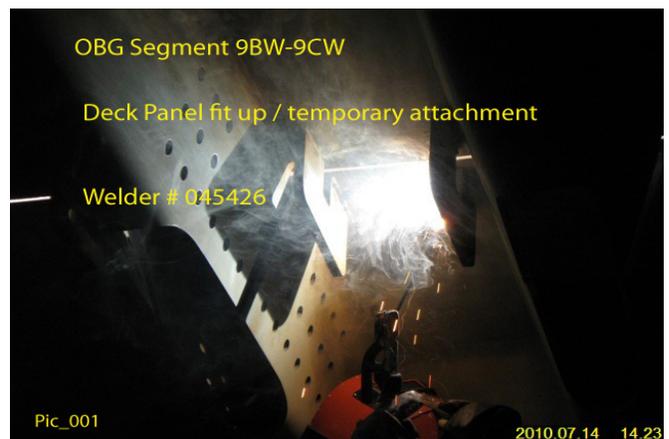
During in process visual inspection of AW, This QA Inspector observed ABF Quality Assurance (QA) personnel Mr. Gao Qiming performing Magnetic Particle Testing (MT) temporary attachment removed area at 8CW side. See attached photograph Pic_002

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 3G position of 9AW-9BW DP 'T' Rib Splice weld joint. Weld # DP671-001-019 as per Repair Report # B-WR-13942. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G(3F)-FCM-Repair-1.

OBG Segment 9DE-9EE

Flux Core Arc Welding (FCAW) in the 3G position of 9DE-9EE Bottom 'T' Rib Splice weld joint. Weld # BP073-001-022. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
