

**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-020398**Date Inspected:** 13-Aug-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:** Geng Wei**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 performed the following work:

Bay 14 – OBG 13BW Sub Assy

Sub Arc Welding (SAW) in the 1G position of 13BW sub assy plate BP3062A to BP3063A splice weld # SEG3014A-003. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Guoxing Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 14 – OBG 13CE Sub Assy

uring in process visual inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on BP3044A to 3045A splice weld # SEG3011A-006 repaired area.

Cross Beam CB12 Tagging

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## WELDING INSPECTION REPORT

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This QA inspector performed Magnetic Particle (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 CB12 TAG#1~TAG#7 as per ZPMC notification # 06395.

The weld designations reviewed are as follows:

CB201G-033-045, 046, 047, 048, 147 and 165

CB201G-034-045, 046, 047, 048, 147 and 165

**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.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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