

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-020405**Date Inspected:** 11-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:** Lui Fawen**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 – Travel Rail Bracket

Flux Core Arc Welding (FCAW) in the 2G position of Travel rail Bracket weld # TRBPP83-004. The welders are identified as 048714. ZPMC Quality Control (QC) is identified as LI ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F.

Bay 15 – Cross Beam CB17

Flux Core Arc Welding (FCAW) in the 2G position of Side Panel to Bottom Panel weld # CB3001A-017-005. The welders are identified as 500479 and 054459. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F. See attached photograph Pic_001.

OBG Segment 11DW

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Shielded Metal Arc Welding (SMAW) of various VT touch up locations. The welder is identified as 066480. ZPMC Quality Control (QC) is identified as Wu Shi Gao.

OBG Segment 11DE

During in process visual inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Bike path side LD to Floor Beam weld. See attached photograph Pic_002.

Bay 14 – OBG 13CW Sub Assy

Sub Arc Welding (SAW) in the 1G position of 13CW sub assy plate BP3058A to BP3059A splice weld # SEG3014A-005. 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.



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
