

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-020410**Date Inspected:** 06-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:** Li Yan Hua**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:

Bay 14 – OBG 13CW Sub Assy

Sub Arc Welding (SAW) in the 1G position of 13CW sub assy plate SP3098A to SP3097A splice weld # SEG3015A-013. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-2221-B-L2c-S-2. See attached photograph Pic_001.

Bay 13 – OBG 12BW

Flux Core Arc Welding (FCAW) in the 3F position of Counterweight side SP 'T' rib lug weld # SEG305D-060. The welders are identified as 048714. ZPMC Quality Control (QC) is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with WPS-B-T-2133. See attached photograph Pic_002.

OBG Segment 11EW

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 11EW LD and attachment melts as per ZPMC notification # 06344.

The weld designations reviewed are as follows:

SEG073B-002, 003, 004, 006, 007, 008, 012, 015, 016, 017, 018, 019, 020, 025, 026, 027, 028, 029, 030, 032, 033 and 034

SEG073C-001, 002, 003, 007, 008, 009, 010, 011, 012, 013, 014, 015, 017, 023, 024, 025, 026, 027, 028, 031, 032 and 033



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
