

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017408**Date Inspected:** 08-Oct-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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 & Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 006876

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 12BW. The weld designations reviewed are as follows:

1. SEG3005L-001, 002, 003
2. SEG3005A-001, 002

This QA Inspector observed the following work in progress:

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A2-009-016 and 018 located on Bike Path. Welder is identified as 062734. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-B-U4b-F.

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FCAW welding of weld joint BK004ASD1-012-008 located on Bike Path. Welder is identified as 062734. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK006A6-001-002 and 007 located on Bike Path. Welder is identified as 062749. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2332-Tc-P4-F.

FCAW welding of weld joint BK004A8-012-001 and 165 located on Bike Path. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2333-Tc-P4-F.

FCAW welding of weld joint BK004A012-017 and 015 located on Bike Path. Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-2-plug.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BP3056-001-049 and 050 located on bottom plate stiffener of OBG segment 14W. Welder is identified as 070254 and 037705. ZPMC Quality Control (QC) is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW repair welding of weld joint LD3033-001-128 located on Longitudinal Diaphragm Lifting lug of OBG Segment 13CW. Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Li Shi You. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-2G (2F)-Repair and which is used as per Welding Repair Report (WRR) B-WRR-15658.

FCAW welding of weld joint LD3036-001-046 located on Longitudinal Diaphragm Lifting lug of OBG Segment 13CW. Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Li Shi You. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U5-F.

FCAW welding of weld joint LD3031-001-067 located on Longitudinal Diaphragm Lifting lug of OBG Segment 13AW. Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Li Shi You. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U5-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

WELDING INSPECTION REPORT

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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 , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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