

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018419**Date Inspected:** 18-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

Trial assembly yard, CB13, East side plate.

SMAW Repair welding of Base metal repair area (CWR#B-CWR1958); located at Trial assembly yard. Welder is identified as 040484; ZPMC Quality Control Inspector (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-REPAIR-1.

Trial assembly yard, 10AE-10BE, Water Diverter, CB side.

SMAW welding of weld joint OBE10D-13, 14; located at Trial assembly yard. Welder is identified as 056200; ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Yard in front of Paint shop, 13AE, Floor beam .

SMAW Repair welding of Floor beam stiffener-built up (WRR#B-WR15246); located at Trial assembly yard. Floor beam identified as FB3125. Welder is identified as 051359; ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The attached photograph provides additional detail.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Trial assembly yard, 10AE, FL3 area.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel “Xie Gen Lin” carrying out Magnetic Particle Testing (MT) on Temporary attachment removal areas at 10AE FL3 area. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer