

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-025150**Date Inspected:** 25-Nov-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**CWI Name:** Tian Lei**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1D-030 weld number(s) 126~131. Welder is identified as welder no. 068493. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2133-B-U2.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1D-022 weld number(s) 032~043. Welder is identified as welder no. 068916. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2132-B-U2.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1D-049 weld number(s) 030~043. Welder is identified as welder no. 059450. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2133-B-U2.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1-040 weld number(s) 063~074. Welder is identified as welder no. 215397. The welding variables recorded by ZPMC QC identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2133-B-U2.

Bay Number 2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 07478. The member(s) is/are identified as OBG Segments and Longitudinal Diaphragms.

The weld designations reviewed are as follows:

1. SEG3020K-265, 010, 382, 163, 054, 362, 180, 381, 101, 361, 049, 146, & 108.
2. LD3048-001-101, 097, 081, & 085.

Performed verification VT for the component(s) identified as OBG Segment for components listed as SEG3019K & SEG3019L. This QA inspector signed green tag #15377.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. All components were as listed on NWIT notification no. 07497. The member(s) is/are identified as OBG Longitudinal Diaphragms & Edge Beams. The weld designations reviewed are as follows:

1. LD3048-001-010~021, 024~027, 030~033, 111, 118~121, 126, 127, 132, 133, 138, 139, 144, 145, 152~155, 160, 161, 166, 167, 174~177, 182, 183, 188, 189, 194, 195, 200, 201, & 208~211.
2. EB3054-001-001~008.
3. EB3054-002-005~008.
4. EB3056-001-001~016.
5. EB3055-001-001~004.
6. EB3057-001-001~012.

Bay Number 3

This inspector observed ZPMC personnel conducting UT examination on Anchorage Plate component identified as AP3032.

This inspector observed ZPMC personnel conducting MT examination on Longitudinal Diaphragm component identified as LD3048-001.

Bay Number 4

This inspector did not observe any welding or contract work in this bay today.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Pertinent conversations are included in the body of the report.

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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
