

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-021287**Date Inspected:** 17-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**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.

OBG Segment 13BE / Bay 14

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Segment 13AE welds as per ZPMC notification # 08207.

The weld designations reviewed are as follows:

SEG3007K-038, 039

Deck Panel / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Deck Panel Diaphragm welds of DP3118A and DP3119A.

OBG Segment 13BW / Bay 14

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This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of DP3136A to DP3135A weld # SEG3014-003. The welder is identified as 250050. ZPMC Quality Control (QC) is identified as Liu Fang. The welding variables recorded by QC appeared to comply with WPS-B-T-222(2)1T-ESAB-1.

OBG Segment 13BW / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of DP Diaphragm weld # SEG3014D-001. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2-FCM-1.

OBG Segment 13CW / Bay 14

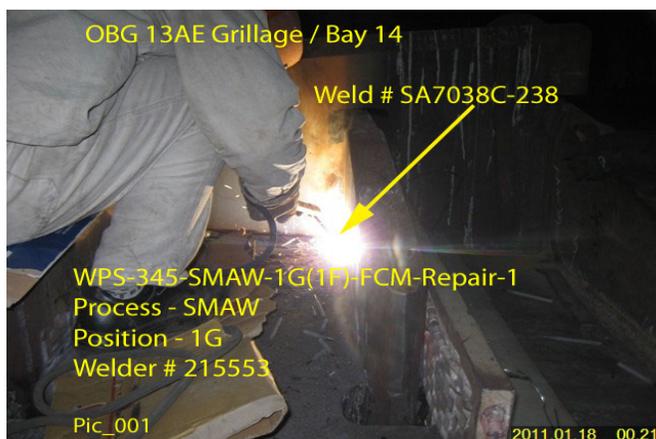
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of DP Diaphragm weld # SEG3014G-001. The welder is identified as 037780. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2-FCM-1.

OBG Segment 13AE / Bay 13

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of 13AE Grillage repair weld # SA7038C-228, as per B-CWR # 2756. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Zhaong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-FCM-Repair-1. See attached photograph Pic_001.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

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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
