

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-021411**Date Inspected:** 11-Jan-2011**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:** Lv Li Qing**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 Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 14E floor beam to longitudinal diaphragm weld, SEG3019Q-1-042. ZPMC welder was identified as 068501. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW) of OBG Segment 13AE bottom panel stiffener to bottom panel weld, SEG3007AT-017. ZPMC welder was identified as 067947. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-345-SMAW-2G(2F)-FCM-Repair.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ABF QC for OBG segment 13AW deck panel diaphragm welds. See MT report TL-6028 generated this date for additional information. The following welds were tested:

DP3123-001-011, 012, 013, 018, 019, 020, 022, 023, 026~029, 034~038, 042~047

DP3123-001-051~055, 058~063, 066~071, 074~079, 082, 083, 084, 086, 087

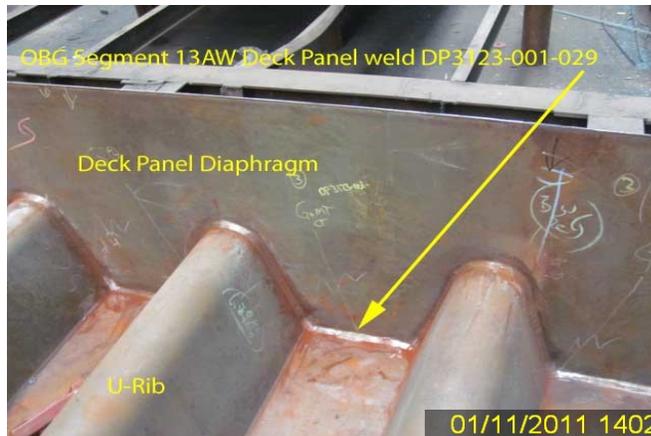
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DP3123-001-091, 092, 093, 098, 099, 102, 106, 017, 108, 110, 114, 115, 117, 122, 123, 126

Caltrans QA issued an Incident report for longitudinal linear indication on OBG segment 13AW deck panel diaphragm to deck panel weld, DP3123-001-029 previously tested by ABF QC. See attached photos for additional information.

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



Summary of Conversations:

Caltrans QA notified ZPMC and ABF QC that an incident report would be issued for the above mentioned MT indication.

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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
