

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-023658**Date Inspected:** 09-May-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:** Liu Hua Jie**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

FCAW in the 1G position for OBG segment 13AW to 13BW, welding of splice weld No. OBW13-001. The Welder is identified as 201215. ZPMC Quality Control is identified as Mr. Zhou Peng. The welding variables recorded by QC personnel appeared to comply with WPS-B-T-2231-ESAB. The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AE, welding of UT repair weld No. SEG3007J-013. The Welder is identified as 200113. ZPMC Quality Control is identified as Mr. Liu Hua Jie. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The weld repair report is identified as WR20872. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13AW, welding of UT repair weld No. SEG3013L-105. The Welder

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

is identified as 066002. ZPMC Quality Control is identified as Mr. Shi Li . The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The weld repair report is identified as WR20693. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13AW, welding of UT repair weld No. SEG3013Q-022. The Welder is identified as 068493. ZPMC Quality Control is identified as Mr. Shi Li . The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The weld repair report is identified as WR20591. The In-process SMAW appears to be progressing in compliance with approved contract documents.

Magnetic Particle Testing (MPT) for Bike Path

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG bike Path welds. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ABF QC MT technicians.

The Weld Designations are as follows

BK009A6-001-001~004

BK009A8-001-001~004

BK009A3-001-104~111

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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