

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016532**Date Inspected:** 01-Sep-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, China**CWI Name:** Li 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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 10AE

ABF Report No: UT-10E-021R1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back weld between deck panel and edge panel of OBG segment 10AE on bike path side at the intersection of OBG 9EE. The weld designations were as follows:

CA072-006 (OBG 10AE, DP to EP, BK side @ 9EE)

OBG SEGMENT 10AE

ABF Report No: UT-10E-020R1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back weld between side panel and edge panel of OBG segment 10AE on bike path side at the intersection of OBG 9EE. The weld designations were as follows:

CA072-005 (OBG 10AE, SP to EP, BK side @ 9EE)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG LIFT # 10 WEST

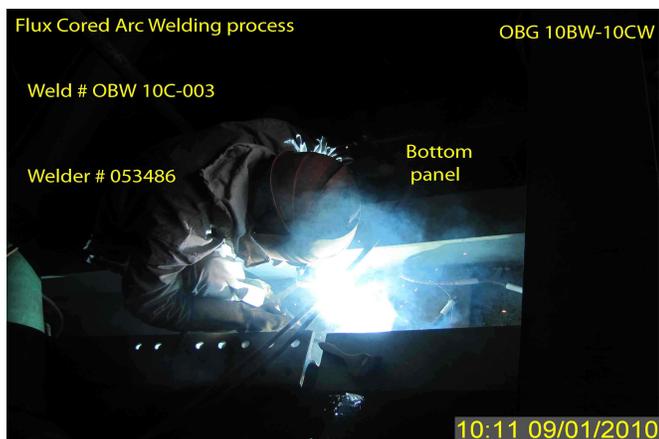
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053486 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBW10C. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053316 performing the Flux Cored Arc Welding process on weld 004 located at PCMK OBW10C. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040603 performing the Flux Cored Arc Welding process on weld 005 located at PCMK OBW10C. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic Testing on the side panel splice weld between OBG segment 10AW and 10BW on cross beam side. Weld number identified as OBW10B-004.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No significant conversations were reported on this date.

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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
