

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016588**Date Inspected:** 30-Aug-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) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. Geng Wei & Mr. Xu Tao	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 Segments	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) - Document No's: 006533

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB019-076-001, 004, 005, 006, 007, 008, 009, 010, 011
2. SB019-076-012, 013, 014, 015, 016, 017, 018, 019, 020, 025
3. SB019-076-026, 031, 032, 037, 043, 049, 055, 061, 067, 077

Bay 19

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Suspender Bracket.

Component: SB74W

Weld Numbers: SB016-074-001, 004~020, 025, 026, 031, 032, 037, 043, 049, 055, 061, 067 and 077

Green tag No: 12267

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Component: SB76E

Weld Numbers: SB019-076-001, 004~020, 025, 026, 031, 032, 037, 043, 049, 055, 061, 067 and 077

Green tag No: 12278

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE, weld joint identified as SEG3011A-004. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 217805 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-002. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform SAW Welding on OBG Segment 13CW, weld joint identified as SEG3015A-007. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform FCAW Welding on OBG Segment 13BW, weld joint identified as CA3015B-175 and 176. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Bay 13

During random Quality Assurance Visual review of OBG Segment 13 lift Bottom Plate, this Quality Assurance Inspector (QA) observed machining of 100mm bottom plate at bay 13. The bottom plate is identified as OBG segment 13AW bottom plate BP3074. The bottom plate is identified as SPCM. See the attached pictures

Visual Inspection after Blast

Cross beam 11

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of the deck panel, floor beams intermediate diaphragm, bottom plate and side plate of this cross beam. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer