

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017096**Date Inspected:** 28-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**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 date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG suspender Bracket, weld No. SB019-078-026/032. The welder is identified as #062808. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 13AE, weld No. SEG3007AD-005. The welder is identified as #044790. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

SAW in the 1G position for the OBG Segment 13AE, weld No. SEG3007AE-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

WPS-B-T-2221-B-L2c-S-2.

FCAW in the 1F position for the OBG Segment 13CW, weld No. CA3016B-70/071. The welder is identified as #047866. ZPMC QC is identified as Mr. Xing Chen Hui .The welding variables recorded by QC appear to comply with WPS-B-T-2131.

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 12AE, UT repair weld No. SEG3001P-002. The welder is identified as #044772. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-1.

SMAW in the 2G position for the OBG Segment 12AE, weld No. SEG3001J-246. The welder is identified as #050232. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Ultrasonic Testing (UT) for Segment 13CE

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 13CE bottom plate splice joints.

The welds designation reviewed are as follows:

SEG3011A-005,006

Visual Inspection after Blast at 11AW

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11AW external deck panel ,side panel, edge panel and bottom panel after grit blasting in between panel point PP95 to PP97. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 4)



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 4 of 4)

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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