

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-017107**Date Inspected:** 06-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:** 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 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

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG segment 12AE, weld No. FB3006-001-164. The welder is identified as #058087. ZPMC QC is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appear to comply with WPS-B-P-2212-B-U2-FCM.

SMAW in the 1G position for the OBG segment 12AE, weld No. SEG3001P-017. The welder is identified as #044779. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2211-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 12AW weld build up at rate hole area of X8E at crossbeam side. The welder is identified as #047864. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR. The weld repair report is identified as B-CWR-1796.

SMAW in the 4G position for the OBG segment 12BE, weld No. SEG3002E-222. The welder is identified as

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#043661. ZPMC QC is identified as Mr.Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG segment 12BE, weld No. SEG3002E-222. The welder is identified as #051013. ZPMC QC is identified as Mr.Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Bay#16

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13AW, weld No. LD3034-001-038. The welder is identified as #040344. ZPMC QC is identified as Mr.Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U5-F.

FCAW in the 2G position for the OBG segment 13BW, weld No. LD3032-001-028. The welder is identified as #045143. ZPMC QC is identified as Mr.Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U5-F.

Bay#14

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG sandwich plate for lift 14, weld No. SA3347-003/004. The welder is identified as #0201087. ZPMC QC is identified as Mr.Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

Ultrasonic Testing (UT) for Floor Beam

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 Floor Beam weld joints.

The welds designation reviewed are as follows:

FB3265-001-001~009

FB3260-001-001~009

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

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your project.

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