

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-017130**Date Inspected:** 10-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:** Wang 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 Components**Summary of Items Observed:**

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

OUTSIDE SHOP

11EE

This QA inspector performed UT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Segment 11EE. The weld designations reviewed as follows.

SEG074*-025,026,018.

SEG074A-004,006,007.

SSD19A-PP108-134,128,106,131,002,003,007.

CSD7-PP108-023,027,019.

BAY#16

SAW welding of weld is identified as 1G-001 of FL-3 Bottom plate BP3056-001 of segment 13AW. The welder is identified as 219168. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

SAW welding of weld is identified as 1G-003 of Bottom plate SEG3013AC of segment 13AW. The welder is

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

identified as 045265. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld is identified as 2G-066 of Lifting lugs LD3031-001 of segment 13AW. The welder is identified as 045280. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U5-F.

BAY#14

FCAW welding of weld joint 1G-007 located on PCMK SEG3013AD of Segment 13AW the welder is identified as 407866. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

BAY#15

SAW welding of weld joint 1G-001 located on PCMK SEG3013AC of Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

BAY#19

Green tag issued the following Suspender bracket after NDT carried out successfully.

SB74E – 1 stage-12297.

SB74E - 2 stage-12279.

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

Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
