

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-017136**Date Inspected:** 16-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 yan hua**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.

BAY#19

This QA inspector performed MT 15% of weld areas 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 Bike path. The weld designations reviewed as follows.

BK005A4-001-020,046,055,071

BK005A8-001-023,024,035,036

BK005A3-001-008

BK006A4-002-004,019,020,045,072

BK006A3-002-010

BK006A6-002-023,024,035,036

OUTSIDE SHOP

SMAW welding of weld is identified as 4F-051 of CA6502B for segment 12BE. The welder is identified as 043661. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2114-FCM-1.

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SMAW welding of weld is identified as 4F-006 of OBE12C for segment 12BE. The welder is identified as 054013. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW welding of repair weld is identified as 3G-014 of SEG3004L for segment 12AW. The welder is identified as 045246. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-3G-Repair-FCM.

BLAST SHOP # 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Segment 11BE Interior bottom panel, side panel and longitudinal diaphragm surfaces in between the panel point 98 to 099 after grit blasting. 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.

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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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