

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017142**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:** 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**Summary of Items Observed:**

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

West of Bay 14-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 11DE Critical Weld Repairs. See MT report TL-6028 generated this date for additional information. The following welds were tested:

SSD16A-PP104-004

FB003-187-004

Caltrans QA performed preliminary visual inspection of internal weld and base material surfaces of OBG Segment 11EE.

ZPMC QA observed ZPMC personnel grinding OBG segment 11EE side panel to corner assembly weld SEG074A-010. Approximately 2.2 meters of the weld has been removed for misalignment. Repair work appeared to be in conformance with Critical Weld Repair (CWR) report B-CWR 1862.

Bay 16-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 13AW longitudinal diaphragm weld, LD3034-001-038. ZPMC welder was identified as 040344. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U5-F.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AW longitudinal diaphragm weld, LD3034-001-058. ZPMC welder was identified as 045143. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U5-F.

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11AW internal lower section base metal and weld surfaces from panel point 96 to 97. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair.

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

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
