

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017153**Date Inspected:** 12-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Segments**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) – NWIT Document No's: 006648

This QA inspector performed MT of approximately 15% of the area 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 Suspender bracket. The weld designations reviewed are as follows:

1. SB020-080-004

Ultrasonic Testing (UT) – NWIT Document No: 006653

This QA inspector performed UT of approximately 10% of the area 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 Suspender Bracket. The weld designations reviewed are as follows:

1. SB020-080-004

OBG Segment 12AE

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This QA inspector observed ZPMC qualified welding personnel identified as 218086 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 12AE, weld joint identified as SEG300H1-170, 171. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2213-Tc-U5-F.

OBG Segment 12BE

This QA inspector observed ZPMC qualified welding personnel identified as 044661 perform SMAW welding on OBG Segment 12AE, weld joint identified as OBE12C-006 and 007. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 049339 perform SMAW welding on OBG Segment 12AE, weld joint identified as OBE12C-004 and 005. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2114-FCM-1.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AW, weld joint identified as SEG3013AD-010 and 015. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform FCAW welding on the Longitudinal Diaphragm Lifting leg of OBG Segment 13AW, weld joint identified LD3034-001-079, 059. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW on Bike Path, weld joint identified as BK004A3-014-053, 054 and 055. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062762 perform FCAW on Bike Path, weld joint identified as BK004A4-001-016, 017 and 018. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on Bike Path deck plate. The

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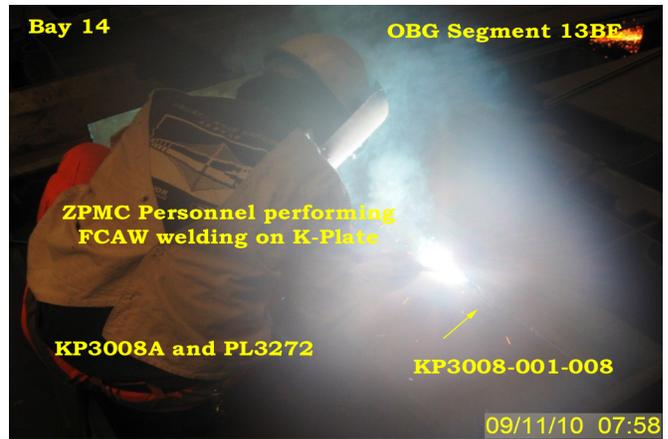
weld joint is identified as BK004A1-004-008 and 009. ZPMC QC is identified as Mr. Xu Tao.

Visual Inspection after Blast

Segment 11BW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11BW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

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