

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-017188**Date Inspected:** 27-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 Bike Path and Segment**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: 006775

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 Bike Path. The weld designations reviewed are as follows:

1. BK004A2-010-016, 018

Ultrasonic Testing (UT) – NWIT Document No: 006778

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. BK004A1-004-006

2. BK004A5-004-090

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This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform Flux Core Arc Welding (FCAW) welding on steel barrier of OBG Component, weld joint identified as W5-SB08-001-017 and 018. ZPMC QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 068994 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB01-028-097 and 111. ZPMC QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2333-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB08-001-097 and 111. QC is identified as Mr. Ma Qian Li. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2333-Tc-P4-F.

This QA inspector observed ZPMC qualified welding personnel identified as 041285 perform FCAW welding on the Longitudinal Diaphragm Lifting lug of OBG Segment 13AW, weld joint identified LD3031-001-163. ABF QC is identified as Mr. Li Shi You. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045143 perform FCAW welding on the Longitudinal Diaphragm Lifting lug of OBG Segment 13BW, weld joint identified LD3035-001-023. ABF QC is identified as Mr. Li Shi You. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 206356 perform FCAW welding on the Longitudinal Diaphragm Lifting lug of OBG Segment 13AW, weld joint identified LD3034-001-061. ABF QC is identified as Mr. Li Shi You. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform FCAW welding on the Longitudinal Diaphragm Lifting lug of OBG Segment 13CW, weld joint identified LD3033-001-035. ABF QC is identified as Mr. Li Shi You. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U5-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 052808 perform Flux Core Arc Welding (FCAW) welding on Suspender bracket, weld joint identified as SB018-94-001 and 005. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW welding on

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Suspender bracket, weld joint identified as SB021-94-001 and 005. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062795 perform FCAW welding on Bike path, weld joint identified as BK004A7-013-224 and 228. 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 welding on Bike path, weld joint identified as BK004B1-001-043. 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-2232-Tc-U4b-F.

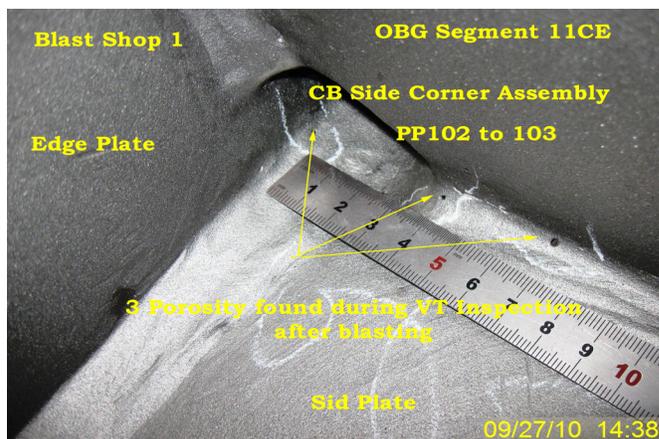
This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW welding on Bike path, weld joint identified as BK004A1-013-006 and 043. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

Visual Inspection after Blast

Segment 11CE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11CE, 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.



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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
