

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017198**Date Inspected:** 19-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:** Mr. 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, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

In process Inspection

OUTSIDE YARD

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 12BE, weld No: SEG3002N-060/061. The welder is identified as #054013. ZPMC QC is identified as Mr. Wang xiang pin. The welding variables recorded by QC appear to comply with WPS-B-P-2112.

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the Bike Path, weld No: BK004A3-013-051/052. The welder is identified as #062761. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the Bike Path, weld No: BK004A8-012-065. The welder is identified as #062808.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2333-TC-P4-F.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB020-086-008. The welder is identified as #062904. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U5-F. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB020-090-061. The welder is identified as #062749. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U5-F.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13AE, weld No: VP3002A-001-003. The welder is identified as #067079. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13BE, weld No: VP3005-001-003. The welder is identified as #044795. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW, weld No: SEG3013AD-001. The welder is identified as #045270. ZPMC QC is identified as Mr. Xia Chun hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2. Please see the attached picture.

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (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 member is identified as Bike Path. The weld designation reviewed is as follows:

BK004B8-009-059, 060, 108, 109, 106, 107, 031, 032, 033, 034, 115, 116

BK004B7-009-055, 056, 061, 062, 067, 068, 073, 074, 079, 080, 085, 086, 091, 092, 097, 098

BK004B3-009-025, 026, 051, 052

BK004B4-009-014, 015, 040, 041, 066, 067

BK004B5-009-016, 017, 018, 019, 020, 021, 038, 039

BK004B6-009-045, 046, 049, 050, 047, 048, 104, 105, 107

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai, Pandaram

Quality Assurance Inspector

Reviewed By: McClendon, Timothy

QA Reviewer