

**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-017666**Date Inspected:** 30-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

Trial assembly yard, 11CW-11DW, Transverse splice SP @ E7, 8.

During Random Visual in process Inspection, this QA inspector observed fit-up of two Side panels at intersection of OBG segment 11CW-11DW. This QA inspector observed ZPMC Personnel welding Clits (temporary attachments) using Shielded metal arc welding (SMAW). Welder is identified as 041713; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2114. The attached photographs provide additional detail.

Trial assembly yard, 11BE-11CE, Bottom Panel T-rib splice.

SMAW welding of weld joint BP187-001-020, 022; located at Trial assembly yard. Welder is identified as 044575; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-U2-FCM-1.

Trial assembly yard, 11CE-11DE, BP transverse splice.

FCAW welding of weld joint SEG070A-011; located at Trial assembly yard. Welder is identified as 040367; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

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This QA Inspector carried out NDE on following  
Trial assembly yard, 11AE-11BE.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 10292010-1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between two Bottom panels at the intersection of OBG Segment 11AE- 11BE. The weld designations were as;

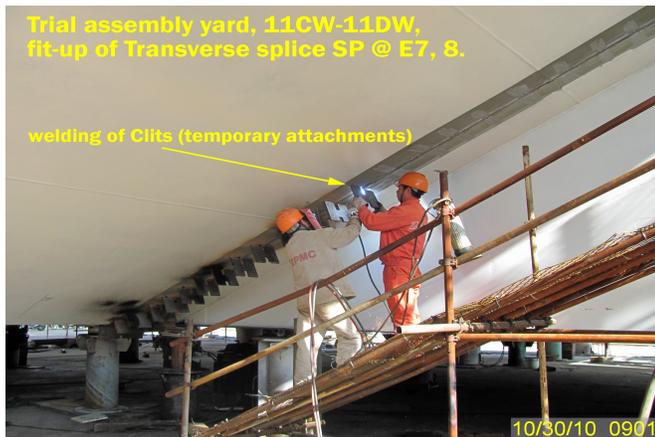
OBE11B-003. (11AE-11BE, BP-D6).

Trial assembly yard, 11AE-11BE.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11E-037R1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Side panel & Edge panel at the intersection of OBG Segment 11AE- 11BE, Cross beam Side. The weld designations were as;

- 1) CA081-005. (11AE-11BE, SP-EP-E6);
- 2) SEG068A-028. (11AE-11BE, SP-EP-E6).

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



## Summary of Conversations:

No relevant conversations.

## 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer
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