

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-017870**Date Inspected:** 30-Aug-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:** Gong Wai**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13CE, weld No. SEG3011A-004. The welder is identified as #044771. ZPMC QC is identified as Mr. Wang Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG Segment 13CW, weld No. SEG3015A-007. The welder is identified as #045270. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Bay#13

During random visual inspection this QA inspector observed that the ZPMC personnel were performing machining at back side of the bottom plate for segment 13AW at bay#13. The bottom plate is identified as BP3074.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Magnetic Particle Testing (MPT) for Segment 9W

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment 9W at deck plate to angle weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

PSL-W-PP72-004

PSL-W-PP74-004

PSL-W-PP79-004

PSL-W-PP81-004

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment 9W at deck plate to counter weight connecting stiffener. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

OBW-9K-013,015

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between deck plate to edge Plate for segment 12AW at crossbeam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

SEG3004AA-003

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between deck plate to edge Plate for segment 12AW at counter weight side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

CA3007-004

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

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer