

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-017873**Date Inspected:** 23-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:** 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

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 12AW, VT repair weld No. SEG3004AL-020. The welder is identified as #051348. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-repair.

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3005-001-019. The welder is identified as #066439. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3007-001-037. The welder is identified as #067876. ZPMC QC is identified as Mr.Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

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SAW in the 1G position for the OBG segment 13AE, weld No. SEG3007-003. The welder is identified as #044771. 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#19

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG bike path, weld No. BK004A4-006-032/033. The welder is identified as #062755. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 2F position for the OBG bike path, weld No. BK005A2-002-076/077. The welder is identified as #062738. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 4F position for the OBG bike path, weld No. BK004A4-007-057. The welder is identified as #208641. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2134.

FCAW in the 2G position for the OBG Suspender Bracket SB90W , weld No. SB017-090-018. The welder is identified as #062761. ABF QA is identified as Mr.Peng Wen Jun . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket SB88W , weld No. SB017-088-011. The welder is identified as #062762. ABF QA is identified as Mr.Peng Wen Jun . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

Magnetic Particle Testing (MPT) for OBG Cross Beam CB16

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Cross Beam CB16 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

SSD25-PP111-197,200,203,206

SSD25-PP111-115,116,201,202,198,207,208,204

SSD25-PP104-185,191,194,197,200,203,206,209

SSD25-PP104-037,189,187,195,192

SSD25-PP105-115,116,201,202,198,207,208,204

Visual Inspection after Blast at 11CW

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11CW internal side panel, edge panel and bottom panel surfaces after grit blasting in between PP102 to PP103.5. Areas that marked

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for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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



Summary of Conversations:

No relevant conversations

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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.

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| Inspected By: | Bera,Subhasis | Quality Assurance Inspector |
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| Reviewed By: | Patterson,Rodney | QA Reviewer |
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