

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-017961**Date Inspected:** 18-Oct-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**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.

Ultrasonic Testing (UT) – NWIT Document No: 007010

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. SB018-092-001, 004, 005, 007, 008, 019
2. SB018-092-025, 049, 061, 055, 031, 020
3. SB017-088-001, 004, 005, 007, 008, 011
4. SB017-088-025, 037, 043, 055, 037, 019

This QA Inspector observed the following work in progress:

Bay 19

Flux Core Arc Welding (FCAW) welding of weld joint BK004ASD1-012-01 and 002, located on Bike Path. Welder is identified as 062739. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4c-F.

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FCAW welding of weld joint BK004A2-007-008, located on Bike Path. Welder is identified as 062904. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-1G (1F)-Repair.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing on bottom cover plate of OBG Bike Path BK004A-01.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing on closure plate welds of OBG Bike Path BK004A-006.

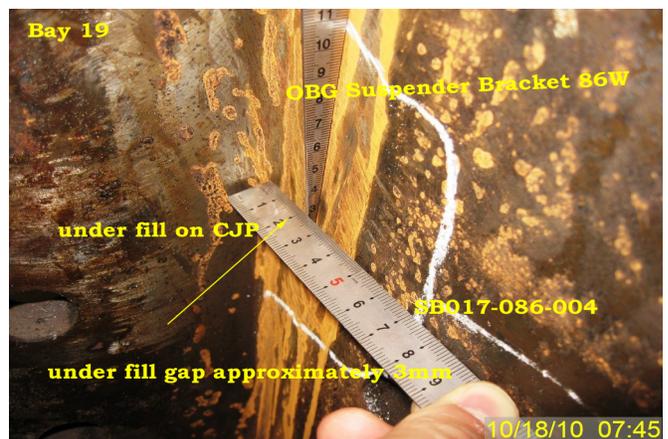
Out Side Yard

This QA Inspector observed the following work in progress:

ZPMC Shielded Metal Arc Welding (SMAW) welding personnel performed buttering on Floor Beam Stiffener (FB3125 and FB2122) of OBG Segment 13AE. Welders are identified as 048047, 054013, 051359 and 066258. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the applicable WPS -345-FCAW-3G (3F)-Repair, which is used as per Welding Repair Report (WRR) B-WRR-15246. See the attached picture.

Visual Inspection Observation: During the Quality Assurance random work in progress and visual inspection (VT) review of weld located on OBG Suspender Bracket 86W at Fabrication bay 19, this Quality Assurance Inspector (QA) observed under fill on CJP weld and QA Inspector measured the under fill gap approximately 3mm. This under fill appeared to be caused by improper welding. The under fill weld number is identified as SB017-086-004. This QA inform to ZPMC QC regarding this problem/issue and ZPMC QC is identified as Mr. Xu Tao. 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
