

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-017968**Date Inspected:** 26-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 Segment and 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.

Magnetic Particle Testing (MT) – NWIT Document No's: 007121

This QA inspector performed 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 members are identified as OBG Steel barrier. The weld designations reviewed are as follows:

1. W5-SB1-032-002
2. W5-SB2-002-033
3. W5-SB1-029-042
4. W5-SB1-013-008

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (FCAW) welding of weld joint W5-SB2-002-033 located on OBG steel barrier. ZPMC Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is

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used as per Critical Welding Repair Report (CWR) B-CWR-2059.

SMAW welding of weld joint W5-SB1-013-008 located on OBG steel barrier. ZPMC Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2061.

SMAW welding of weld joint W5-SB1-032-002 located on OBG steel barrier. ZPMC Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2060.

SMAW welding of weld joint W5-SB1-029-042 located on OBG steel barrier. ZPMC Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2058.

Bay 19

This QA Inspector observed the following work in progress:

SMAW repair welding of weld joint BK006A2-001-014, 015, 017, 019 and 020 located on bottom plate cover plate of OBG Bike Path. ZPMC Welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2115.

SMAW repair welding of weld joint BK006A2-002-014, 015, 017, 019 and 020 located on bottom plate cover plate of OBG Bike Path. ZPMC Welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2117.

SMAW repair welding of weld joint BK004A2-003-014, 015, 017, 019 and 020 located on bottom plate cover plate of OBG Bike Path. ZPMC Welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2116.

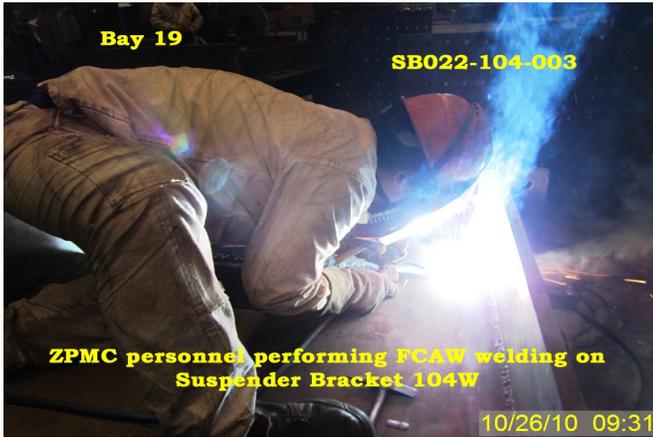
FCAW welding of weld joint SB022-104-003 located on OBG suspender bracket. ZPMC Welder is identified as 062752. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB022-106-003 located on OBG suspender bracket. ZPMC Welder is identified as 260562. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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
