

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-018032**Date Inspected:** 23-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), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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	

Summary of Items Observed:

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

Magnetic Particle Testing:-

BAY#16

This QA inspector performed Magnetic Particle Testing (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 member is identified as OBG Segment Steel Barriers. The weld designation reviewed is as follows:

W5-SB1-010-128,131,87,55,115,25
W5-SB13A-003-126,129,52,20,121,115
W5-SB1E-001-128,131,87,55,115,25
WS-SB1-020-59,130,131,13,45,128,86,95
W5-SB1-025-128,131,86,95,55,131,87
W5-SB1-003-128,131,89,55,25,115,87
W5-SB2-005-52,126,20,21,129,115
W5-SB1-023-65,69,101,103,130,76,45
W5-SB1-004-41,43,44,14,10,12,130,131

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In process Inspection

OUTSIDE YARD

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG3001*-022 located on OBG Segment 12AE. Welder is identified as #066695. ZPMC QC is identified as Mr. Li Ping. Welding was performed according to the weld repair report B-WR16071 and the UT report: B787-UT-16170. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-Repair.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: EP3001C-067 located on OBG Segment 12AE. Welder is identified as #215553. ZPMC QC is identified as Mr. Li Ping. Welding was performed according to the weld repair report B-WR16121 . The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 12AW, The weld joint was designated as: CA3006C-152. The welder is identified as #048714. ZPMC QC is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4C-F. Please see the attached picture.

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This QA inspector observed the following work in progress:

SMAW welding of weld joint no: W5-SB1-001-004 located on OBG Segment Steel Barrier. Welder is identified as #201905. ZPMC QC is identified as Mr. Guo pan. Welding was performed according to the Critical weld repair report B-CWR2057. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

Visual Inspection after Blast

Tower South Shaft Lift 3

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Exterior components of the Skin A, B, D and E of Tower South Shaft Lift 3. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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

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Summary of Conversations:

No Relevant Conversation.

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: Pillai,Pandaram Quality Assurance Inspector

Reviewed By: McClendon,Timothy QA Reviewer