

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-018041**Date Inspected:** 02-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:** 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**Summary of Items Observed:**

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

Bay 16-

This QA Inspector observed the following work in progress: Excavation areas of OBG Segment 13CW SPCM Lifting Lug welds that exceeded AWS D1.5 (2002) excavation depth of 65% for the following welds:

LD3036-001-056 (32 mm of 40 mm plate)

LD3036-001-046 (28 mm of 40 mm plate)

LD3036-001-052 (30 mm of 40 mm plate)

The above mentioned areas were shown to ABF QC Li You Shi. Mr. Li stated he would submit a Critical Weld Repair Report for these welds for Engineering approval.

Bay 19-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Bike Path weld, BK004A-003-116. ZPMC welder was identified as 062762. ZPMC QC was identified as Guo Pan. ZPMC CWI was identified as Xu Tao. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P4-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Bay 16-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Suspender Bracket SB92W weld, SB018-092-019 . ZPMC welder was identified as 062739. ABF CWI was identified as Pen Wen Jun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2331-TC-U4b-F.

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11DW upper internal base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair.

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

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
