

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018312**Date Inspected:** 26-Nov-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: 007502

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 Steel Barrier. The weld designations reviewed are as follows:

1. W5-SB1-067-050
2. W5-SB1-038-050
3. W5-SB1-048-050
4. W5-SB1-061-050
5. W5-SB1-053-050
6. W5-SB1-058-081
7. W5-SB1D-009-050
8. W5-SB1-066-050
9. W5-SB22-001-050
10. W5-SB19-001-050

Ultrasonic Testing (UT) – NWIT Document No: 007491

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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 Segment 12CE. The weld designations reviewed are as follows:

1. SEG3003A-006, 014

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld is identified as 1G-004 of BK004A5-002 for BK005A-002. The welder is identified as 062761. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld is identified as 2G-006 of BK4ASD1-014 for BK004A-014. The welder is identified as 062808. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-B-U2-F.

FCAW welding of weld is identified as 3F-033 of BK004A3-014 for BK004A-014. The welder is identified as 260562. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133.

FCAW welding of Plug weld is identified as 1G-019 of BK004A2-006 for BK004A-006. The welder is identified as 058792. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-2-Plug.

FCAW welding of weld is identified as 2G-004 of SB021-012 for SB102E. The welder is identified as 062783. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair.

Visual Inspection after Blast

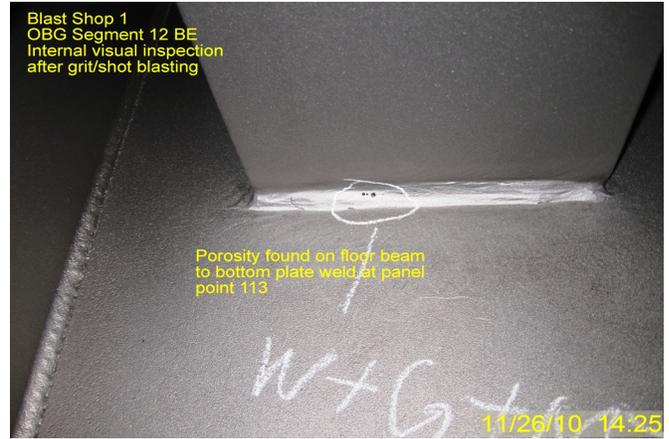
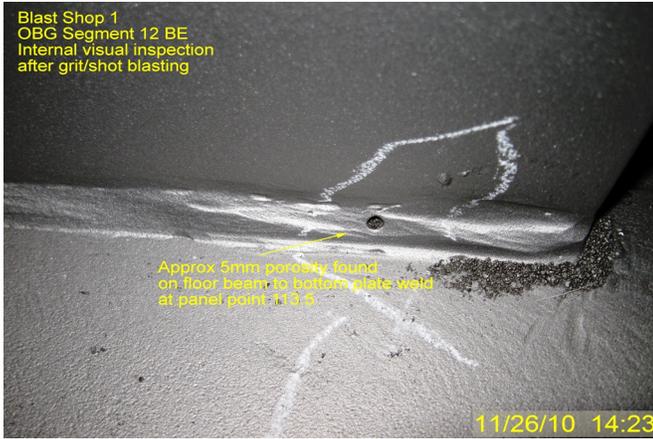
OBG Segment 12BW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12BW, after the grit blast of the interior components bottom side of the longitudinal diaphragm, floor beams, side plates and corner assemblies of this segment panel point PP113 to P115. 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 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: Patel,Hiranch

QA Reviewer