

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018488**Date Inspected:** 29-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: 007539

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 Brackets at Bay 19. The weld designations reviewed are as follows:

1. SB027-110-037, 041, 059, 066, 070, 077, 081, 088, 092, 099

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint is identified as SB024-108-003 located on web flange of OBG Suspender Bracket 108E. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-3G (3F)-Repair.

FCAW welding of weld joint is identified as SB025-108-003 and 004 located on web flange of OBG Suspender

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bracket 10W. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -345-FCAW-3G (3F)-Repair.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on OBG Bike Path BK004B-001.

This QA inspector observed ABF personnel performed Ultrasonic Testing on OBG Bike Path BK004A-014 and BK005A-002.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BP3101-001-013, 014, 015, 016, 017 and 018 located on bottom plate of OBG Segment 14W. Welder is identified as 220314. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2132.

FCAW welding of weld joint BP3101-001-003, 004, 005, 006, 007, 008, 009 and 010 located on bottom plate of OBG Segment 14W. Welder is identified as 218995. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2132.

Bay 14 – East Line

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of welds joint DP3102-001-251 located on deck panel diaphragm of OBG Segment 13AE. ZPMC Welder is identified as 068994. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

FCAW welding of welds joint DP3079-001-375, 372 and 385 located on deck plate U-ribs of OBG Segment 13AE. ZPMC Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhou Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-ESAB.

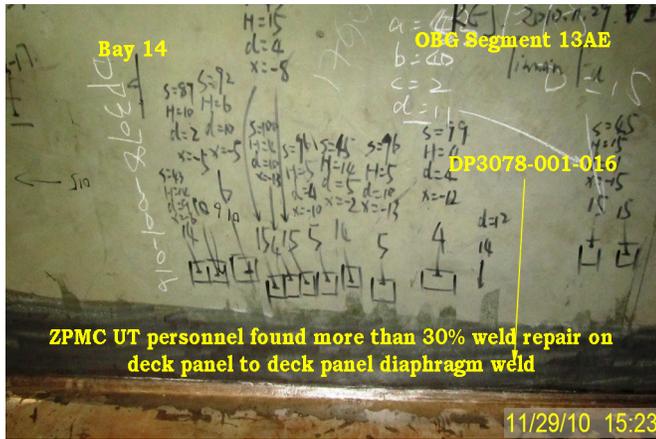
FCAW welding of welds joint DP3079-001-042, 045 located on deck plate U-ribs of OBG Segment 13BE. ZPMC Welder is identified as 044790. ZPMC Quality Control (QC) is identified as Mr. Zhou Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-ESAB.

This QA inspector observed ABF personnel performed Ultrasonic Testing on deck panel to deck panel diaphragm weld of OBG Segment 13AE. The weld joint is identified as DP3078-001-016. ZPMC QC is identified as Mr. Zhou Guo Hui. During this QA observation, 30% weld length is repair area marked by ZPMC UT inspector. See the attached pictures.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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: Patel,Hiranch

QA Reviewer