

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018652**Date Inspected:** 23-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Tian Lei**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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(s) is/are identified as follows; 20TR1-051,043,046,017,038,052,041,024,032, 034,047,040, for item number 2 on NWIT tracker document # 07078.

Bay 2

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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(s) is/are identified as follows; E5-SB1-001, E5-SB1-034, E5-SB1-037, for item number 3 on NWIT tracker document # 07078.

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Tian Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Components: Floor Beam
PCMK: FB3343-001-281
Welder: 066236
Report: B-WR-16137
WPS-345-FCAW-2G (2F)-Repair-1

PCMK: FB3343-001-103
Welder: 045240
Report: B-WR-16142
WPS-345-FCAW-2G (2F)-Repair-1

PCMK: FB3343-001-023
Welder: 045276
Report: B-WR-16150
WPS-345-FCAW-2G (2F)-Repair-1

PCMK: FB3343-001-035
Welder: 045227
Report: B-WR-16155
WPS-345-FCAW-2G (2F)-Repair-1

PCMK: FB3343-001-025
Welder: 045280
Report: B-WR-16152
WPS-345-FCAW-3G (3F)-Repair-1

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Tian Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam
PCMK: FB3286-001-105
Welder: 055491
Report: B-WR-16125
WPS-345-FCAW-2G (2F)-Repair-1

PCMK: FB3286-001-231
Welder: 044830
Report: B-WR-16130
WPS-345-FCAW-2G (2F)-Repair-1

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

PCMK: FB3286-001-111

Welder: 055564

Report: B-WR-16126

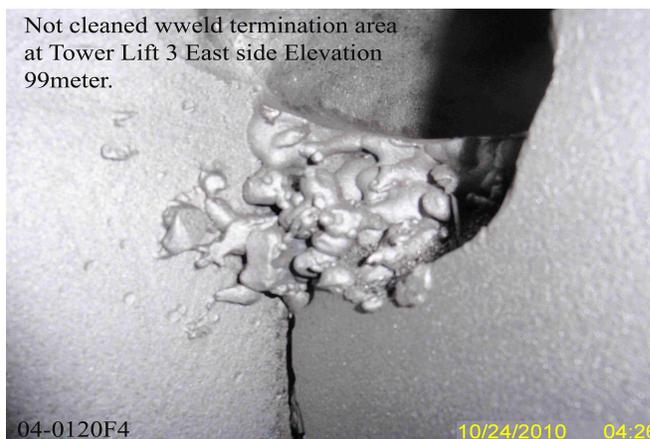
WPS-345-FCAW-3G (3F)-Repair-1

Blasting Shop # 1

QA inspector has performed visual inspection on interior of elevation 99 meter to 114 meter of Tower Lift 3 East side, QA inspector has find out 2 weld repair areas.

All indication locations and detail information were turn to QA Inspector Mr. Baskar.

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



Summary of Conversations:

No relevant conversations

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Shin,DJ

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer