

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-018742**Date Inspected:** 29-Sep-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:** Lin Fe Wen**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay#8

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG bike path joint, weld No.BK004SD1-053. The welder is identified as #067947. ZPMC QC is identified as Mr.Lin Fe Wen .The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

Bay#7

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Tie down Seat plate joint, weld No.SA3077-006-001. The welder is identified as #051246. ZPMC QC is identified as Mr.Wang Li Yang.The welding variables recorded by QC appear to comply with WPS-B-T-2333-C-P2-F.

FCAW in the 2F position for the OBG Floor Beam joint, weld No.FB3241-001-009/010. The welder is identified as #062447. ZPMC QC is identified as Mr. Wang Li Yang.The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

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FCAW in the 1G position for the OBG Cross Beam CB19, weld No.X4253A-004-001. The welder is identified as #053742. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F-2.

Magnetic Particle Testing (MPT) for OBG Steel Barrier

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Steel Barrier weld. This QA inspector generated a (MT) report for this date. This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

W2-SB1-011- 050, 93, 131, 86
W2-SB1-014- 050, 93, 131, 86
W2-SB1-017- 050, 31, 131, 94
W2-SB1-008- 050, 31, 131, 94
W2-SB1-016- 019, 62, 131, 94
W2-SB1G-004- 050, 31, 131, 94
W2-SB1G-008- 050, 31, 131, 94

Ultrasonic Testing (UT) for Steel Barrier

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG steel barrier weld joints.

The welds designation reviewed are as follows:

W2-SB1-017- 019
W2-SB1-009- 019
W2-SB1-012- 019
W2-SB1G-008- 019
W2-SB1G-002- 050
W2-SB1G-004- 019

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

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ZPMC personnel performing FCAW for weld joint BK4ASD1-053 at 3G position on bike path at Bay#8



ZPMC personnel performing FCAW for weld joint SA3077-006-001 at 3G position on Tie down Seat Plate at Bay#7



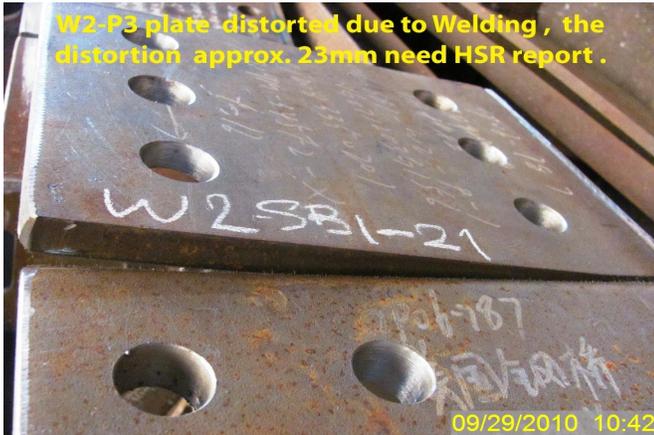
ZPMC personnel performing semi automatic FCAW for weld joint FB3241-001-009/010 at 2F position at bay#7



ZPMC personnel performing FCAW for weld joint W2-SB1-023-126 at 2F position on Steel Barrier at bay#7



W2-P3 plate distorted due to Welding , the distortion approx. 23mm need HSR report .



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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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