

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-020363**Date Inspected:** 05-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:** Liu Hua Jie**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 Segment Assembly**Summary of Items Observed:**

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

This QA Inspector performed the following work:

OBG Segment 10AE-10BE

Flux Core Arc Welding (FCAW) in the 3G position of Bottom Panel 'I' rib weld # B129-001-022. The welder is identified as 040367. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2 -F. See attached photograph Pic_001.

OBG Segment 10AE-10BE

Shielded Metal Arc Welding (SMAW) in the 3G position of Crossbeam side DP 'I' rib weld # DP701-001-35. The welder is identified as 044504. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b. See attached photograph Pic_001.

OBG Segment 10AE-10BE

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Shielded Metal Arc Welding (SMAW) in the 3G position of Bike Path side DP 'T' rib weld # DP714-001-35. The welder is identified as 044504. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b. See attached photograph Pic_001.

OBG Segment 10AW-10BW

During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on DP to EP hold back weld.

OBG Segment 10AE-10BE

Flux Core Arc Welding (FCAW) in the 1G position of Counterweight connection plate weld # OBW10L-007. The welder is identified as 053316. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T. See attached photograph Pic_002.



Summary of Conversations:

No relevant conversations reported on 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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
