

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-020380**Date Inspected:** 22-Aug-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: Zhu Zong Hai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 10AW-10BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Crossbeam side SP to SP splice weld # OBW10B-004.

The welders are identified as 067752. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photographPic_001.

OBG Segment 10AW-10BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side SP to SP 'I' rib splice weld # SP660-001-31. The welders are identified as 067571. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photographPic_002.

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OBG Segment 10AE-10BE

Flux Core Arc Welding (FCAW) in the 1G position of DP to DP splice weld # OBE10-002. The welders are identified as 040367. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

OBG Segment 9EW

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Counterweight side SP to EP holdback weld (10AW side)

ABF Report # UT-9W-083-R1

The weld designations reviewed are as follows:

CA067-005

OBG Segment 10AW

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Counterweight side DP to EP holdback weld (9EW side)

ABF Report # UT-10W-018-R1

The weld designations reviewed are as follows:

CA071-002

OBG Segment 10AW

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Counterweight side SP to EP holdback weld (9EW side)

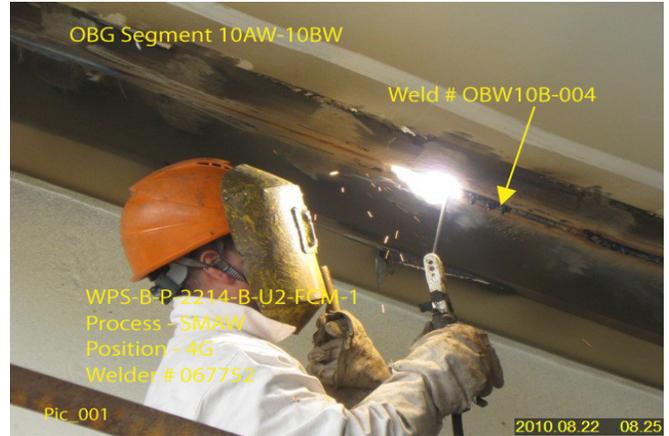
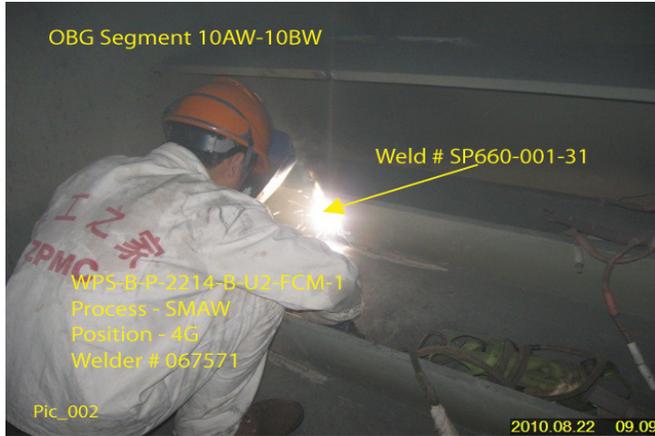
ABF Report # UT-10W-019-R1

The weld designations reviewed are as follows:

CA071-001

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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
