

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-020382**Date Inspected:** 20-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 Counterweight side SP to SP splice weld # OBW10B-002. The welder is identified as 067665. 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 photograph Pic_001.

OBG Segment 10AW-10BW

Flux Core Arc Welding (FCAW) in the 3G position of Counterweight side 'I' rib splice weld # SP676-001-047. The welders are identified as 040704. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

OBG Segment 10AW-10BW

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Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side DP to EP hold back weld # 10AW-CA071-006 & 10BW-CA073-002. The welder is identified as 037723. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-F. See attached photograph Pic_002.

OBG Segment 10AW-10BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Crossbeam side DP to EP hold back weld # 10AW-SEG059*-035 & 10BW-CA074-006. The welder is 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-TC-U4b-F.

OBG Segment 10AW

Flux Core Arc Welding (FCAW) in the 2G position of Counterweight side EP to SP hold back weld # CA071-005. The welder is identified as 040759. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-P-2232-TC-U4b-F.

OBG Segment 9BW-9CW

This QA inspector performed Magnetic Particle (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as Counterweight side EP to EP & SP to SP welds as per ZPMC notification # 06443.

The weld designations reviewed are as follows:

OBW9-006

OBW9B-006 and 007



Summary of Conversations:

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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
