

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020555**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi 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:** Lift 12W, Lift 12E**Summary of Items Observed:**

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

OBG: (Trail Assembly)

WELDING

Lift 12E

This QA Inspector observed the following work in progress:

SMAW Repair welding of weld joint OBE12E-003 side plate, located on Lift 12E. Welder is identified as 040378, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G-(4F)-Repair and Critical Weld Repair, # B-CWR2126.

Lift 12W

SMAW Repair welding of weld joint SP3041-001-048, located on Lift 12W, Welder is identified as 040611, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Bu2-FCM-1.

SMAW welding of SP3041-001-041, located on Lift 12W, Welder is identified as 057333, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with

WELDING INSPECTION REPORT

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WPS-B-P-2214-Bu2-FCM-1.

SMAW welding of weld joint SP3050-001-042, located on Lift 12W, Welder is identified as 057333, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Bu2-FCM-1.

SMAW welding of weld joint SP3050-001-040, located on Lift 12W, Welder is identified as 046709, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Bu2-FCM-1.

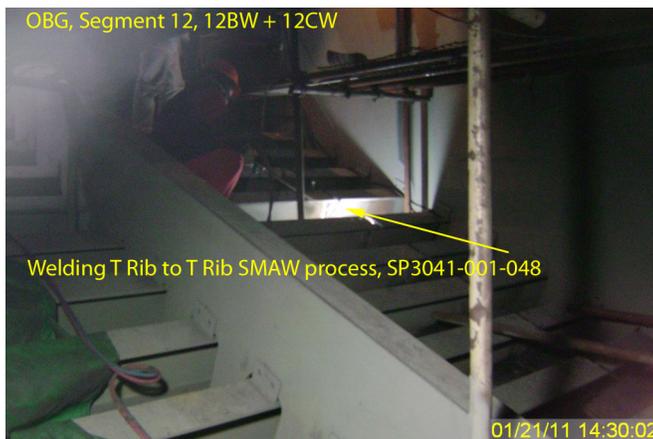
OBG Bay # 28

NDT

The following NDT performed ZPMC NDT notification 08256:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 1540 hours. The members are identified as follows OBG, Splice Plates, The weld designations reviewed are as follow: SA3400B~036-003, 004, SA7010A-001~007-001, 002, SA7010B-001~007-001, 002, SA3321A-001~036-001, 002

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were 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, 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
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Reviewed By:	Hall, Steven	QA Reviewer
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