

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-020706**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiung**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**Summary of Items Observed:**

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

Bay 13

This QA Inspector observed the following work in progress for Bay 13.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Anchor Tie Down

PCMK: SA3011-001

Weld Number: 001

Welder: 070140

WPS-B-T-2333-ESAB

Component: Anchor Tie Down

PCMK: SA3011-002

Weld Number: 001

Welder: 070140

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-B-T-2333-ESAB

Trial Assembly Yard

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07914 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG 11EW, 11DW, and 11DE. The weld designations reviewed are as follows.

OBW11E-079, 081, 082, 083, 085, 087, 092

OBW11D-079, 081, 082, 083, 087, 092

FB020-009-128

FB024-011-128

FB028-012-128

SSD16-PP104-170

SSD17-PP105-166

SSD18-PP106-169

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

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.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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