

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-020811**Date Inspected:** 24-Oct-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:** Li Yan Hua**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.

OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld joint OBW12B-013 located on Counterweight side Drain Plate. The welder is identified as 067746. ZPMC Quality Control (QC) is identified as Wang Wei Ming.

The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1. See attached photograph Pic_001.

Paint Shop 3 / Cross Beam CB 14

This QA Inspector could not performed MT as per ZPMC notification # 7065 item # 1 to 4 due to water all around welds & unavailability of power supply in Paint Shop # 3. Finally ZPMC cancelled notification.

Waiting time: - Morning 9.00 to 11.00 AM

Afternoon 12.15 to 14.30 PM

OBG Segment 12AW

WELDING INSPECTION REPORT

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During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Deck Panel Diaphragm to Flange weld. See attached photograph Pic_002.

OBG Segment 12AW

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 3G position of weld joint CA3006C-152 located on PP110 West. The welder is identified as 048714. ZPMC Quality Control (QC) is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS B-P-2233-TC-U4c-F.

Bay 14 / OBG Segment 14W

This QA Inspector observed the following work in progress:
Sub Arc Welding (SAW) in the 1G position of weld joint SEG3020AZ-007 located on SP3143B to SP3142E. The welder is identified as 045270. ABF Quality Assurance (QA) is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS B-T-2221-B-L2c-S-2. 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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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