

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-020817**Date Inspected:** 23-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 12BE

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Cross Beam side SP long seam welds.

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-153 located on PP110 East. 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. See attached photograph Pic_001.

Bay 16 / Steel Barrier

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Steel Barrier W5-SB1-007.

WELDING INSPECTION REPORT

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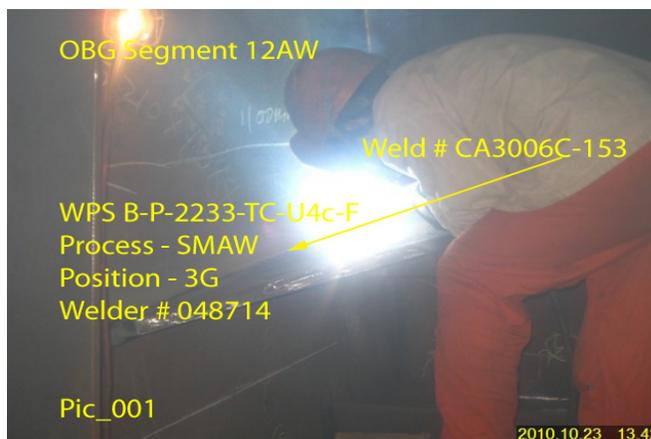
OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld joint SEG3004T-031 located on CW side PP110 flange to LD repair as per WR # 15246. The welder is identified as 045133. ZPMC Quality Control (QC) is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-1G(1F)-FCM -Repair. See attached photograph Pic_002.

Paint Shop 2 / Tower Lift 3 South Shaft

This QA inspector performed external visual inspection of welds & base metal after blasting along with ZPMC and ABF Quality Assurance (QA) personnel. The member is identified as South Shaft of Tower Lift 3.



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
