

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-021157**Date Inspected:** 09-Feb-2011**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:** Sha Zhi**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 13AE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of EP to FB repair weld # SEG3007AB-087, as per B-WR # 20166. The welder is identified as 044772. ZPMC Quality Control (QC) is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair. See attached photograph Pic_001.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3007T-114. The welder is identified as 066173. ZPMC Quality Control (QC) is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 14E / Bay 14

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of SA3358A to AP3031A weld # SEG3009BB-025. The welder is identified as 067877. ABF Quality Assurance (QA) is identified as Zhang Xiao Bin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Deck Panel weld # DP3160-001-003 after back gauging. See attached photograph Pic_002.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC personnel performing back gauging on AP3031A to LD weld.

OBG Lift 13 and 14 / Bay 14

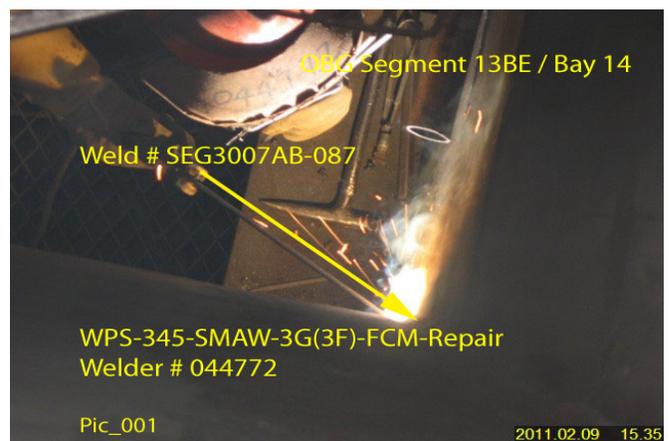
This QA Inspector observed the following:

ZPMC was not performing any work on OBG lift 13 and 14 in Bay 14 after 1900 hrs.

Reporting on PMIV

This QA Inspector performed the following:

This QA Inspector entered back date WIR and NDE reports on PMIV.



Summary of Conversations:

No relevant conversations reported on this date.

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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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