

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-021166**Date Inspected:** 29-Sep-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:** Xu Tao**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.

This QA Inspector performed the following work:

Bay 16/OBG 13CW Assy

Flux Core Arc Welding (FCAW) in the 3G position of Longitudinal Diaphragm Lifting Bracket weld # LD3033-001-048. The welder is identified as 045280. ABF Quality Assurance (QA) is identified as Li Shi You. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-TC-U5-F.

Bay 16/OBG 13BW Assy

Flux Core Arc Welding (FCAW) in the 3G position of Longitudinal Diaphragm Lifting Bracket weld # LD3035-001-049. The welder is identified as 048696. ABF Quality Assurance (QA) is identified as Li Shi You. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-TC-U5-F. See attached photograph Pic_001.

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Bay 16/ OBG 13AE Assy

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on weld repaired area of Bottom Panel Weld # BP3050-001-001. While performing UT ZPMC NDT personnel found linear indications at Y= 4060 and Y= 4340. See attached photograph Pic_002

Bay 16/ Steel Barriers

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1-029 Steel Barrier internals weld # SB1-029-044. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16/ Steel Barriers

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1-014 Steel Barrier internals weld # SB1-029-128. The welder is identified as 068994. ZPMC Quality Control (QC) is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16/OBG 13CW Assy

Flux Core Arc Welding (FCAW) in the 2G position of Longitudinal Diaphragm Lifting Bracket weld # LD3036-001-052. The welder is identified as 045143. ABF Quality Assurance (QA) is identified as Li Shi You. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U5-F.



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.

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Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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