

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-021168**Date Inspected:** 26-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:** LV Li Qing**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 14/OBG 13CW Assy

Flux Core Arc Welding (FCAW) in the 1G position of Deck Panel plate PL3146A to PL3147A root pass weld # SEG3015-003. The welder is identified as 202122. ZPMC Quality Control (QC) is identified as Xia Chun Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F. See attached photograph Pic_001.

Bay 14/OBG 14E Assy

Flux Core Arc Welding (FCAW) in the 2G position of Vertical Plate 'I' rib weld # VP3016-001-016. The welder is identified as 069089. ZPMC CWI is identified as LV Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F. See attached photograph Pic_002.

Bay 14/OBG 14E Assy

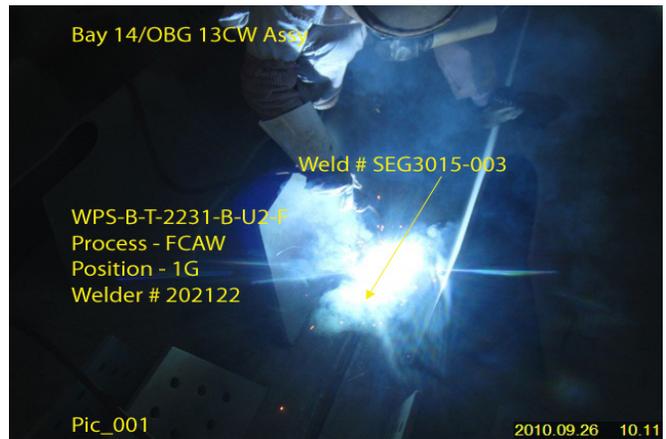
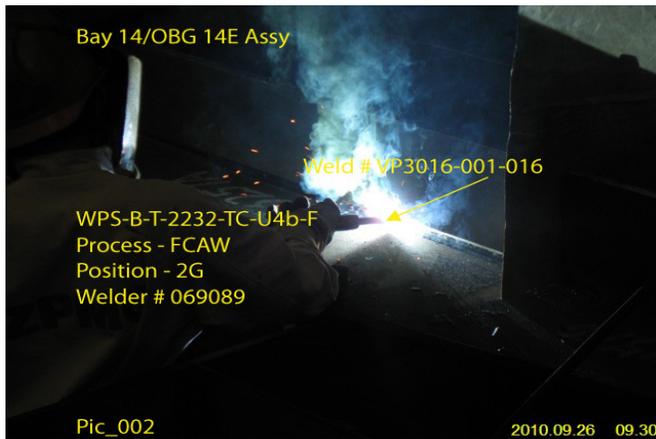
WELDING INSPECTION REPORT

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Flux Core Arc Welding (FCAW) in the 2G position of Vertical Plate 'I' rib weld # VP3016-001-006. The welder is identified as 066763. ZPMC CWI is identified as LV Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U4b-F.

Bay 14/OBG 14W Assy

Flux Core Arc Welding (FCAW) in the 2F position of AP plate PL3530A 'I' rib weld # AP2023-001-023. The welder is identified as 020122. ZPMC Quality Control (QC) is identified as Xia Chun Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.



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
