

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-021254**Date Inspected:** 12-Jul-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:** Le Yang**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 observed the following work in progress:

OBG Segment 9BE

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BE-FL#3 Half Diaphragm Flange. Weld # SSD27-PP075-137 as per Repair Report # B-WR-13976. The welder is identified as 048569. ZPMC Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1. See attached photograph Pic_001

OBG Segment 9BE-9CE

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Side Panel Splice weld between OBG segment 9BE and 9CE of Cross Beam side. ABF Report No: UT-9E-057

The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

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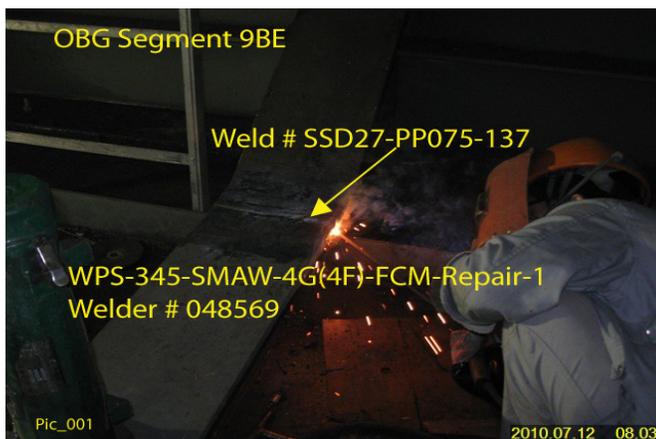
OBE9B-006 and 007

OBG Segment 9BE-9CE

During in process visual inspection of 9BE-9CE, This QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Side Panel Splice weld at Bike Path side. See attached photograph Pic_002

OBG Segment 9CE-9DE

Shielded Metal Arc Welding (SMAW) in the 4G position of Side Panel Splice weld at Cross Beam side. Weld # OBE9C-001. The welder is identified as 066179. ZPMC CWI is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.



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
