

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-021257**Date Inspected:** 10-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:** Liu Hua Jie**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 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 2G position of Bottom Panel 'T' Rib Hold back weld MT repair area.

The welder is identified as 067904. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS – 345-SMAW-2G(2F)-FCM-Repair-1.

OBG Segment 9AW-9BW

During in process visual inspection of 9AW-9BW, This QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Deck Panel temporary attachment removed area. See attached photograph Pic_001

OBG Segment 9CE-9DE

Flux Core Arc Welding (FCAW) in the 3G position of Bottom Panel 'T' Rib Splice weld joint, weld # BP126-001-022. The welder is identified as 068501. ZPMC CWI is identified as Liu Huajie. The welding

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variables recorded by QC appeared to comply with WPS - B-T-2233T. See attached photograph Pic_002.

OBG Segment 9CE-9DE

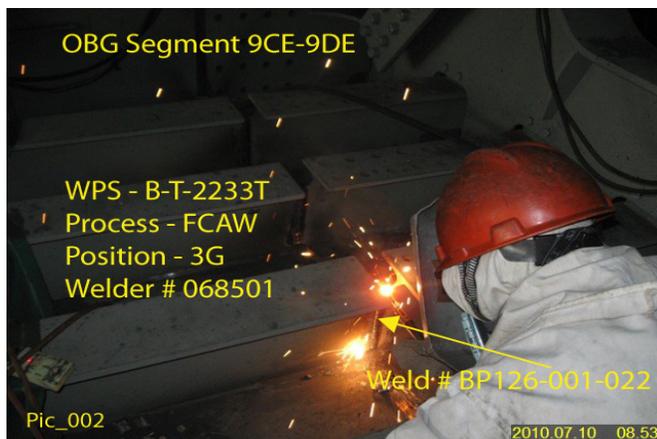
Flux Core Arc Welding (FCAW) in the 3G position of Side Panel 'T' Rib Splice weld joint at Cross Beam side, weld # SP545-001-053. The welder is identified as. ZPMC CWI is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS - B-T-2233T.

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Side Panel UT Repair weld area at Counterweight side , weld # OBW9B-002. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS – 345-SMAW-4G(4F)-FCM-Repair-1, as per repair report # B-CWR1698.

OBG Segment 9CE-9DE

Flux Core Arc Welding (FCAW) in the 1G position of Counterweight side Deck Panel Splice weld, weld # BOE9A-002. The welder is identified as 066443. ZPMC CWI is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS - B-T-2233T-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

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Reviewed By: McClendon, Timothy

QA Reviewer