

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-021266**Date Inspected:** 27-Jun-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: Wu Zhi Cheng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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-9CE

Shielded Metal Arc Welding (SMAW) in the 4F position of 8CW Side Panel base metal at Cross beam side connecting end of 9AW, as per repair report # B-CWR-1414. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-345-SMAW 4G(4F)-FCM-Repair. See attached photograph Pic_001

OBG Segment 9AE-9BE

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

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of Side Panel at Bike Path side, weld joint OBE9B-010.

WELDING INSPECTION REPORT

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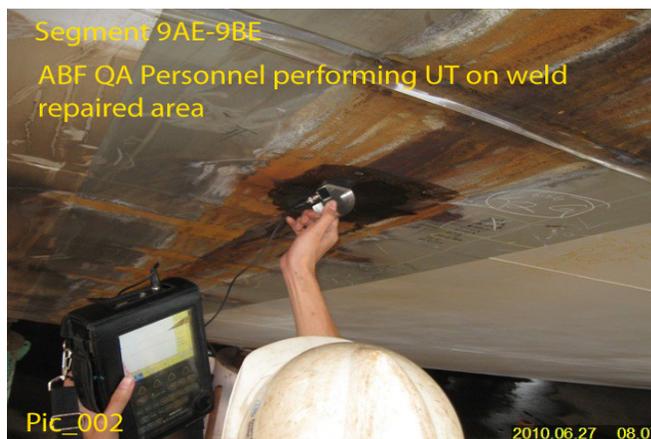
The welder is identified as 048659. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-BU2-FCM-1.

Counterweight CW56

Shielded Metal Arc Welding (SMAW) in the 1G(1F) position of Lower Plate edge built up as per report # B-WR13677. The welder is identified as 66179. ZPMC Quality Control (QC) is identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-Repair.

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of Bike Path side Edge Panel 'I' Rib, weld joint EP163-001-014. The welder is identified as 054467. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-BU2-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
