

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-021270**Date Inspected:** 26-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:** 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 observed the following work in progress:

OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 4F position of Cross beam side Edge Panel 'I' Ribs, weld joint 9BE-EP163-001-010 & 012, 9CE-EP164-001-006 & 0081. The welder is identified as 220067. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2134. See attached photograph Pic_001

OBG Segment 8AW

Magnetic Particle Testing (MT) of FL3 panel Holdback area at PP62 of Cross beam side was in progress by ABF Technician. See attached photograph Pic_002

OBG Segment 11BE

Shielded Metal Arc Welding (SMAW) in the 4F position of side panel manhole stiffeners at PP99 of cross beam side weld joint SSD17-PP99-262 & 263. The welder is identified as 200113. ZPMC Quality Control (QC) is

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identified as Tangyajun. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Counterweight CW56

Magnetic Particle Testing (MT) of Counterweight CW56 touch up areas was in progress by ABF Technician.

OBG Segment 8AW

Magnetic Particle Testing (MT) of FL3 panel at PP63 of Cross beam side was in progress by ZPMC Technician.

OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 3G position of Cross beam side Edge Panel, weld joint OBE9B-006. The welder is identified as 220067. ZPMC Quality Control (QC) is identified as Anqing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.



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
