

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-022005**Date Inspected:** 09-Mar-2011**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:** Geng Wei**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08490

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

SEGMENT 14 EAST

SEG3019X-095~098

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #187 located on 13AW, SA3126A-001. Welder is identified as 068091. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

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Weld joint #190 located on 13AW, SA3126A-001. Welder is identified as 037996. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

Weld joint #188 located on 13AW, SA3126A-001. Welder is identified as 068091. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

Flux Cored Arc Welding (FCAW):

Weld joint #165 located on 13BW, Deck Panel DP3126-001. Welder is identified as 048696. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB. (See attached photo)

Weld joint #068 located on 13AW, Deck Panel DP3138-001. Welder is identified as 204730. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #010 located on SA3013-001. Welder is identified as 051356. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB. (See attached photo)

Weld joint #140 located on Deck Panel DP3173-001. Welder is identified as 048433. ZPMC Quality Control (QC) Inspector is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #161 located on 13BW, Deck Panel DP3126-001. Welder is identified as 048696. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #076 located on 13AW, Deck Panel DP3138-001. Welder is identified as 204730. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

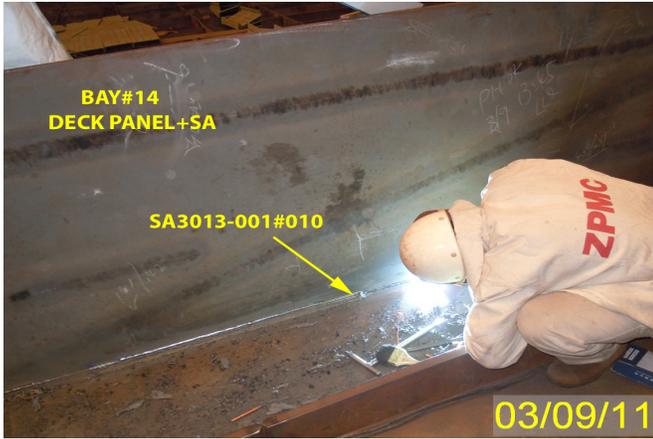
Weld joint #076 located on 13AW, Deck Panel DP3138-001. Welder is identified as 204730. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #279 located on SA3013-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer