

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-022368**Date Inspected:** 24-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Geng Wei
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.

OBG Segment 12BE / Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Segment 12BE welds as per ZPMC notification # 08612.

The weld designations reviewed are as follows:

SEG3001G-133, 134, 010, 011
CA6501D-061, 062, 013~016, 001, 002, 153~156, 037, 038
DP3010-001-082~086
FB3009-001-010, 011
SEG3001E-131~134, 004, 005
CA6501C-061, 062, 013~016, 001, 002, 037, 038, 049, 050
DP3010-001-052~054, 050
SEG3001C-132, 0133, 010, 011
CA6501D-261, 262, 213~216, 235~238, 277, 278, 001, 002
DP3010-001-018~022

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SEG3001K-131~134, 004, 005
CA3003C-061, 062, 013~016, 001, 002, 037, 038
DP3021-001-103~105
SEG3001H-130~134, 013, 014
CA3003D-061, 062, 013~016, 001, 002, 035~038, 153, 154
DP3021-001-071~075

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-089. The welder is identified as 216086. Quality Control (QC) is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-111. The welder is identified as 043601. Quality Control (QC) is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-133. The welder is identified as 215553. Quality Control (QC) is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

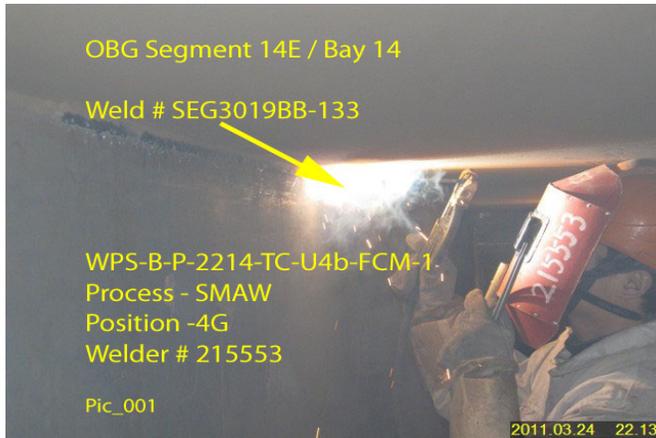
This QA Inspector observed the following work in progress:
Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-155. The welder is identified as 044779. Quality Control (QC) is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:
During in process inspection this QA observed ZPMC personnel performing back gauging on weld # SEG3019AQ-025.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
