

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022777**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:** Wang Jun**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, APBB**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Wang Xiang Pin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Architectural Housing

PCMK: AH3001

Weld Number: 001

Welder: 067876

WPS-B-T-2231-ESAB

Component: Side Plate

PCMK: SEG3014A

Weld Number: 007

Welder: 067572

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WPS-B-P-2214-B-U2-FCM-1

Component: Side Plate

PCMK: SEG3014A

Weld Number: 007

Welder: 067829

WPS-B-P-2214-B-U2-FCM-1

Component: Traveler Rail

PCMK: TR3004-001

Weld Number: 016

Welder: 201215

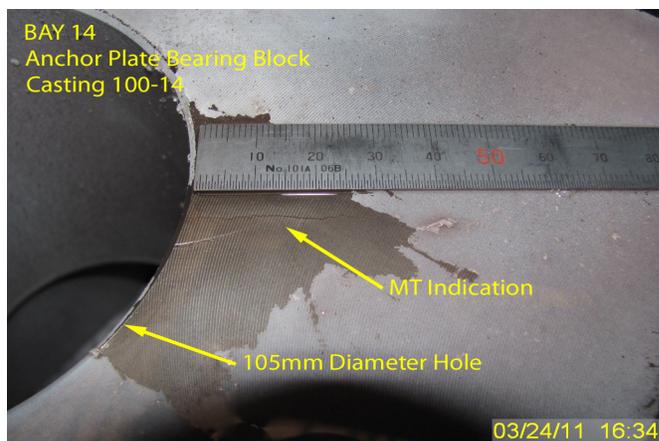
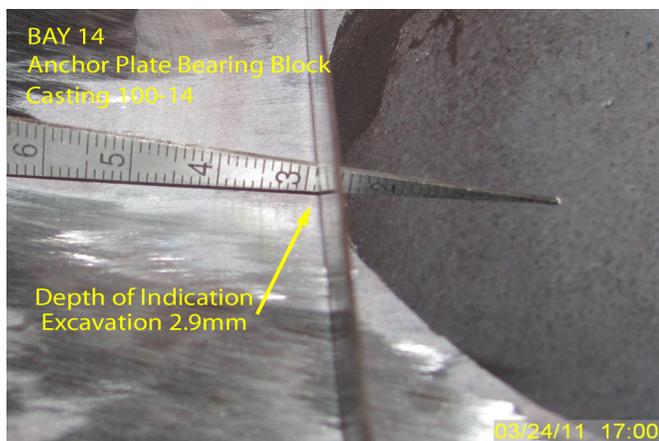
WPS-B-T-2231-ESAB

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08614 from ZPMC for Bay 14. This QA inspector performed magnetic particle testing (MT) verification of castings after ZPMC had performed their MT inspection. The segment is identified as OBG Anchor Plate Bearing Blocks. The weld designations reviewed are as follows.

APBB1-094-06, APBB1-100-14, APBB1-088-08, APBB1-082-02, APBB1-083-15

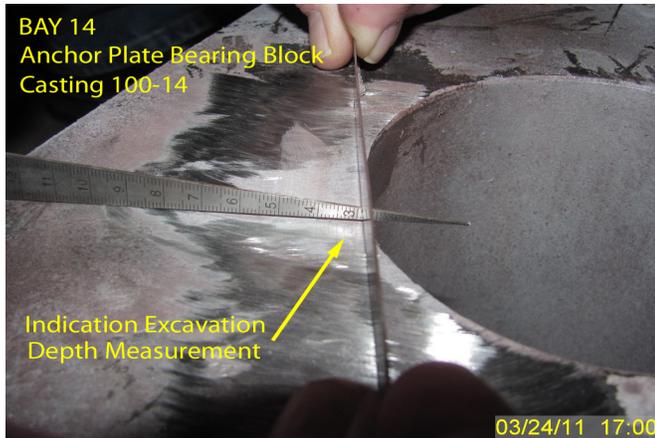
This QA inspector during wet MT verification found an indication on Anchor Plate Bearing Block Casting 100-14 approximately 30 mm in length beginning from the 105 mm diameter hole. Informed ZPMC QC of MT indication found, ZPMC verified indication and proceeded to excavate base metal with mechanical grinder until no indication was present. This QA inspector verified excavation depth at 2.9mm. ZPMC QC determined no weld repair was required. Photos attached.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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