

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-023283**Date Inspected:** 04-May-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. Li Yang**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.

Bay 14 / Bike Path 016

This QA Inspector observed the following work in progress:

ZPMC personnel performed weld repair on Bike Path Cantilever weld # BK016-001-003 as per B-CWR # 2961 as follows.

- Back gauged existing weld ground smooth all weld faces to be welded
- ABF performed MT on back gauged area
- Fit up of backing strip and tack welded
- Root pass welding completed
- ABF performed MT on root pass welding
- Filling and capping weld completed

Flux Core Arc Welding (FCAW) in the 3G position performed for above weld repair. The welder is identified as 044733. Quality Control (QC) is identified as LI Yang. The welding variables recorded by QC appeared to comply with WPS- 345-FCAW-3G(3F)-FCM-Repair. See attached photograph Pic_001.

WELDING INSPECTION REPORT

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Bay 19 / Bike Path

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of Bike Path weld # BK24A1-001-012. The welder is identified as 062807. Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS- B-T-2231-ESAB.

Bay 14 / Bike Path

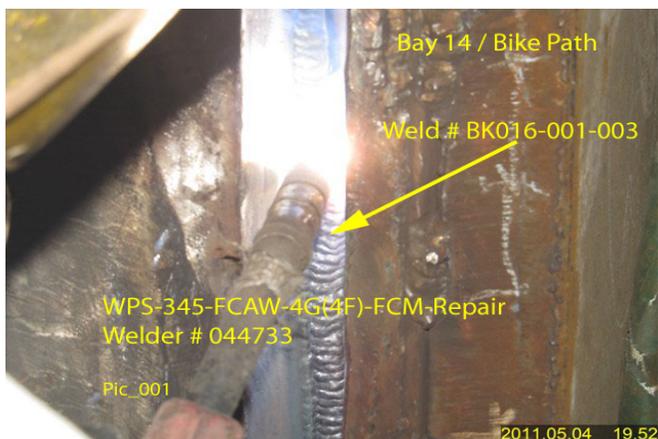
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2F position of weld # BK017-001-056. The welder is identified as 052493. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-2112-FCM-1.

Bay 14 / U Rib Splice Plate

This QA Inspector observed the following work in progress:

ZPMC NDT personnel performing Ultrasonic Testing (UT) on U Rib Splice Plate weld # X3305K-091-001.



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 James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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