

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023290**Date Inspected:** 24-Apr-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. Lv Li Qing**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 / OBG segment 14E

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 14E welds as per ZPMC notification # 08920.

The weld designations reviewed are as follows:

SEG3019AB-136, 137

SEG3019X-07, 006, 005, 004

Trial Assembly / OBG segment 13AW – 13BW

This QA Inspector observed the following work in progress:

ZPMC personnel performing fit up and tack welding of OBG 13AW and 13BW Bottom Panel weld. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

WELDING INSPECTION REPORT

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Trial Assembly / OBG segment 13AW

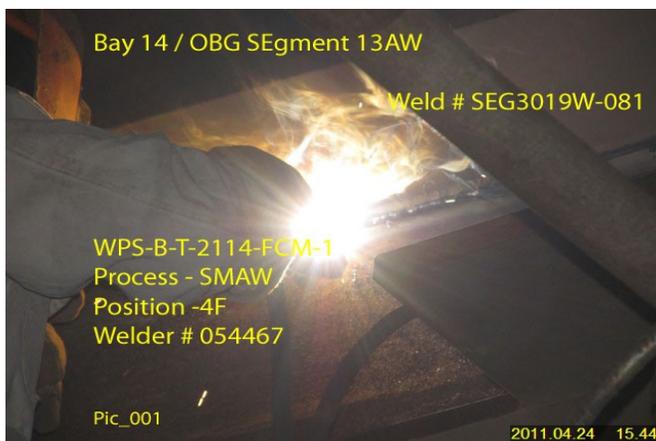
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3013C-206. The welder is identified as 054467. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1. See attached photograph Pic_001.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of weld # SEG3013C-215. The welder is identified as 220066. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS- B-T-2132-ESAB.



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
Reviewed By:	McClendon,Timothy	QA Reviewer
