

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-023508**Date Inspected:** 18-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:**

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC personnel performing back gauging on weld # SEG3019W-082. See attached photograph Pic_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Deck panel weld # SEG3011-004.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Deck panel weld # SEG3009-004.

OBG Segment 14E / Bay 14

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of AP to BP repair weld # SEG3019U-003. The welder is identified as 215553 and 216086, as per B-CWR # 2822. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-SMAW-345-2G(2F)-FCM-Repair.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3019BB-181. The welder is identified as 054013. Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-2214-FCM-1.

OBG Segment 13CE / Bay 14

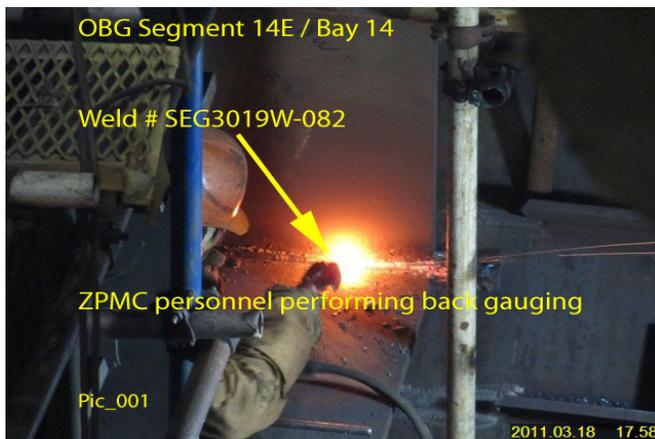
This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Segment 13CE welds as per ZPMC notification # 08574.

The weld designations reviewed are as follows:

SEG3011L-194, 199, 200, 204, 205, 209, 210, 214, 215, 219, 220

SEG3011J-215, 206, 214, 205, 201, 200, 195, 196, 191

Note: - This QA wrote an IR of a class 'A' indication found on weld SEG3011L-219 of OBFG Segment 13CE.



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.

WELDING INSPECTION REPORT

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