

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-023663**Date Inspected:** 29-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Geng Wei**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 Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process in (1G) Position on a weld joint identified as SEG3019AQ-023.OBG 14E Segment. The welder is identified as 067877. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process in (1G) Position on a weld joint identified as SEG3019AQ-023.OBG 14E Segment. The welder is identified as 066763. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB

WELDING INSPECTION REPORT

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MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Bike Path. The welds designations reviewed are as follows: bk25A2-001-020,021,042,009~011,022~024,031~033,044~046

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Bike Path. The welds designations reviewed are as follows: Bk25A6-001-003 004,009,010,063,064,069,070,125,126,132,133,015,016,021,022,075,076,081,082,142,143,147, 148,039,040,045,046,099,100,105,106,170,171,175,176,051,052,057,058,111,112,117,118,183,184,193,194,017, 018,023,024,077,078,083,084,144,145,149,150,041,042,047,048,101,102,107,108,172,173,177,178,053,054,059, 060.113,114,119,120,185,186,195,196,005,006,011,012,065,066,071,072,127,128,134,135

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Bike Path. The welds designations reviewed are as follows: Bk25A3-001-031,035,056,057,023,021,025,036~038,045~047,058~060

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as SEG3019ap 14E. The welds designations reviewed are as follows SEG3019ap-004

VISUAL INSPECTION

This QA Inspector Manuel Teall performed a random visual inspection on OBG APBB1-Bearing Blocks .the blocks are located in Bay 14 And in the paint bay .All visual defects were marked and ZPMC QC was notified .

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant conversations were reported on this date.

WELDING INSPECTION REPORT

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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:	Teall,Manuel	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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