

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023688**Date Inspected:** 16-May-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sun Tian Liang**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**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) – NWIT Document No's: 009143

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Cable Bracket. The weld designations reviewed are as follows:

1. SA6030-001-001, 002, 013, 014, 017, 019, 020, 006, 007, 008, 009, 036, 040
2. SA6030-001-041, 004, 005, 011, 012, 034, 035, 032, 033, 010, 030, 084, 015
3. SA6030-001-039, 018, 107, 110, 051, 046, 047, 028, 031, 066, 095, 102, 103
4. SA6030-001-127, 128, 135, 136, 054, 055, 056, 057, 050, 052, 109, 111
5. SA6030-001-059, 060, 066, 067, 075, 076, 082, 083, 064, 065, 070, 071
6. SA6030-001-072, 079, 080, 061, 062, 068, 069, 077, 078, 084, 085, 063
7. Base metal repair area on SA6030 (CWR2953)

OBG Bike Path – Bay 19

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

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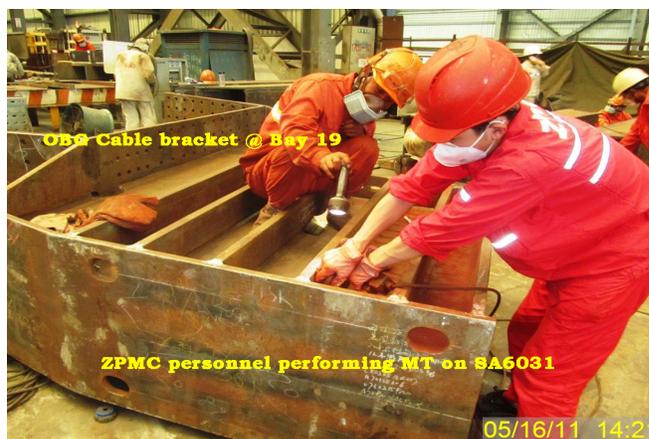
Flux Core Arc Welding (FCAW) welding of weld joint BK24A4-001-001, 002, 016, 017, 023, 024, 038 and 039 located on OBG Bike Path BK24A-001. ZPMC Welder is identified as 208632. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2134-ESAB.

FCAW welding of weld joint BK24A4-001-027, 028, 005, 006, 021, 022, 043 and 044 located on OBG Bike Path BK24A-001. ZPMC Welder is identified as 208641. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

FCAW welding of weld joint BK24A4-001-008, 009, 019, 020, 025, 026, 041 and 042 located on OBG Bike Path BK24A-001. ZPMC Welder is identified as 058792. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2134-ESAB.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing (MT) on OBG cable bracket. The cable bracket is identified as SA6031. See the attached picture.

general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
