

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-024165**Date Inspected:** 01-Jun-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:** Liu Hua Jie/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**Summary of Items Observed:**

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

Ultrasonic Testing:-

OBG Trial Assembly

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 13AE Edge Beam and 13BE Deck Panel Stiffeners. The weld designation reviewed is as follows

OBE13J-001

DP3085-001-003

DP3108-001-033

DP3109-001-020

SEG3007E-191,192

In process Inspection:-

OBG Trial Assembly

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This QA inspector observed the following work in progress:

SMAW welding of weld joint No: OBE13AD-001 located on OBG Segment 13AE and 13BE Vertical panel Splice. Welder is identified as #043661. ZPMC QC is identified as Mr. Wang Li yang. Welding was performed according to the Critical weld repair report B-CWR-3010. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: OBE13AD-005 located on OBG Segment 13AE and 13BE Vertical panel Splice. Welder is identified as #043661. ZPMC QC is identified as Mr. Wang Li yang. Welding was performed according to the Critical weld repair report B-CWR-3009. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

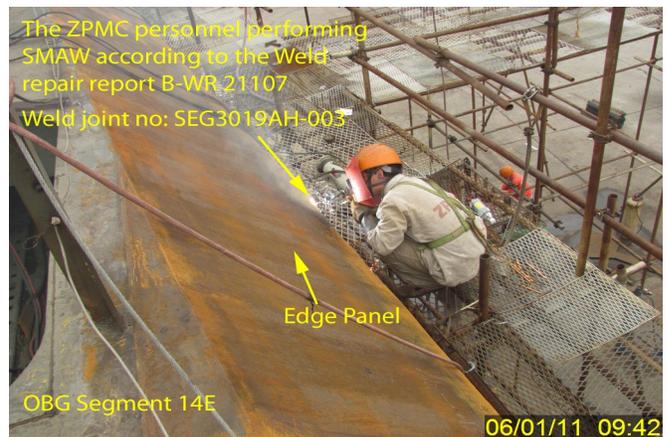
This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3019 AH-003 located on OBG Segment 14E Side panel to Edge Panel. Welder is identified as #215553. ZPMC QC is identified as Mr. Zhu Yuan Yuan. Welding was performed according to the weld repair report B-WR-21107. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair-1. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of Temporary attachments removal areas located on OBG Segment 14E Floor Beam Stiffeners. Welder is identified as #216086. ZPMC QC is identified as Mr. Zhu Yuan Yuan. Welding was performed according to the Critical weld repair report B-CWR-2944. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No Relevant Conversation.

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:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
