

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024297**Date Inspected:** 28-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), Changxing Island **Location:** Shanghai**CWI Name:****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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly Segments 14AE @ CB19E & 14AW @ CB19W

This QA inspector observed the ZPMC personnel performing drilling of floor beams to receive high strength bolting holes at CB19E @ 14AE exterior at bottom plate, also observed match drilling of bolt holes at CB19W @ 14W.

Trial Assembly Segments 13AW @ CB18W

SMAW welding of complete joint penetration welds located on CB18W component identified as CB3013D-018 weld no.(s) 021. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Zhou Zhong Hai appeared to comply with applicable WPS(s) WPS-B-P-2212-TC-U-4b-FCM-1.

Trial Assembly 13AE @ CB18E

This QA inspector observed ZPMC personnel installing alignment pins into bottom plate at CB18E between PP118 & PP120. This inspector conducted visual inspection of hole alignment at FB3108A, FB3122A, FB3109A,

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FB3125A, & FB3121A.

Trial Assembly 13AW

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. All components were as listed on NWIT notification no. 09283. The member(s) is/are identified as OBG Deck Plates and Segments assembly components identified below with the following identifying weld no.(s):

1. DP3120-001-011, 012, 014, 015, 017, 018, 020, & 021.
2. SEG3013Q-106~109.
3. SEG3013L-023, 024, 025, 028, 110, & 111.
4. SEG3013AX-058.
5. SEG3013AS-026, 209, & 210.
6. DP3117-131, 132, 133, 134, & 135.
7. DP3119-085~089.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the report.

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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Rene

Quality Assurance Inspector

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Reviewed By: Hall,Steven

QA Reviewer