

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024412**Date Inspected:** 03-Jun-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. An Qing Xian**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 Assembly**Summary of Items Observed:**

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

Trial Assembly / OBG 13AW

This QA inspector performed verification Magnetic Particle Testing (MT) of the area that has been previously tested by ABF Quality Assurance (QA) personnel. The member is identified as OBG 13AW welds on CB side PP118, 118.65 and 119 -1500.

Trial Assembly / OBG Segment 14W

This QA Inspector observed the following work in progress:

Flux Core Metal Arc Welding (FCAW) in the 2F position of weld # SEG3020AE-061. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as An Qing Xian. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB. See attached photograph Pic_001.

Trial Assembly / OBG Segment 14W

This QA Inspector observed the following work in progress:

Flux Core Metal Arc Welding (FCAW) in the 2F position of weld # SEG3020AE-036. The welder is identified as

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048696. ZPMC Quality Control (QC) is identified as An Qing Xian. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Trial Assembly / OBG Segment 14W

This QA Inspector observed the following work in progress:

Flux Core Metal Arc Welding (FCAW) in the 2G position of weld # SEG3020L-015. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.



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.

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