

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-025205**Date Inspected:** 11-Jul-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:** shen Jian Bo**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.

Magnetic Particle Testing:-

OBG Trial Assembly

This QA inspector performed Magnetic Particle Testing (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 member is identified as OBG Segment 13CW vertical panel stiffeners. The weld designation reviewed is as follows:

LD3036-001-164,165,197,198,257,258,287,288

SEG3015F-207,210,220,221,222,223,243,235,236,237,238

SEG3015H-201,202,300,301,302,303,034,305,320,321,322,323,324,325

In process Inspection:-

OBG Trial Assembly

This QA inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint No: SEG3014S-053 located on OBG Segment 13BW Deck panel to Vertical panel stiffener. Welder is identified as #066156. ZPMC QC is identified as Mr. Shi Lei. Welding was performed according to the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1. Please see the attached picture.

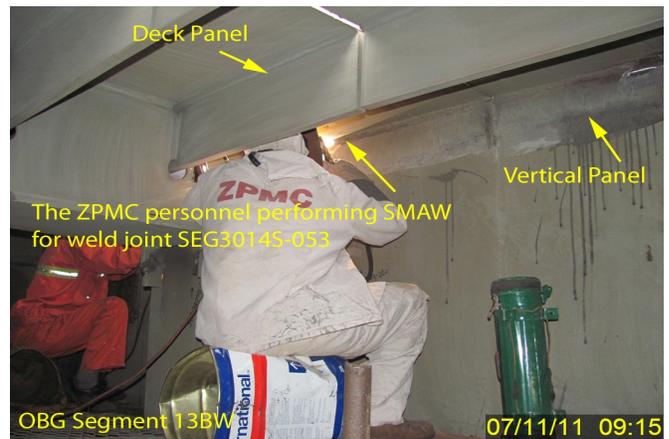
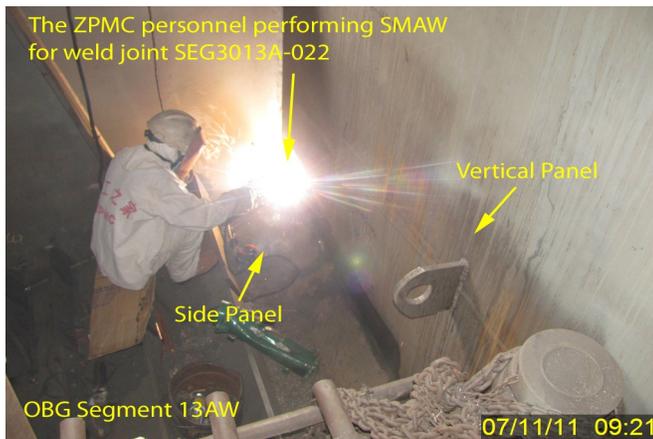
This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3013A-022 located on OBG Segment 13AW Side panel to Vertical panel. Welder is identified as #068097. ZPMC QC is identified as Mr. Shi Lei. Welding was performed according to the temporary weld repair report. 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 weld joint No: SEG3015U-003 located on OBG Segment 13CW Deck panel to Vertical panel. Welder is identified as #067707. ZPMC QC is identified as Mr. Shi Lai. Welding was performed according to the temporary weld repair report. 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.



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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Patel,Hiranch

QA Reviewer