

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006150**Date Inspected:** 08-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**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 Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 13 OBG Assembly

Segment 6CE

Flux Cored Arc Welding (FCAW) of weld joint CSD4-PP44-081 to 084 located on Segment Corner Assembly. Welder is identified as 066163. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Flux Cored Arc Welding (FCAW) of weld joint CA30-003 located on Segment Corner Assembly. Welder is identified as 066687. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Flux Cored Arc Welding (FCAW) of weld joint CSD4-PP46-093, 094, 089, 090, 085, 086 located on Segment Corner Assembly. Welder is identified as 066164. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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Flux Cored Arc Welding (FCAW) of weld joint CSD4-PP44-085, 086, 089, 090, 093, 094 located on Segment Corner Assembly. Welder is identified as 066163. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Flux Cored Arc Welding (FCAW) of weld joint CSD4-PP46-081 to 084 located on Segment Corner Assembly. Welder is identified as 066164. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of Complete Joint Penetration (CJP) welds previously tested and accepted by ZPMC Quality Control personnel. The weld designations are as follows:

Segment 2BW

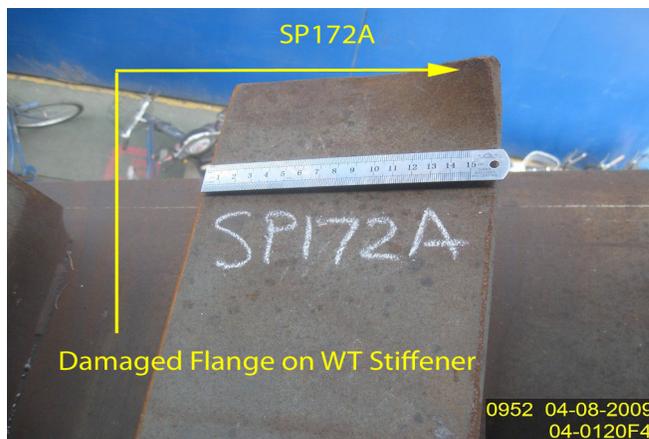
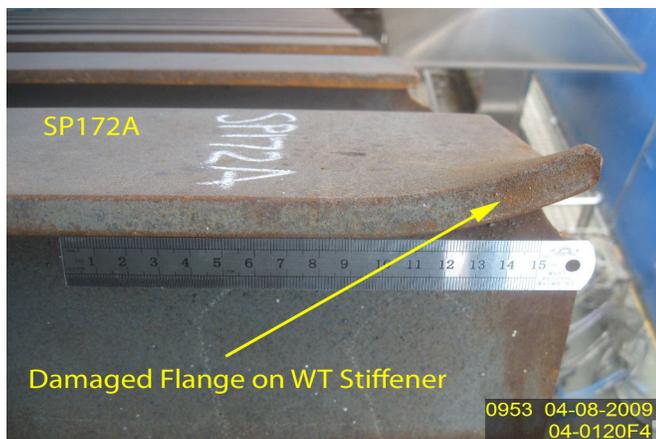
SEG009A-003, 002, 001, 009

SEG009-001, 002, 020, 003, 019

SEG009-007, 008, 023

This QA Inspector observed a bent Flange on a WT Stiffener on OBG Segment 2BW, Side Plate SP172A.

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



Summary of Conversations:

No relevant conversations.

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: Hernandez, Dan

Quality Assurance Inspector

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Reviewed By: Carreon,Albert

QA Reviewer