

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-008487**Date Inspected:** 04-Aug-2009**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:	Zhu Zheng Hai & Shen Fu You			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 Bay 13**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Rory O'Kane was present during the time noted above for observations relative to the work being performed.

OBG - BAY No. 13

Shielded Metal Arc Welding Process:

Welding of weld joint SEG047*-046 located on OBG Segment 8CW. Welder is identified as 067609. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-P-2214-TC-U4b-FCM-1.

Welding of weld joint SEG047B-SSD9A-PP71-004 located on OBG Segment 8CW. Welder is identified as 200432. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-P-2213-B-U2-F.

Outside - OBG Segments

During in process visual inspection of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector visually discovered a total of three (3) transverse linear indications that the ABF Magnetic Particle verification contractor "S.E.N.S.E." had discovered while doing verification testing. The ABF QA representative Mr. Mankit Lee was then verbally notified who explained that he was already aware of the indications. This QA

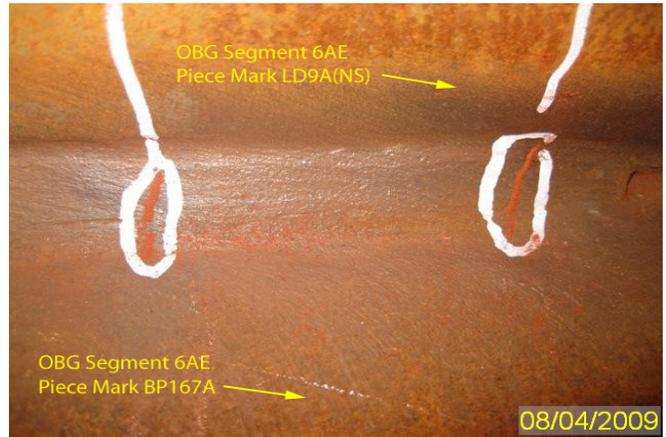
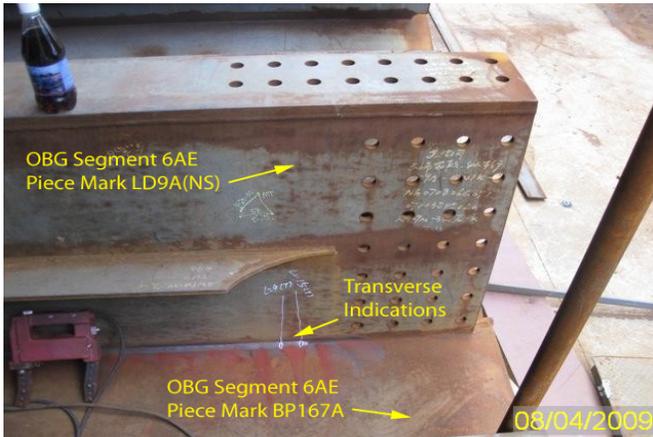
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inspector notified Mr. Lee that, as per the contract special provisions, ZPMC would need an approved critical weld repair procedure prior to repair.

See attached photos for details:

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



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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, who represents the Office of Structural Materials for your project.

Inspected By: O'Kane,Rory

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer
