

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-010311**Date Inspected:** 23-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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:** Chen 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 Components**Summary of Items Observed:**

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

BAY#14

FCAW welding of weld joint 1F-016 located on PCMK SP773-001 of 9DW welder is identified as 066401.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2131.

SMAW welding of weld joint 4F-013 located on PCMK SP772-001 of 9DW welder is identified as 066413.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM.

FCAW weld joint Fit-up of 10CW located on PCMK SEG063*-003 the dimension recorded by ZPMC QC Mr. Liu wan ning appeared to Comply with the WPS-B-T-2231-B-U2-F.

Ongoing heat straightening of Deck panel splice weld joint SEG051*-006 Flatness, temperature Checked with ZPMC QC Mr.Liu wan ning and the variables recorded as per report HSR1(B)7534.

SMAW welding of weld joint 4G-009 located on PCMK SEG051A of 9BW welder is identified as 051348.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the

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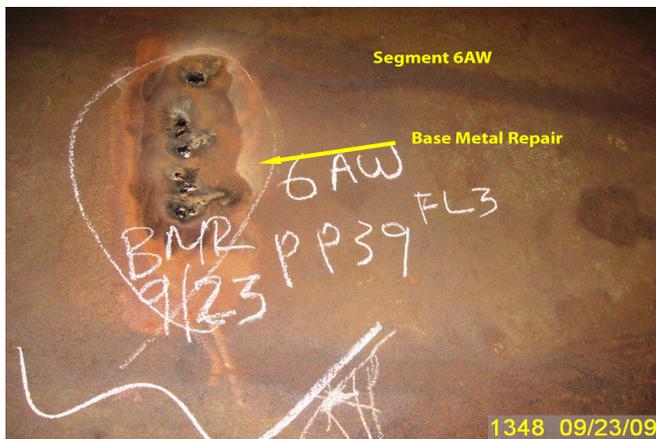
WPS-B-P-2214-Tc-U4b.

Backing bar used for Segment Lifting Leg fit up of 9AW, 9BW, 9CW ZPMC does not appear to have tracability for Backing bar they used. This is informed to ZPMC QC Mr. Li ming yang. See the attached photos.

Dimension of cope holes which is coming in FL3 and FL3 with bottom plate measured in segment 10CW, 10AW, 9BW it is found that all the locations the radius of cope hole is 25mm and 40mm instead of required 15mm and 25mm in drawings.

ZPMC is doing base metal repair in segment without any approval of engineer in the following locations in Segment 6AW FL3-PP39 and FL3-PP38.

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



Item	Description	WBS	Dwg No.	Status
1				
2				

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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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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