

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013361**Date Inspected:** 20-Jan-2010**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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhu Zhong Hai**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 7DW**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) - Document No's: 005086

This QA inspector performed MT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 7DW. The weld designations reviewed are as follows:

1. SSD11A-PP57-003
2. DP090-036, 041, 046, 049, 054, 057
3. DP117-001-047, 052, 057, 060, 065, 068, 073, 076
4. DP144-058, 063, 068, 071, 076, 079, 084, 087, 092, 095
5. DP171-058, 063, 068, 071, 076, 079, 084, 087, 092, 095
6. DP198-058, 063, 068, 071, 076, 079, 084, 087, 092, 095
7. DP225-058, 063, 068, 071, 076, 079, 084, 087, 092, 095
8. DP252-058, 063, 068, 071, 076, 079, 084, 087, 092, 095
9. DP117-002-047, 052, 057, 060, 065, 068, 073, 076
10. DP279-036, 041, 046, 049, 054, 057

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This QA inspector observed ZPMC qualified welding personnel identified as 062783 & 062765 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB008-044-001, 005. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062731 & 062763 perform FCAW welding on Suspender Bracket, weld joint identified as SB007-046-001, 005. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062788 & 062752 perform FCAW welding on Suspender Bracket, weld joint identified as SB007-044-001, 005. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

OUTSIDE YARD

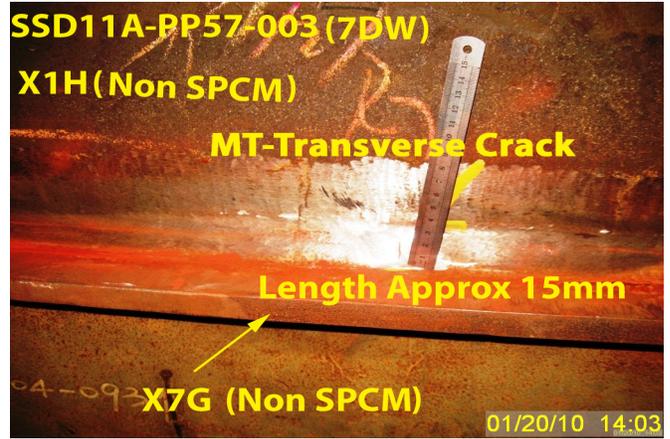
This QA inspector observed ZPMC qualified welding personnel identified as 058087 & 054013 perform Shielded Metal Arc Welding (SMAW) Welding on Segment 9CE; weld joint details identified as SP+BP temporary attachment repairs. ZPMC QC is identified as Mr. Wang Wei Ming & approved Welding Repair Report (WRR) is identified as WRR-B-WR9868. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G/4G (3F/4F).

Description of Incident: During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector (QA) discovered One (1) Transverse linear indication measuring approximately 15mm in length. ZPMC Quality Control MT Technicians claimed that magnetic particle testing have been performed on these welds that require 100% MT. The indication is clearly marked on the material near the weld. The weld is identified as SSD11A-PP57-003. This weld is a Complete Joint Penetration (CJP) and Weld joining the Deck Panel Diaphragm (X1H) to Floor Beam Flange (X7G). The Deck Panel Diaphragm (X1H) is identified as Non SPCM. & the Floor Beam Flange(X7G) is identified as Non SPCM. For further information, please see the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer