

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013818**Date Inspected:** 18-Jan-2010**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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**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 Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) Document: 005074

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. BP025-015-001~003

Bay 19

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 SB008-046-025, 031, 037, 043, 049, 055, 061, & 067. 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 SB008-044-025, 031, 037, 043, 049, 055, 061, & 067. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 SB007-044-025, 031, 037, 043, 049, 055, 061, & 067.. 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 054013 perform Shielded Metal Arc Welding (SMAW) Welding on Segment 9AE; 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-WR9867. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G/4G (3F/4F).

This QA inspector observed ZPMC qualified welding personnel identified as 049339 & 054013 perform SMAW Welding on Segment 9BE; weld joint details identified as SP+BP & CA temporary attachment repairs. ZPMC QC is identified as Mr. Wang Wei Ming & approved Welding Repair Report (WRR) is identified as WRR-B-WR9867. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G/4G (3F/4F).

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
