

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-013205**Date Inspected:** 18-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**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:	N/A	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.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE internal deck panel, floor beam and corner assembly surfaces from the panel point 67.5 to 69 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE. The whole segment exterior Bottom panel, side panel, deck panel carried out. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel

OUTSIDE SHOP

Segment 9DW

-This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange at East side

1)PP81-FB003-135 – 004.

-These welds were previously MT tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

-One location found some deep grinding marks of approximately 3mm deep, those location marked for future

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ZPMC repair and NDT.

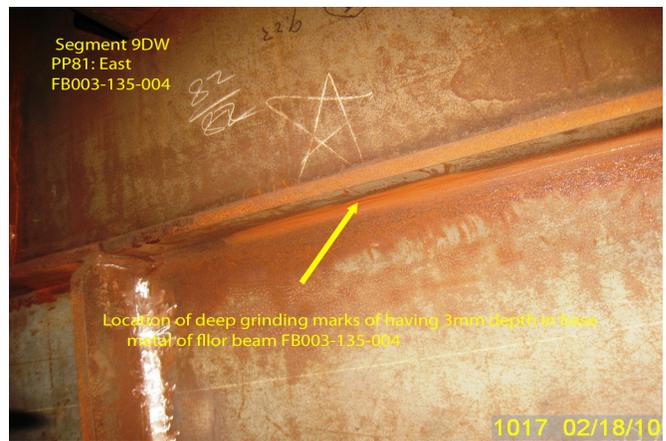
-Visually, these welds appeared to comply with the contract documents.

The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange

Segment 8AW

ABF Quality control (QC) personnel doing UT scanning pattern D as per contract documents on OBG corner assembly CA047 weld is identified as CA047-004 and SEG043*-047 which is connecting Deck plate to Edge plate.

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



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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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