

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-013365**Date Inspected:** 06-Feb-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. Tian Lei**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 9BE**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)

This QA inspector performed Visual Testing (VT) on OBG Segment and VT indications are confirmed by Magnetic Particle Testing on 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 9BE. The weld designations reviewed are as follows:

OBG Segment PP75 East side

1. FB012-023-002
2. FB003-133-005
3. FB024-006-093

Trial Assembly Area

This QA inspector observed ZPMC qualified welding personnel identified as 066361 Shielded Metal Arc Welding (SMAW) Welding on OBG Cross Beam CB6, weld joint identified as CB202-006-018. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in

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general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

Bay1

This QA inspector observed ZPMC qualified welding personnel identified as 219188 perform Flux Cored Arc Welding (FCAW) Welding on Traveler Rail, weld joint identified as 21TR4-001-007. ZPMC QC is identified as Mr. Tian Lei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 219188 perform FCAW Welding on Traveler Rail, weld joint identified as 21TR4-003-007. ZPMC QC is identified as Mr. Tian Lei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

Bay3

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-016-015. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044824 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-011-017. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

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
