

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012741**Date Inspected:** 15-Mar-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**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:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port

Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

In- Process Inspections:

Grinding of weld profile on section 7BW to 7CW Side Plate transverse splice, Counterweight side.

Grinding of weld profile on section 7AE to 7BE, Side Plate transverse splice, Crossbeam side.

Base metal weld repair of temporary attachment welds on section 7AE to 7BE Side Plate transverse splice, bike path side.

Grinding of weld profile on section 7AE to 7BE Bottom Plate transverse splice.

Back gouging of weld prep on the edge plate horizontal stiffeners, section 7AE to 7BE splice, Crossbeam side.

Welding of VT repairs on "T" stiffeners at the 7AE to 7BE transverse splice, bike path side. The weld procedure was identified as WPS- 345- SMAW- 4G(4F). The welder was identified as Niu Duo Jun, 037932.

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Welding of "T" stiffener splices in section 7BE to 7CE at EP79-028. The welder was identified as 048659. The welding procedure was identified as WPS- B-T-3213-B-U3b.

Welding of "T" stiffener splices in section 7BE to 7CE at EP80-014. The welder was identified as 220067. The welding procedure was identified as WPS- B-T-3213-B-U3b.

Welding of deck panel splices in section 7BE to 7CE at DP656-021. The welder was identified as 054467. The welding procedure was identified as WPS- B-T-3213-B-U3b.

Welding of deck panel splices in section 7BE to 7CE at DP664-021. The welder was identified as 037743. The welding procedure was identified as WPS- B-T-3213-B-U3b.

Back gouging of temporary attachments between U- ribs at the 7AE to 7BE splice.

Welding pursuant to weld repair B-WR 10620. The welder was identified as 045196. The welding procedure was identified as WPS- 345- SMAW- 4g(4F)- FCM- Repair- 1. ZPMC QC was identified as Zhong Yong Gang.

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

Summary of Conversations:

No Relevant 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
