

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013355**Date Inspected:** 04-Apr-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:** Zhou Cheng/Sun Bo**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#19

During random in process inspection of Bike Path, BK6A this QA inspector observed following issue. ZPMC personal performed carbon arc gouging of the parts of BK006A-001. According to fit up procedure ZPMC personal remove the weld of the interior diaphragm plates and longitudinal stiffeners from bike path. After removing the parts ZPMC personal performed grinding to make smooth surface. ZPMC personal will performed MT for surface cracks because of cutting the welds.

For further information, please see the attached pictures below.

Bay#19

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SB008-048-002, 003, 021, 022, 027, 028)

-(SB015-060-002, 003, 021, 022, 027, 028)

-(SB007-048-002, 003, 021, 022, 027, 028)

-(SB014-058-002, 003, 021, 022, 027, 028)

-(SB008-048-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060)

-(SB015-060-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060)

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-(SB007-048-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060)

-(SB014-058-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060)

-(SB008-048-069, 070)

-(SB015-060-069, 070)

-(SB007-048-069, 070)

-(SB014-058-069, 070)

Bay#8

FCAW welding of weld joint BK004A6-054-084, 085 located on BK004A. Welder is identified as 054060 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-063-125, 126 located on BK004A. Welder is identified as 054459 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-061-009, 010 located on BK004A. Welder is identified as 054459 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-063-063, 064 located on BK004A. Welder is identified as 500479 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-061-132, 133 located on BK004A. Welder is identified as 500479 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

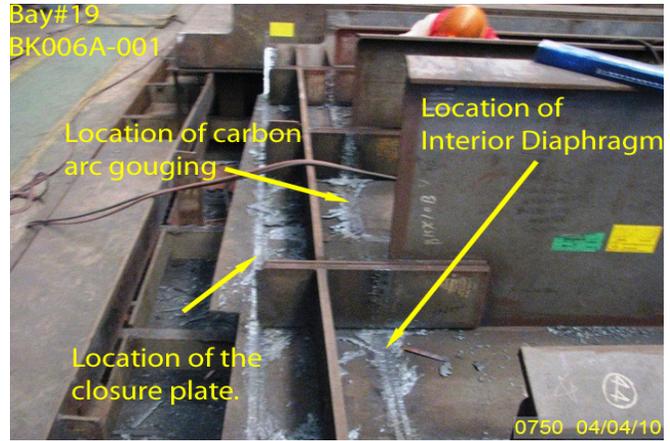
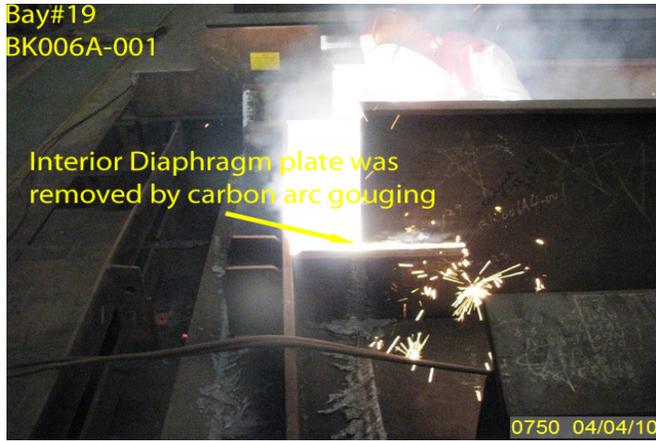
FCAW welding of weld joint BK004A7-058-150, 151, 075, 076 located on BK004A. Welder is identified as 054460 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-058-081, 082, 02, 022 located on BK004A. Welder is identified as 219414 (2F). ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

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

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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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
