

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-013413**Date Inspected:** 20-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:** Jhou 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 visual in process inspection of bike path, BK004A-002 and BK004A-005, this QA inspector observed that MT and UT inspection performed by ABFJV technician. MT and UT performed on the base metal repair locations and after heat straightening.

For further information, please see the attached pictures below.

Bay#19

FCAW welding of weld joint SB014-052-049, 055 located on SB052, lift 7&8. Welder is identified as 062749 (2G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

Bay#8

FCAW welding of weld joint BK004A6-058-112, 113 located on BK004A-058. Welder is identified as 210341 and 040785 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-058-210, 211 located on BK004A-058. Welder is identified as 210341 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with

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the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-058-117, 118 located on BK004A-058. Welder is identified as 500405 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-063-021, 022 located on BK004A-063. Welder is identified as 500479 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-063-074, 075 located on BK004A-063. Welder is identified as 040671 and 500479 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

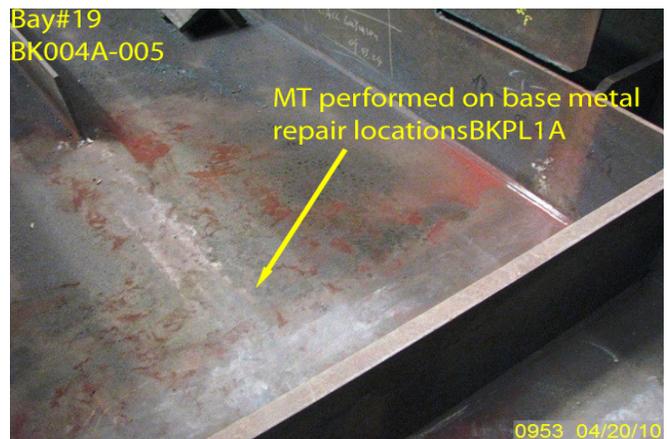
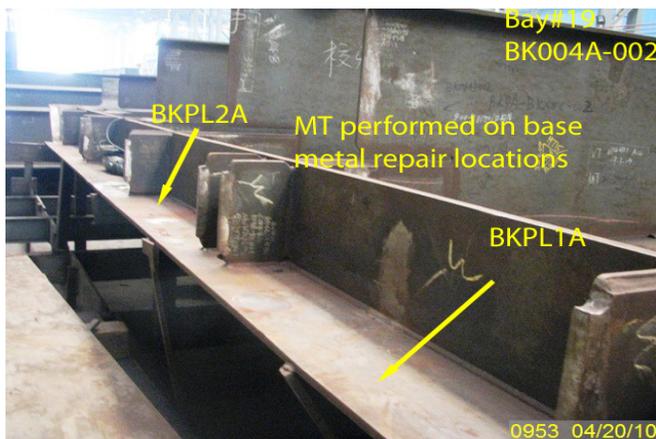
FCAW welding of weld joint BK004A7-063-150, 151 located on BK004A-063. Welder is identified as 500479 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-064-057, 058 located on BK004A-064. Welder is identified as 210341 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-064-112, 113 located on BK004A-064. Welder is identified as 500405 and 210341 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-064-210, 211 located on BK004A-064. Welder is identified as 500405 (2F). ZPMC QC is identified as Zhao Cheng Jian. 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
