

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-014649**Date Inspected:** 07-Jun-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**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 inprocess welding inspection of BK4A-008 and BK4A-010, this QA inspector observed that ZPMC welding personnel performed welding inspection in 3F position. The weld is connected the end diaphragm plates to stringer plate and end diaphragm plates to side plates. The size of fillet weld was observed 12mm in single pass. According to approved WPS maximum size of fillet weld for single pass is 9mm for 3F position. The affected fillet weld numbers are identified as BK004A8-010-015, 016, 019, 020, 021, 022 and BK004A8-008-049, 050, 051, 52, 022, 021, 015, 016

For further information, please see attached pictures. Please see incident report generated by B294 on this date.

Bay#19

FCAW welding of weld joint BK004A6-010-029, 030 located on BK004A-010. Welder is identified as 062788(2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-008-029, 030 located on BK004A-008. Welder is identified as 062761(2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-008-041, 042 located on BK004A-008. Welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

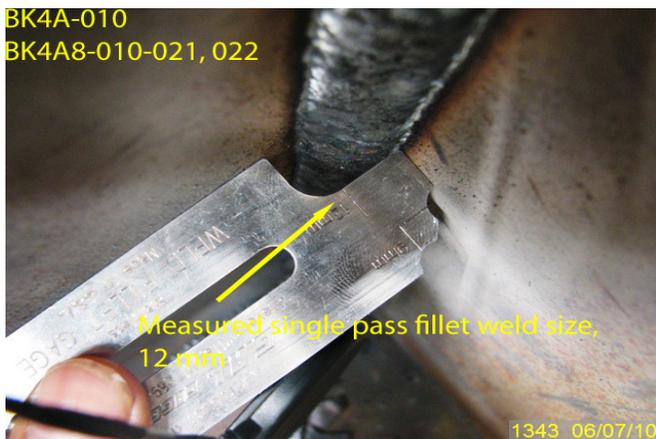
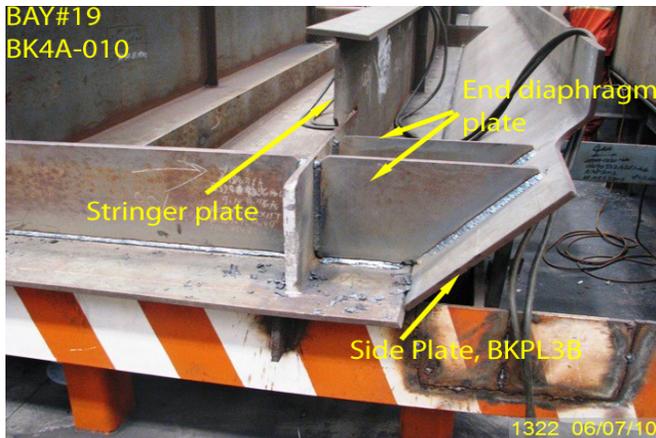
062761(2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-010-041, 042 located on BK004A-010. Welder is identified as 062788(2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-008-031~034 located on BK004A-008. Welder is identified as 062761(3F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

FCAW welding of weld joint BK004A6-010-031~034 located on BK004A-010. Welder is identified as 062757(3F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

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



Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------------	-------------