

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-015140**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:** Xu Tao**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AE side plate to stiffener, weld No. SP3059B-001-071. The welder is identified as #051356. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 13AW side plate to stiffener, weld No. SP3059B-001-085. The welder is identified as #044830. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #13

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AE bottom Plate , weld No. BP3031-001-001. The welder is identified as #055564. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U3-F.

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SAW in the 1G position for the OBG Segment 13AE bottom Plate , weld No. BP3032-001-005. The welder is identified as #207288. ZPMC QC is identified as Mr. Guo Pan . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Bay #16

This QA Inspector observed the following work in progress:

During in-process observations of the Bottom Plate BP3074-001 of segment 13AW being fabricated in bay 16, the Caltrans Quality Assurance Inspector (QA) observed that the root pass weld between two plate has cracked .The crack is approximately 600mm in length. The weld number is identified as BP3074-001-003. The QA Inspector inform to ZPMC QC Mr. Li Ming Yang to remove the indication and do magnetic particle testing for confirmation the metal is sound metal.

For details see the attached photo.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 10BW after repair.

The weld designation reviewed is as follows:

SEG061A-005

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 10CE after repair.

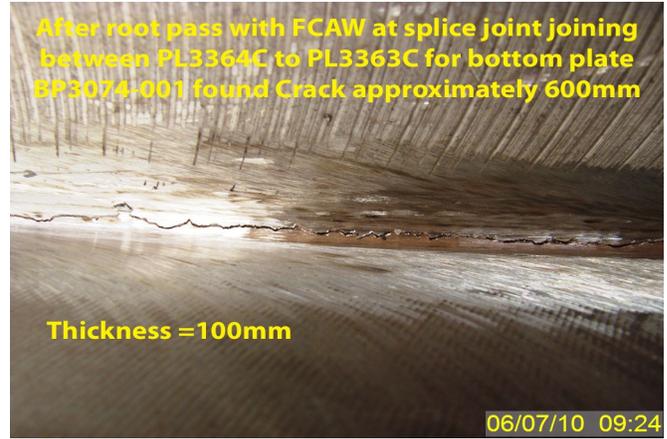
The weld designation reviewed is as follows:

SSD18A-PP94-108

Unless otherwise noted, all work 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: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer