

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015348**Date Inspected:** 03-Jul-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Segment**Summary of Items Observed:**

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

OBG Segment 11DE

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SSD17-PP105-014~031. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SSD17A-PP105-049~064. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 208939 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK004A6-004-088. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2334-Tc-P4-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 208641 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK004A8-004-088. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2334-Tc-P4-F. See the attached picture

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 062406 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE bottom plate, weld joint identified as BP3032-001-004. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AW bottom plate, weld joint identified as BP3074-001-004. ZPMC QC is identified as Mr. Tao Wei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer