

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-015576**Date Inspected:** 11-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Geng wei**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4F-006 located on PCMK OBW12C for Segment 12BW the welder is identified as 067609. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4G-002 located on PCMK SEG3006A for Segment 12CW the welder is identified as 067840. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of repair weld joint 4G-031 located on PCMK SEG3004AL for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1.

OUTSIDE SHOP

11CW

SMAW welding of weld joint 4F-020 located on PCMK OBW11E for Segment 11CW the welder is identified as 250113. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

with the WPS-B-P2114-FCM-1.

BAY#16

SAW welding of weld joint 1G-004 located on PCMK BP3074-001 for Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

ZPMC personnel performing their heat straightening of bottom plate splice for Lift 13 West is identified as BP3075-001-004 , appeared to comply with HSR-8164.

BAY#19

During random in-process observation of the fabrication of Bike path identified as BK004A-004, this Caltrans Quality Assurance Inspector (QA) discovered the following issue:

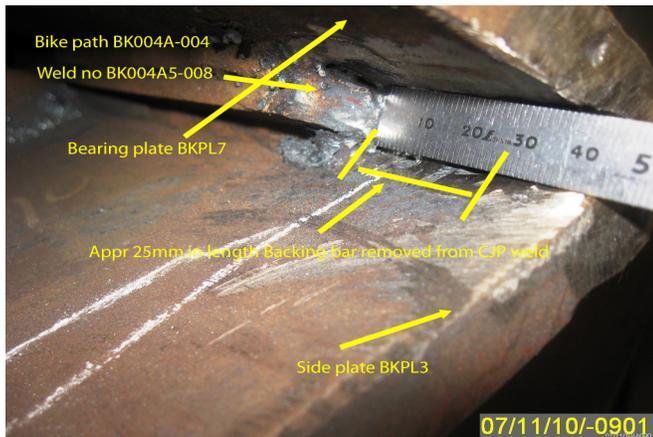
-ZPMC personnel have removed approximately 25mm in length of the steel backing bar without the engineer's approval.

-The welds are identified as BK004A5-008,002 and BK004A3-004-002,010.

For more information please see the Incident report ,

04-0120F4_TL-15_B247_07-11-10_Backling bar removed in CJP weld BK004A-004

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



Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon, Timothy	QA Reviewer
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