

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-015588**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) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 11CW

This QA inspector observed ZPMC qualified welding personnel identified as 066258 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11CW, weld joint identified as SEG069A-001. ZPMC QC is identified as Mr. Wu Shi Gao and Welding Repair Report (WRR) is identified as WRR-B-WR9859. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 200113 perform SMAW welding on drain plate of OBG Segment 11CW, weld joint identified OBW11E-020 and 021. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG Segment 12 BW

This QA inspector observed ZPMC qualified welding personnel identified as 045246 and 037723 perform SMAW welding on side plate to bottom plate weld of OBG Segment 12BW, weld joint identified as SEG3006A-002 and 008. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated

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instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067609 and 037743 perform SMAW welding on drain plate of OBG Segment 12BW, weld joint identified OBW12C-006 and 007. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044774 and 044830 perform Flux Cored Arc Welding (FCAW) welding on Side Plate of OBG Segment 13AW, weld joint identified as SP3102-001-089 to 096. ZPMC QC is identified as Mr. Guo Xing Hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 044795 and 044801 perform Flux Cored Arc Welding (FCAW) welding on Side Plate of OBG Segment 13AW, weld joint identified as SP3102-001-041 to 048. ZPMC QC is identified as Mr. Guo Xing Hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AW bottom plate, weld joint identified as BP3074-001-002. 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.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on OBG Segment 13BW Side plate, weld joint identified as SP3075-001-004. See the attached picture.

OBG Segment 11DE

This QA inspector observed ZPMC qualified welding personnel identified as 067589 perform SMAW Welding on OBG Segment 11DE, weld joint identified as SEG072-032. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 045268 perform SMAW welding on drain plate of OBG Segment 11DE, weld joint identified OBW11A-011 and 015. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

Visual Inspection after Blast

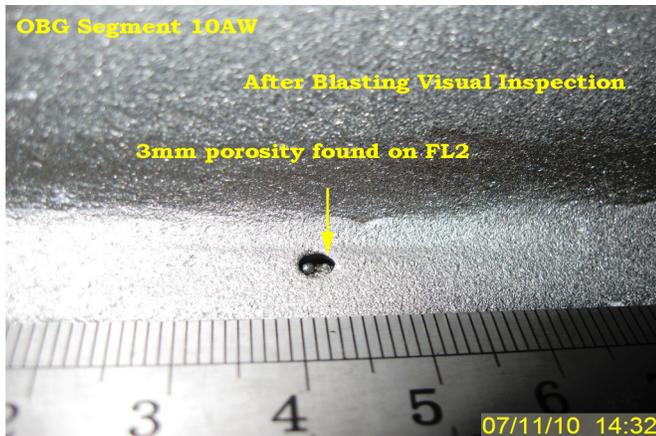
Segment 10AW

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This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

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
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