

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-016019**Date Inspected:** 31-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:** Geng wei / 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 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

FCAW welding of weld joint 1G-009 located on PCMK SEG3011A for Segment 13CE the welder is identified as 214945. ZPMC QC is identified as Mr. Zhong lin. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 1G-004 located on PCMK SEG3014A for Segment 13BW the welder is identified as 0201215. ZPMC QC is identified as Mr. Zhong lin. The welding variables recorded by QC appeared to Comply with the WPS-B-T2231-B-U2-F.

SAW welding of weld joint 1G-005 located on PCMK SEG3015A for Segment 13CW the welder is identified as 045270. ZPMC QC is identified as Mr. Zhong liu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

BAY#19

FCAW welding of weld joint 2F-006 located on PCMK SB020-084 for OBG SB84E the welder is identified as 062783. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

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ZPMC personnel performing Heat straightening of Suspender bracket is identified as SB90E
Weld no is identified as SB020-090-002,003,021,022,027,028,033 is according to approved
HSR1 (B)-7207 report.

OUTSIDE SHOP

SMAW welding of weld joint 3F-038 located on PCMK CA093 for Segment 11EE the welder is identified as
043661. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with
the WPS-B-T-4113-2.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10BW
Bottom panel, Side panel and Floor beam surfaces from the panel point 90 to 91 after grit blasting. Areas requiring
additional grinding were marked by QA and repaired by ZPMC personnel.

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.

Inspected By: Kumar, Chadra

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer