

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016182**Date Inspected:** 12-Aug-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:** Wang jie**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#19

FCAW welding of weld joint 2G-011 located on PCMK SB019-072 for OBG SB72E the welder is identified as 062807. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 1G-005 located on PCMK SB016-078 for OBG SB78W the welder is identified as 062757. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 1G-005 located on PCMK SB016-076 for OBG SB76W the welder is identified as 062755. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 2G-037 located on PCMK SB020-082 for OBG SB82E the welder is identified as 062808. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-037 located on PCMK SB019-078 for OBG SB78E the welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

062783. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path BK004A-012. The weld designations reviewed as follows.

BK004A3-012-025,026,051,052.

BK004A5-012-022,023.

BK004A6-012-013,015,019,021,022,029,030,059,053.

BK004A7-012-023,027,222,226,140,141,142,143,158,159.

BK004A8-012-021,022,031,032,115,116,029,030.

During MT of Bike path BK004A-012, it is observed that the 25mm center plate connecting end plate and stringer plate following fillet welds is identified as

BK004A6-012-013,015,019,059,053.

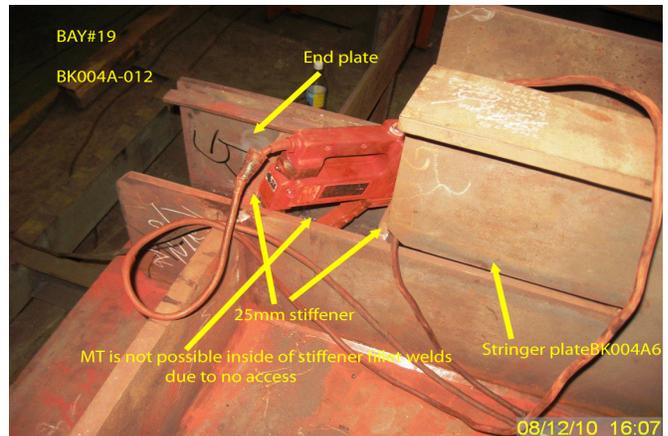
BK004A8-012-013,015,019,059,053.

Couldn't perform MT because of no access. For more information please see the attached photos.

BAY#14

ZPMC personnel performing Heat straightening of Segment 13AE bottom plate weld is identified as BP3032-001-001,003 is appeared to comply with HSR(B)-9004.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
Reviewed By:	McClendon,Timothy	QA Reviewer
