

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016195**Date Inspected:** 03-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. 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 Segments**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.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BW, weld joint identified as SEG3015A-005. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3015A-005. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform Flux Core Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3033-001-011, 010, 008 and 009. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed ZPMC qualified welding personnel identified as 201583 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3033-001- 006 and 007. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-084-006. ZPMC QC is identified as Mr. Li Ming Yang. 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 062761 perform FCAW Welding on Suspender Bracket, weld joint identified as SB016-072-008. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

OBG Segment 12CW

This QA inspector observed ZPMC qualified welding personnel identified as 066174 perform SMAW welding on OBG Segment 12CW, weld joint identified SEG3006*-056. 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-345-FCAW-4G (4F)-FCM-Repair.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing (MT) on OBG Segment 13BE Side plate, weld joint identified as SP3105A.

Visual Inspection Details: During random Quality Assurance Visual review of holes located on OBG Segment 13AW Bottom Plate, , this Quality Assurance Inspector (QA) discovered bottom plate 20 holes are damaged base metal, because of flame cutting; repair bottom plate is identified as BP3074. The weld repair holes are clearly marked on the material near the holes. The bottom plate is identified as SPCM. See the attached pictures

Visual Inspection after Blast

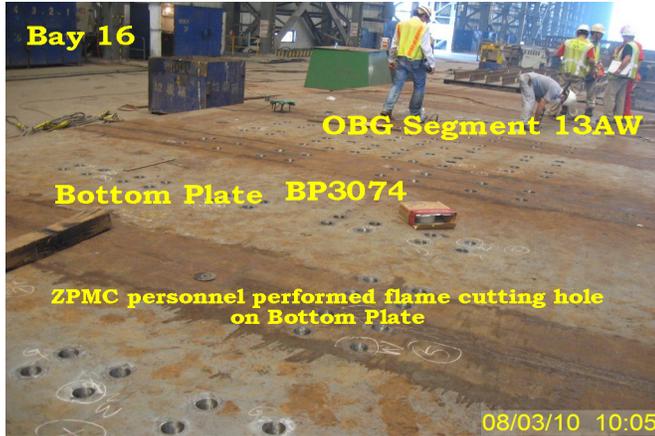
OBG Segment 10CW

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.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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

Reviewed By: McClendon,Timothy

QA Reviewer