

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-016196**Date Inspected:** 05-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 SEG3014A-004. 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. See the attached picture.

OBG Segment 12BW

This QA inspector observed ZPMC qualified welding personnel identified as 045227 perform FCAW welding on OBG Segment 12BW, weld joint identified SEG3005D-256. 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-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045133 perform SMAW Welding on OBG Segment 12BW, weld joint identified as SEG3005C-059 to 076. 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-T-2113.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed ZPMC qualified welding personnel identified as 067183 perform SMAW Welding on OBG Segment 12BW, weld joint identified as SEG3005H-022 to 029. 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-2112.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 664802 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 13AW bottom plate holes. Bottom plate 20 holes are damaged base metal, because of flame cutting; repair bottom plate is identified as BP3074. ZPMC QC is identified as Mr. Tao Wei and Critical Weld Repair Report (CWR) is identified as B-CWR1782. 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.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB016-074-006, 077. ZPMC QC is identified as Mr. Xu Tao. 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 062806 perform FCAW welding on Suspender Bracket, weld joint identified as SB019-076-043, 037, 055, 049. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062794 perform FCAW welding on Suspender Bracket, weld joint identified as SB020-080-043, 031, 055, 067. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Visual Inspection after Blast

Segment 10CW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 10CW PP092 to 94.4, 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.

Segment 10CE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 10CE PP092 to 94.4, after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.



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
