

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-016226**Date Inspected:** 10-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. 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 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.

Magnetic Particle Testing (MT) - Document No's: 006373

This QA inspector performed MT of approximately 15% of the area 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. The weld designations reviewed are as follows:

1. BK004A3-054-053, 054, 055
2. BK004A6-054-068, 069
3. BK004A7-054-111, 112, 113, 114
4. BK004A7-054-117, 118, 119, 120
5. BK004A4-054-042, 043, 044
6. BK004A6-054-074, 075
7. BK004A7-054-075, 076, 077, 078
8. BK004A7-054-081, 082, 083, 084

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SAW) Welding on OBG Segment 13CW, weld joint identified as SEG3015A-006. ZPMC QC is identified as Mr. Guo Xing Hui. 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 058100 perform SAW Welding on OBG Segment 13CE, weld joint identified as SEG3011A-010. ZPMC QC is identified as Mr. Guo Xing Hui. 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 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BW, weld joint identified as SEG3014A-003. ZPMC QC is identified as Mr. Guo Xing Hui. 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 040801 perform Flux Core Arc Welding (FCAW) Welding on Side Plate of OBG Segment 13CE, weld joint identified as SP3080-001-074~081. 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-F.

This QA inspector observed ZPMC qualified welding personnel identified as 040801 perform FCAW Welding on Side Plate of OBG Segment 13CE, weld joint identified as SP3080-001-074~027. 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-2232-Tc-U4b-F.

During random Quality Assurance Visual review of holes located on OBG Segment 13AE Bottom Plate, this Quality Assurance Inspector (QA) observed ZPMC personnel performed Ultrasonic Testing (UT) on Bottom Plate hole, the bottom plate is identified as BP3032A. See the attached pictures

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045204 perform Flux Core Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001-008, 032. 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-P-2211-B-U2.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, weld joint identified as SB016-074-025, 031. 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 062782 perform FCAW Welding on Suspender Bracket, weld joint identified as SB019-078-011, 018. ZPMC QC is identified as Mr. Li Ming Yang.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 062808 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-082-077. 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-2232-Tc-U4b-F.

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
