

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-016432**Date Inspected:** 22-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:** Wu shi gao / 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#19

FCAW welding of repair weld joint 1G-004 located on PCMK SB019-078 of SB78E 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-345-FCAW-1G (1F)-Repair.

FCAW welding of repair weld joint 2G-018 located on PCMK SB019-074 of SB74E the welder is identified as 062761. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-Repair.

FCAW welding of repair weld joint 2G-067 located on PCMK SB019-072 of SB72E the welder is identified as 062807. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-Repair.

FCAW welding of repair weld joint 2G-011 located on PCMK SB020-082 of SB82E the welder is identified as 062808. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-Repair.

Following suspender brackets green tags has been issued after NDT carried out satisfactorily

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The suspender bracket is identified as
SB92W-12282.
SB90W-12283.
SB90E-12289.

OUTSIDE SHOP

11DE

During random in-process observation of the Weld Repair (WR) in Segment 11DE, this Caltrans Quality Assurance Inspector (QA) discovered the following issue:

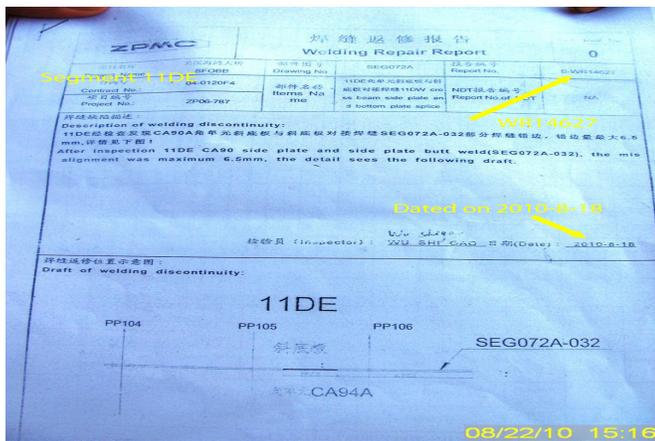
ZPMC personnel have performed critical repairs at two areas of a Seismic Performance Critical Member (SPCM) weld without the Engineers approval.

-ZPMC personnel removed and re-welded two areas of SPCM weld joint identified as SEG072A-032.

For more information please see the Incident report

04-0120F4_TL-15_B247_08-22-10_11DE__removed_spcm_cjp_weld_without_Engineer_approval.

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



Summary of Conversations:

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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
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