

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-005597**Date Inspected:** 11-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Luan Zhao Gang**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 Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (South of the paint shop)

Segment 4AW

This QA Inspector observed the following work in progress:

Preproduction testing of stud welds for the bike path counter weight. The welder was qualified in accordance with AWS D1.5/2002 section 7.7.4.1. (See attached Photo)

Flux Cored Arc Welding (FCAW) in the 2G position of the lifting lug vertical side plates at panel point 22. The welder is identified as #058551. The weld designation is SSD18-PP22-241. ZPMC QC is identified as Mr. Luan Zhao Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-TC-U4b-F.

Shielded Metal Arc Welding (SMAW) in the 4G position of side plate to side plate splice weld previously rejected by (UT). The welder is identified as #066413. The weld designation is SEG17A-009. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with WPS-345-4G(4F)-FCM-Repair.

Shielded Metal Arc Welding (SMAW) in the 4G position of side plate to bottom plate splice weld previously rejected by (UT). The welder is identified as #067571. The weld designation is SEG17*-020. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with WPS-345-4G(4F)-FCM-Repair.

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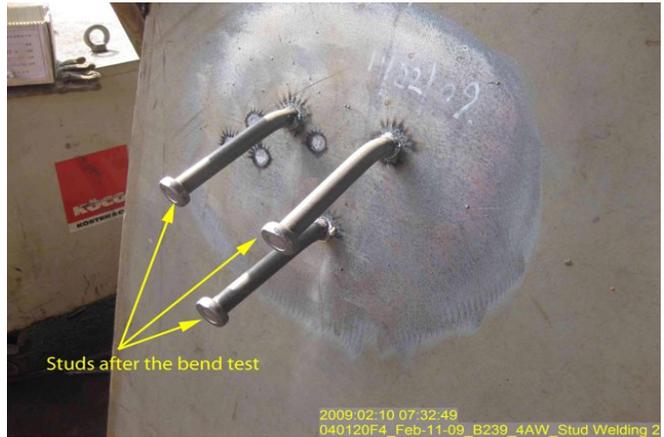
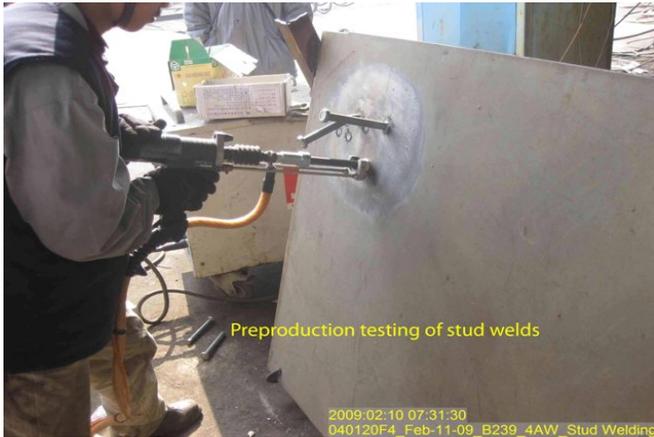
This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck plate sub assembly weld splices. The Weld Designations are as follows: SEG17*-001, SEG17*-002, SEG17*-003, SEG17*-004, SEG17*-005, and SEG17*-006.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the bottom and side plate sub assembly weld splices. The Weld Designations are as follows: SEG17A-002, SEG17A-003, SEG17A-004 and SEG17A-006.

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

Summary of Conversations:

No Relevant conversations



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, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
