

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-008452**Date Inspected:** 09-Jul-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:** Li Zhi Jiang**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

BAY#14

This QA inspector performed UT and MT of base metal on segment 1AAW, temporary attachment removal area previously tested and accepted by ZPMC Quality Control personnel at location A00. The member is identified as edge Plates.

BAY#2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(Seg2F-003, 004, 045, 046, 043, 044)

-(Seg2F-024, 025)

Bay #2

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 member is identified as OBG components. The weld designations reviewed are as follows:

-(Seg2F-024, 025)

BAY#14

This QA inspector witnessed grouting at locations A13, A14, A16, A17, A18, A20, A24 on segment 1AAW.

WELDING INSPECTION REPORT

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This QA inspector observed the following work in progress:

Bay#2

SMAW welding on segment 1AAE weld joint Seg2-001. Welder is identified as 045196 and 047864 (4G/4F), grade 485+ grades 345. ZPMC QC-CWI is identified as Xiang Feng Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg2A-017, 018, 019 located on Segment 1AAE. Welder is identified as 045268 (3G). ZPMC QC-CWI is identified as Li Zhi Jiang . The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg2B-019, 020, 021 located on Segment 1AAE. Welder is identified as 045268 (3G). ZPMC QC-CWI is identified as Li Zhi Jiang . The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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