

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-009575**Date Inspected:** 04-Oct-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:** Shen Fu You**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.

Super structure

This QA inspector performed UT (after repair, Scanning Pattern "D") together with ABF UT Personals, 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:

-(OBE1A-003, 004)

Segment 11CE

FCAW welding of weld joint Seg070A-004 located on Segment 11CE. Welder is identified as 055564 (1G). ZPMC QC is identified as Tang Yu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

SAW welding of weld joint Seg070A-007 located on Segment 11CE. Welder is identified as 044780 (1G). ZPMC QC is identified as Tang Yu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-BL2c-S-2.

Segment 10CW

FCAW welding of weld joint Seg063A-020 located on Segment 10CW. Welder is identified as 066401 (1G).

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ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

Segment 10AW

SMAW welding of weld joint Seg059A-015, 007, 011 located on Segment 10AW. Welder is identified as 051348, 058242, and 045246 (4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

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:	Patterson,Rodney	QA Reviewer
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