

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-010315**Date Inspected:** 19-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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:** Shen fu you / Lv Lvqiang**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#14

SMAW welding of weld joint 4F-150 located on PCMK SP676-001 of 10AW welder is identified as 067610. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-FCM-1.

FCAW welding of weld joint 2G-031 located on PCMK SEG055B of 9DW welder is identified as 202122.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 1G-034 located on PCMK SEG051* of 9BW welder is identified as 066673.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

SMAW welding of weld joint 3G-036 located on PCMK SEG056D of 9DE welder is identified as 215553.ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b-2.

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FCAW welding of weld joint 3F-208 located on PCMK SSD29-PP91.5 of 9DW welder is identified as 214945. ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

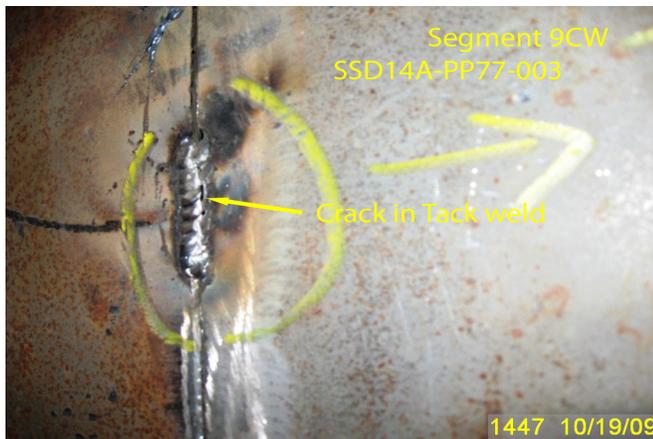
SAW welding of weld joint 1G-006 located on PCMK SEG068* of 11BE welder is identified as 044771. ZPMC QC is identified as Mr. Zhang xian ji. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

During random visual inspection it is found that Segment 9CW Crack in tack weld of weld Joint fit up is identified as SSD14A-PP77-003. This is informed to ZPMC QC MR.Li ming yang. He agreed and told ZPMC will remove that tack weld and perform MT on that location before Fit up.

BAY#13

SMAW welding of repair weld joint 4G-031 located on PCMK SEG068A of 11BE welder is identified as 200113. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-repair-1.

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



Summary of Conversations:

As per 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By: Kumar, Chadra

Quality Assurance Inspector

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Reviewed By: Patterson,Rodney

QA Reviewer