

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-011592**Date Inspected:** 19-Jan-2010**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:** Liu Hua Jei**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.

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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:

-(Seg071A-031)

-(Seg073A-004, 007)

Segment9CE

Base metal repair by SMAW welding of weld with WRR# B-WR9868 on segment 9CE located on in front of blast shop. Welder is identified as 058087 and 054013 (3G and 4G). ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS and the base metal designation as below.

-WPS-345-SMAW-3G/3F-Repair.

-WPS-345-SMAW-4G/4F-Repair.

-WPS-345-SMAW-3G/3F-FCM-Repair.

-WPS-345-SMAW-4G/4F-FCM-Repair.

Components are

-SP545A, SP585A, SP625A, SP374A, SP347A and SP320.

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-BP180A, BP72A and BP126A.

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FCAW welding of weld joint SSD12-PP106-133 located on Segment 11DW. Welder is identified as 202122 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint SSD12A-PP106-014 located on Segment 11DW. Welder is identified as 201215 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint SSD12A-PP106-010 located on Segment 11DW. Welder is identified as 202122 (1G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SSD12-PP106-129, 008 located on Segment 11DW. Welder is identified as 202122 (1G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SSD12-PP106-108 located on Segment 11DW. Welder is identified as 202122 (2G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD12A-PP106-091 located on Segment 11DW. Welder is identified as 201215 (2G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD12A-PP106-008, 009 located on Segment 11DW. Welder is identified as 201215 (3F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

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.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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