

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-011628**Date Inspected:** 14-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:** Li Yan Hua**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 9CW, weld No.CA061-007. The welder is identified as #045196. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b.

SMAW in the 2F position for the OBG Segment 9CW, weld No.CA061-008. The welder is identified as #050433. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112.

FCAW in the 2F position for the OBG Segment 9EW, weld No.SSD13-PP83-21. The welder is identified as #204730. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

SMAW in the 3G position for the OBG Segment 9DW UT repair area, weld No.SSD11A-PP081-182. The welder

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is identified as #045138. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1.

Bay#19

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Cross Beam bottom plate to stiffener, weld No.BP-025-012-015. The welder is identified as #062746. ZPMC QC is identified as Mr. Zhon Cheng. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM.

Witness of Ultrasonic Testing (UT)

This QA Inspector performed witness of Ultrasonic testing (UT) for 'D' scanning which was performed by ZPMC UT technician. The member is identified as OBG Segment 9AW.

The Weld Designation is as follows

SEG49A-001

Witness Magnetic Particle Testing(MPT)

This Quality Insurance Inspector (QA) performed witness of Magnetic Particle Testing (MT) for OBG Cross beam CB16 welds area which was performed by ZPMC MT technician Mr.Xu Hua Xiang .The QA Inspector observed that the ZPMC technician found one transverse liner indication in length approximate 10mm.

The weld designation is as follows:

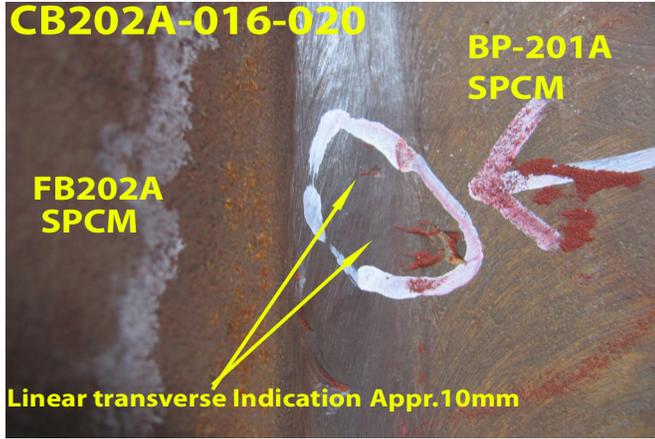
CB202A-016-020

For more details please see the attached photo.

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

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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:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
