

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-013207**Date Inspected:** 27-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** Geng wei**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#19

SMAW welding of weld joint 2F-026,032 located on PCMK SB007-042 of Lift 8 welder is identified as 062811. ZPMC QC is identified as Mr. Chen zhong. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2112.

Ongoing Heat straightening of cross beam bottom plate is identified as BP025-001 to 023,44 to 53 was carried out, temperature and straightening was measured and recorded by ZPMC QC Mr.Cheng zhong to comply with the HSR1(B)-8008.

BAY#14

SAW welding of weld joint 1G-008 located on PCMK SEG3002* of 12BE welder is identified as 044771. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

OUTSIDE SHOP

Ongoing SMAW welding of repair weld joint 1G-032 located on PCMK SEG051A of Segment 9BW welder is

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

identified as 067752. ZPMC QC is identified as Mr. Wang wei ming . The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-FCM-Repair and B-WR10634.

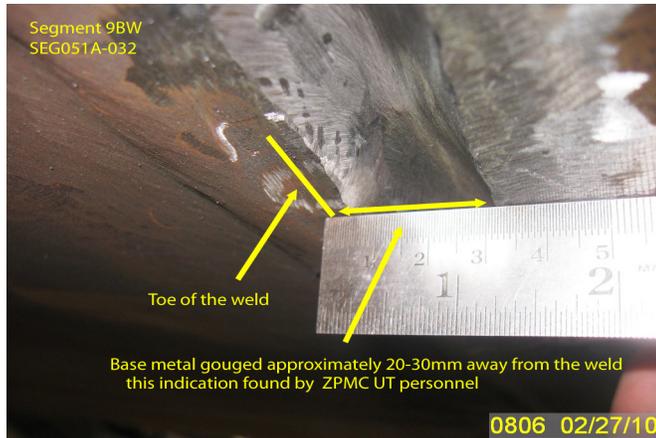
While performing repair welding of weld joint 4G-032 located on PCMK SEG051A of segment 9BW ZPMC gouged on the parent metal at 3 locations which is 20 to 30mm away from the weld and 10-14mm depth and length 100-150mm respectively. ZPMC QC Mr. Wang wei ming said at the following locations ZPMC QC UT personnel found indications. This issue were discussed with ABF QA Mr. Liaho. He agreed and asked ZPMC to issue Critical weld repair report(CWR). ZPMC will not start the repair work until approval has been given by CT engineer's.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant 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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon, Timothy	QA Reviewer
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