

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-013213**Date Inspected:** 07-Mar-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:** Liu hua ji**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 4G-046 located on PCMK SEG072* of 11DE welder is identified as 044772.ZPMC QC is identified as Mr.Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 4G-009,011 located on PCMK SEG3006A of 12CW welder is identified as 047869, 037723.ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint 3F-199,196 located on PCMK CA3009C of 12BW welder is identified as 045175. ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 1G-010 located on PCMK SEG3004A of 12AW 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-2231-B-U2-F.

During in process visual inspection it is found that X37 bracket plate CA56, SEG55D,CA74 of segment 9AW,

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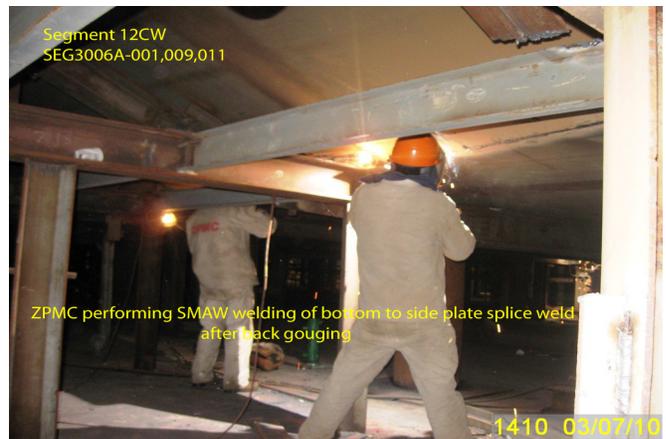
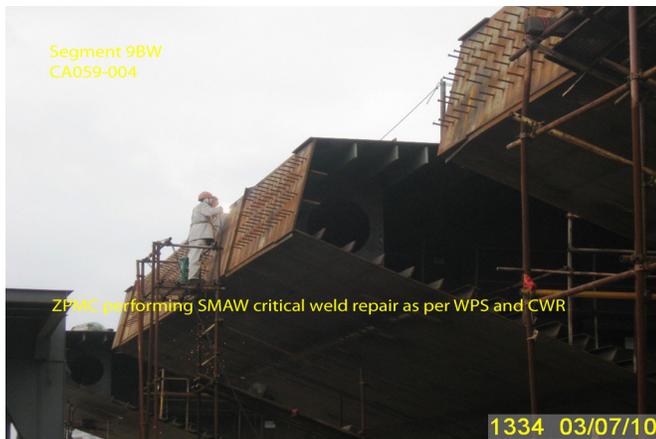
10BW and 9DW.ZPMC forgot to make machine cut on that. This is informed to ZPMC QC Mr.Li ming yang. He agreed and said ZPMC will do free hand cut in this location, but the free hand length will be approximately 300mm.

OUTSIDE SHOP

SMAW critical weld repair welding of weld joint 2G-047 located on PCMK SEG057* of 9BE welder is identified as 054013.ZPMC QC is identified as Mr.wang wei ming . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-repair-1 And approved B-CWR1202.

SMAW critical weld repair welding of weld joint 2G-004 located on PCMK CA057 of 9AE welder is identified as 048661.ZPMC QC is identified as Mr.wang wei ming . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-repair-1 And approved B-CWR1198.

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



Summary of Conversations:

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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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