

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013219**Date Inspected:** 09-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:** Zhou Cheng**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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FCAW welding of weld joint SB023-106-011, 012, 021, 022 located on SB023-106. Welder is identified as 062755 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

FCAW welding of weld joint SB023-104-011, 012, 021, 022 located on SB023-104. Welder is identified as 062788 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

FCAW welding of weld joint SB022-104-011, 012, 021, 022 located on SB022-104. Welder is identified as 062783 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

Bay#19

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SB008-038-049, 061, 037, 005, 007, 004, 018, 001, 008, 025, 077)

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-(BP025-011-004, 005, 006, 007, 008, 009, 010,011, 012, 013)

-(BP025-011-044, 045, 046, 047, 048, 049)

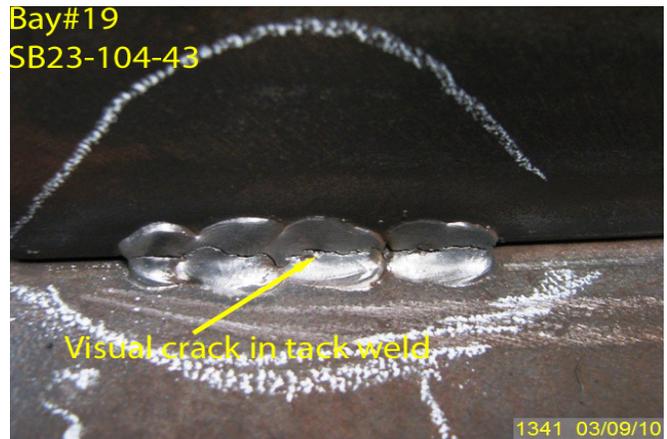
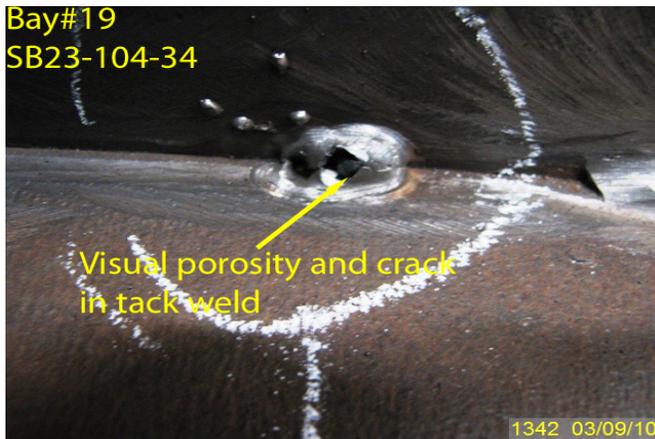
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During random in process inspection of Bike Path, BK4A-004, this QA inspector observed that ZPMC personal doing fit up of Anchor house horizontal plate. Horizontal anchor house plate tacked with vertical anchor house plates and 25mm center plate. The plate fit up performed at location E-E and C-C, according to drawings. For further information, please see the attached pictures below.

During random in process visual inspection of Suspender brackets SB023-104 and 106; this QA inspector observed visual cracks and porosity in tack weld. ZPMC personal has to remove defective tack weld and verify joint fit up before final welding.

For further information, please see the attached pictures below.

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



Summary of Conversations:

No relevant conversations.

Comments

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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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
