

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-013342**Date Inspected:** 20-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/Zhu Zhong Hai**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.

Bay#19

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed that ZPMC personal fit up the bearing plate to stringer plates. According to fit up procedure, the anchor house plate and pipe installed first and bearing plate installed on anchor house plate. ZPMC personal is installing bearing plate without installed anchor house plate and pipe. For further information, please see the attached pictures below.

Bay#19

During random in process inspection of Bike Path, BK4A-004, this QA inspector observed following issue. ZPMC performed buttering of all vertical members by SMAW welding process. According to shop drawings the closure plate is tight fit with all the vertical members. After removing the parts by carbon arc gouging the edge of vertical members are not finished for tight fit joint. ZPMC QC will submit welding repair report for 5 mm weld buttering on the edge of vertical members.

The Welder is identified as 062772 (3G). ZPMC QC is identified as Zhon Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-Repair.

For further information, please see the attached pictures below.

Bay#14

SMAW welding of weld joint Seg3005H-007 located on Segment 12BW. Welder is identified as 045246 (4G).

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ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg3005H-014 located on Segment 12BW. Welder is identified as 047864 (4G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg3005J-017 located on Segment 12BW. Welder is identified as 047864 (4G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg071A-026 located on Segment 11DW. Welder is identified as 066258 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

SMAW welding of weld joint Seg071A-016 located on Segment 11DW. Welder is identified as 045246 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

SMAW welding of weld joint Seg071A-009 located on Segment 11DW. Welder is identified as 066326 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

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:	McClendon, Timothy	QA Reviewer
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