

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-013348**Date Inspected:** 28-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/Sun			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-002 and BK004A-005, this QA inspector observed that ZPMC personal performed heat straightening on BKPL1A and BKPL2A west side. After removing the X11 and closure plate, BKPL8 by carbon arc gouging, BKPL1A and BKPL2A distorted up to 4mm. These plates are non SPCM, according to approved drawings.

For further information, please see the attached pictures below.

Bay#19

During random in process inspection of Bike Path, BK4A-002, this QA inspector observed that ZPMC performed base metal repair on BKPL1A and BKPL2A. This base metal repair performed by SMAW welding process, after removing the BKPL8- Closure plate, BKX7P- Stiffener and BKX11E~G / BKX11EA~GA- Interior diaphragm plate by carbon arc gouging. The depth of excavation is measured as 2~3mm.

For further information, please see the attached pictures below.

Bay#8

During random in process inspection of bike path BK004A, this QA inspector observed that ZPMC personal performed joint fit up of X7F stiffeners to stringer plates and X7L stiffeners to stringers by FCAW and SMAW welding process. This QA inspector verified joint fit up and found within limit. Welder is identified as:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW-210341(2F)- WPS-B-T-2132

SMAW-054015(2F)- WPS-B-P-2112

ZPMC QC is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS.

For further information, please see the attached pictures below.

Bay#14

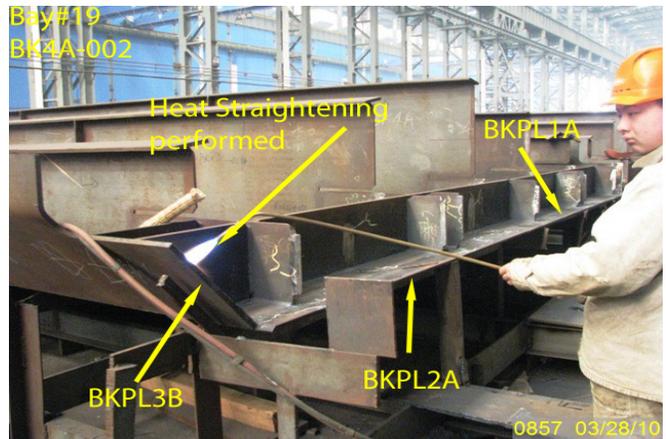
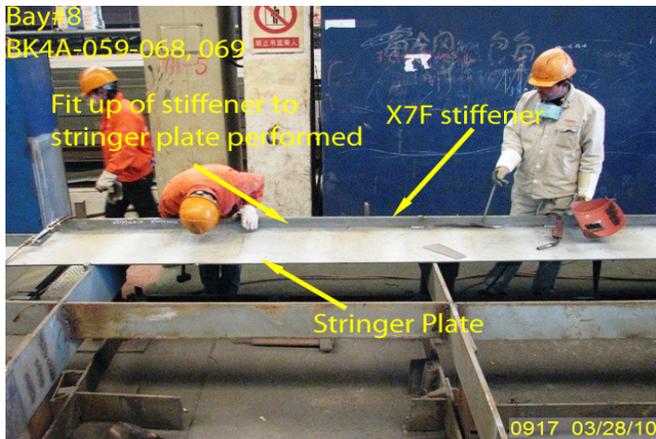
SMAW welding of weld joint CA3009-004 located on Segment 12BW. Welder is identified as 067764, 051348, and 066002 (2G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

SMAW welding of weld joint CA3006-004 located on Segment 12AW. Welder is identified as 067764, 051348, and 066002 (2G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

Seg9BE

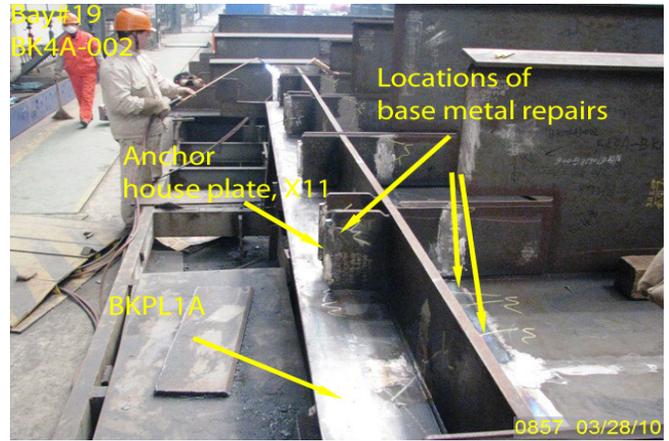
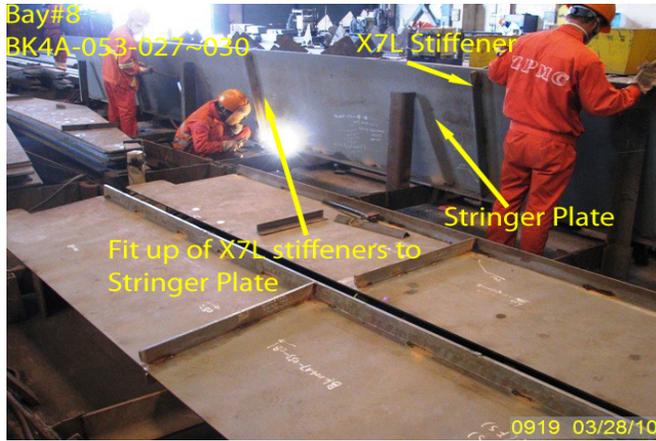
SMAW welding of weld joint Seg52E-43, 44, 75, 76, 129, 130, 120, 121 located on Segment 9BE. Welder is identified as 043661 (4F). ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

Unless otherwise noted, all 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 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: Patel, Hiranch

Quality Assurance Inspector

Reviewed By: McClendon, Timothy

QA Reviewer