

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-013352**Date Inspected:** 31-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/Liu Hua Jie**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.

Segment 9AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the deck panel, floor beams, bottom panel, side panel and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Bay#19

During random in process inspection of bike path BK004A-002, this QA inspector observed that ZPMC personal performing base metal repair. Base metal repair was performed by SMAW welding process. After removing the closure plate, interior diaphragm and horizontal stiffeners from plates, BKPL1A and BKPL2A by carbon arc gouging, ZPMC personal performed MT inspection and found indications. That locations requires a base metal repair. The plate numbers and weld repair reports (WRR) are identified as:

BKPL1A and BKPL2A- WRR# B-WR11259

Welder is identified as 062811 (1G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

For further information, please see the attached pictures below.

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Bay#16

This QA inspector performed VT of the cat walk hand rails, previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The cat walk railings are identified as follows:

Drawing# Type1-CATW- 58 quantity

Drawing# Type4-CATW- 15 quantity

Drawing# Type7-CATW- 09quantity

Bay#14

SAW welding of weld joint Seg3004*-004, 022 located on Seg12AW. Welder is identified as 045265 (1G). ZPMC QC is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

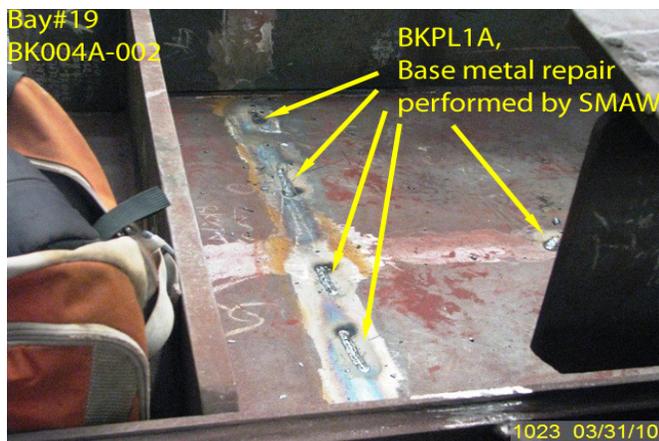
FCAW welding of weld joint Seg3006G-018 located on Seg12CW. Welder is identified as 204730 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint Seg3006E-018 located on Seg12CW. Welder is identified as 204730 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint SP3037B-001-091~096 located on Seg12AW. Welder is identified as 045246 (3G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

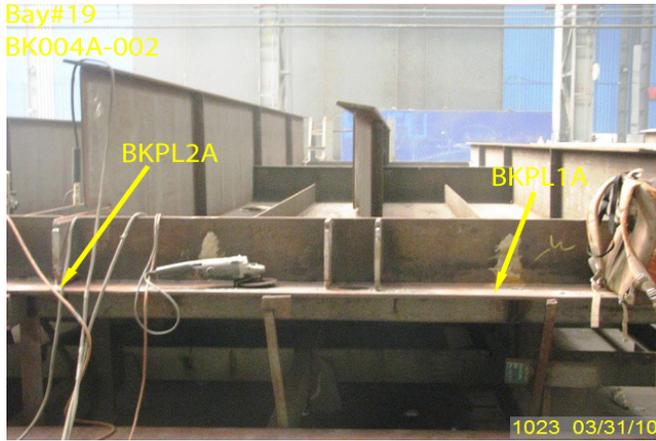
SMAW welding of weld joint SP3035B-001-065~071 located on Seg12AW. Welder is identified as 067764 (3G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

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



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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
