

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-013358**Date Inspected:** 09-Apr-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:** Sun Bo**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#6

During random in process visual inspection of west jacket frame, this QA inspector discovered following issues.

Total three (3) cracks in tack weld measuring approximately 25~50mm in length.

The weld is identified as WJF-0-107 and WJF-0-109.

ZPMC QC personnel will remove the crack tack and will perform MT inspection prior to welding.

For further information, please see the attached pictures below.

Bay#14

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:

-(CA3010E-287, 288, 279, 280, 265, 266)

-(CA3010D-295, 296, 277, 278, 288)

-(CA3010C-281, 282, 237, 238)

-(CA3007D-037, 038, 135, 136, 163, 164)

-(CA3010D-037, 038)

-(CA3010E-095, 096, 103, 104)

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Bay#8

SAW welding of weld joint BK004A1-056-009 located on BK004A-056. Welder is identified as 040831 (1G). ZPMC QC is identified as Sun Yan Fei. 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 BK004A6-059-094, 095 located on BK004A-059. Welder is identified as 500405 and 210341 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

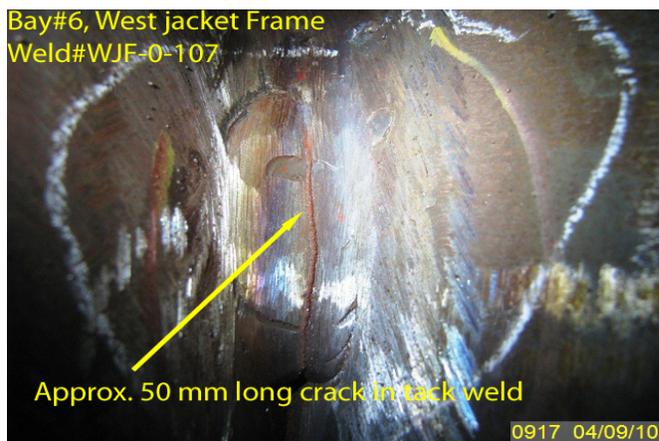
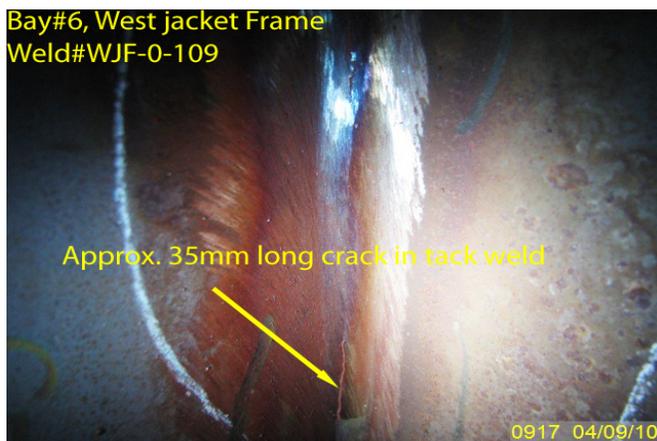
FCAW welding of weld joint BK004A7-059-186, 187 located on BK004A-059. Welder is identified as 500405 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-059-099, 100 located on BK004A-059. Welder is identified as 210341 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-058-188, 189 located on BK004A-058. Welder is identified as 500405 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

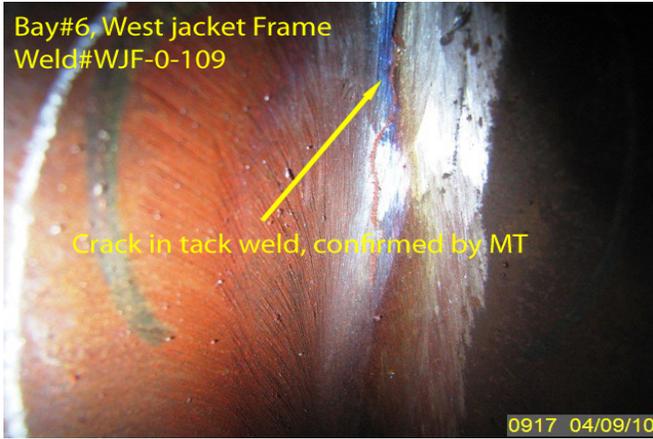
FCAW welding of weld joint BK004A7-060-099, 100 located on BK004A-060. Welder is identified as 040785 (2F). ZPMC QC is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

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
