

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013376**Date Inspected:** 04-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. 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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

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This QA inspector observed ZPMC qualified welding personnel identified as 062814 perform Shielded Metal Arc Welding (SMAW) Welding on CB Bottom Plate, weld joint identified as BP026-014-053 and 054. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2212-B-U2-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 062808 perform Flux Cored Arc Welding (FCAW) Welding on CB Bottom Plate, weld joint identified as BP026-014-044~052. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062772 perform SMAW Welding on Suspender Bracket, repair weld joint detail identified as SB007-044-004, 005 and 061. ZPMC QC is identified as Mr. Zhou Cheng. The welding repair reports (WRR) are identified as B-WR108-26, 27 and 25. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair.

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This QA inspector observed ZPMC qualified welding personnel identified as 062814 perform SMAW Welding on Suspender Bracket, repair weld joint detail identified as SB009-042-005, 007 and 055. ZPMC QC is identified as Mr. Zhou Cheng. The welding repair reports (WRR) are identified as B-WR108-28, 30 and 29. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 062808 perform FCAW Welding on Suspender Bracket, repair weld joint detail identified as SB008-044-001, 004, 005, 007, 019 and 043. ZPMC QC is identified as Mr. Zhou Cheng. The welding repair reports (WRR) are identified as B-WR108-20, 21, 22, 23, 24 and 19. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F) Repair-1.

This QA inspector observed ZPMC qualified welding personnel identified as 062755 perform FCAW Welding on Suspender Bracket, repair weld joint detail identified as SB008-040-061 and 067. ZPMC QC is identified as Mr. Zhou Cheng. The welding repair reports (WRR) are identified as B-WR108-11 and 12. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F) Repair-1.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, repair weld joint detail identified as SB007-046-043, 049, 055, 004, 007, and 019. ZPMC QC is identified as Mr. Zhou Cheng. The welding repair reports (WRR) are identified as B-WR108-13, 14, 15, 16, 17 and 18. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F) Repair-1.

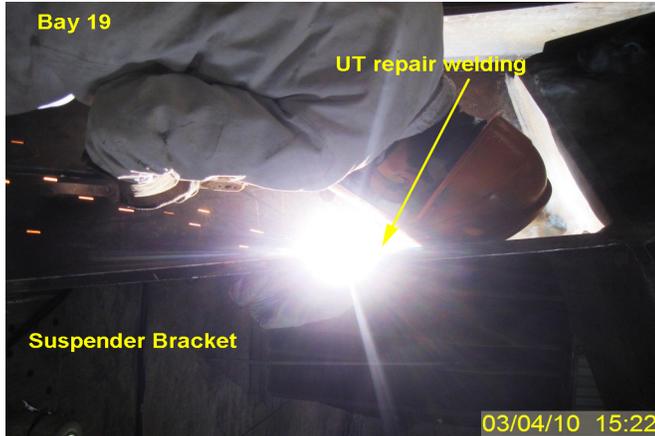
Visual Observation: During the Quality Assurance (QA) random in-process visual inspection this QA inspector observed CB Bottom plate that appear to have been bent due to improper handling and /or storage. This Floor Beam component is identified as BP026-013. The bottom plate is designated as Seismic Performance Critical Member (SPCM). For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Vibin | Quality Assurance Inspector |
| Reviewed By: | McClendon,Timothy | QA Reviewer |
