

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-013377**Date Inspected:** 05-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 045175 perform Flux Cored Arc Welding (FCAW) Welding on Corner Assembly, weld joint identified as CA3011-004. ZPMC QC is identified as Mr. Xu Tao. 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 201215 perform FCAW Welding on Corner Assembly, weld joint identified as CA3011-003. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 perform Shielded Metal Arc Welding (SMAW) Welding on Segment 11DW, weld joint identified as SEG071A-009. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 047864 perform SMAW Welding on

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Segment 11DW, weld joint identified as SEG071A-010. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 037723 SMAW Welding on Segment 11DW, weld joint identified as SEG071A-015. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 069683 perform SMAW Welding on Segment 11DW, weld joint identified as SEG071A-016. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 066258 perform SMAW Welding on Segment 11DW, weld joint identified as SEG071A-026. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 037748 perform SMAW Welding on Segment 11DW, weld joint identified as SEG071A-024. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 047864 perform SMAW Welding on Segment 11EW, weld joint identified as SEG073B-003. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform SMAW Welding on Segment 11DE, weld joint identified as SSD24-PP104.5-129~136. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 049339 perform SMAW Welding on Segment 11DE, weld joint identified as SSD24-PP105.5-129~136. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 20013 perform SMAW Welding on Segment 11DE, weld joint identified as SSD24-PP106.5-129~136. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM

Magnetic Particle Testing (MT)

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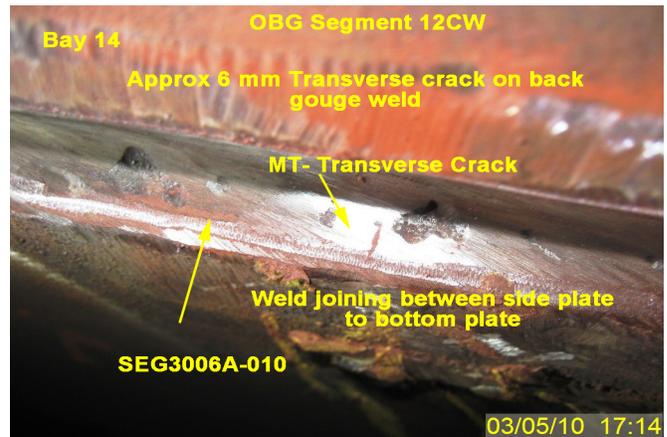
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This QA inspector performed Visual Testing (VT) on OBG Segment 12CW, VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 12CW. The weld designations reviewed are as follows:

1. SEG3006A-001
2. SEG3006A-009
3. SEG3006A-011
4. SEG3006A-002
5. SEG3006A-010
6. SEG3006A-012

VT-Indication details: During random Quality Assurance Visual review of weld bevel back gouging on segment 12CW, this Quality Assurance Inspector (QA) discovered five (5) Transverse linear indications measuring approximately 6mm in lengths. The indication was discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA. ZPMC Quality Control MT Technicians claimed that magnetic particle testing have been performed on these welds. The indication is clearly marked on the material near the weld. The weld is identified as SEG3006A- 001, 009, and 010. This weld is a Fillet weld joining the side plate to bottom plate. For further information, please see the attached pictures

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



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
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Reviewed By:	McClendon, Timothy	QA Reviewer
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