

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-013379**Date Inspected:** 06-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 202122 perform Flux Cored Arc Welding (FCAW) Welding on Corner Assembly, weld joint identified as CA3006C-029 & 030. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 202122 perform FCAW Welding on Corner Assembly, weld joint identified as CA3006C-041 & 042. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2122.

This QA inspector observed ZPMC qualified welding personnel identified as 201213 and 045175 perform FCAW Welding on Corner Assembly, weld joint identified as CA3011-003. ZPMC QC is identified as Mr. Li Ming Yang. 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 047864 perform Shielded Metal Arc

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Welding (SMAW) Welding on Segment 11DW, weld joint identified as SEG071C-001 and 002. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on Traveler Rail, weld joint identified as 11TR1-007. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 206623 perform FCAW Welding on Traveler Rail, weld joint identified as 10TR3-023. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 050242 perform FCAW Welding on Traveler Rail, weld joint identified as 10TR3-024. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1086.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 and 20013 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-045 and 046. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-2124-Tc-U4b-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 044790 and 055491 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-032. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-2124-Tc-U4b-FCM.

This QA inspector observed ZPMC qualified welding personnel identified as 055497 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD18A-PP106-003. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044790 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD17A-PP105-002. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044824 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD16A-PP104-002. ZPMC QC is identified as Mr. Zhong Guo hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

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This QA inspector observed ZPMC qualified welding personnel identified as 062781 and 062788 perform FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001-044 and 045. 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 062753 and 062808 perform FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001-004, 005, 006 and 007. 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 062788 and 062755 perform FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001-008, 009, 012 and 013. 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. 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.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer