

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-013380**Date Inspected:** 07-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 Segment 12AW, weld joint identified as SEG3006A-010. 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-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform Flux Cored Arc Welding (FCAW) Welding on Segment 12AW, weld joint identified as SEG3006A-014. 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-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 047864, 045246 and 037723 perform Shielded Metal Arc Welding (SMAW) Welding on Segment 12CW, weld joint identified as SEG3006A-001, 009, and 011. 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-B-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 047864, 045246 and 037723 perform

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Shielded Metal Arc Welding (SMAW) Welding on Segment 12CW, weld joint identified as SEG3006A-002, 010, and 012. 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-B-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 055491 and 050242 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SEG072A-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-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 and 200113 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-045, 046, and 047. 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-1.

Magnetic Particle Testing (MT) - Document No's: 005276

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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. CA61-019~024, 101, 102
2. CA65-019~024, 101, 102, 067~072, 109, 110, 079~084, 111, 112, 043~048, 105, 106
3. CA67-043~048, 105, 106, 055~060, 107, 108
4. CA68-019~024, 101, 102, 031~036, 103, 043~048, 105, 106, 079~084, 111, 112
5. CA71-043~048, 105, 106, 067~072, 099, 100
6. CA74-015~022, 099~106
7. CA73-023~030
8. SEG055D-001~006, 009, 010, 024~029, 032, 033
9. SEG055E-082~087,003, 004, 068~073, 076, 077

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This QA inspector observed ZPMC qualified welding personnel identified as 062783 and 062755 perform FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001-004 and 005. 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 062808 perform FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001-052 and 053. 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 FCAW Welding on CB Bottom Plate, weld joint identified as BP3018-001- 022 and 023. ZPMC QC is identified as Mr. Xu Tao.

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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 personnel performing MT inspection on SB38E CJP and Fillet welds.

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
