

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-013381**Date Inspected:** 10-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.

Bay 14

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 CA3011-003. ZPMC QC is identified as Mr. Tao Wei. 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 201215 perform FCAW Welding on Corner Assembly, weld joint identified as CA3009-004. ZPMC QC is identified as Mr. Tao Wei. 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 200113 and 049339 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SEG074A-001. 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-P-2214-Tc-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform SMAW Welding on

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Segment 11DE, weld joint identified as SEG072*-045. 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-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 048047 perform SMAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-019 and 039. 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-P-2213-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform SMAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-021, 022 and 040. 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-P-2213-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 050242 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-007. 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-2233-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW and SAW Welding on OBG Segment 11DE, weld joint identified as SEG072*-072. 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-223(2)1-T-2.

This QA inspector observed ZPMC qualified welding personnel identified as 058551 perform FCAW Welding on OBG Segment 11DE, weld joint identified as SSD16-PP104-250, 241, and 251. 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-U4c-F.

Ultrasonic Testing (UT) - Document: 005303

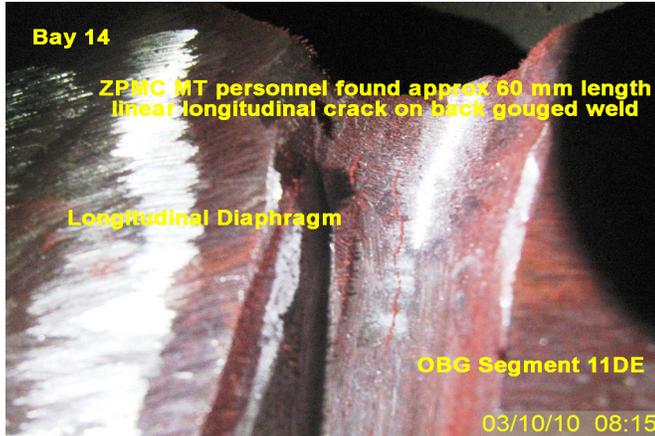
This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. CB202G-009-055, 057, 059, 061, 071
2. CB202G-010-055, 057, 059, 061
3. CB202G-011-055, 057, 059, 061, 069
4. CB202G-009-055, 057, 059, 061, 113

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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