

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-013388**Date Inspected:** 19-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 066326 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12BW, weld joint identified as SEG3005M-115~118. ZPMC QC is identified as Mr. Li Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 202122 and 045240 perform SMAW Welding on OBG Segment 12BW, weld joint identified as SEG3005K-018, 089 and 046. 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-2232-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 204730 perform SMAW Welding on OBG Segment 12BW, weld joint identified as SEG3005D-095~134. 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-T-U4b-FCM-1

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

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OBG Segment 12BW, weld joint identified as SEG3005J-017. 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-T-U4b-FCM-1

This QA inspector observed ZPMC qualified welding personnel identified as 044774 and 058551 perform Flux Cored Arc Welding (FCAW) Welding on OBG Segment 12CE, weld joint identified as SEG3003A-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-T-2231-B-U2-F-1.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006*-008. ZPMC QC is identified as Mr. Liu Hua Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 perform SMAW Welding on OBG Segment 12BW, weld joint identified as SEG3005H-007. 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-T-U4b-FCM-1.

Outside Yard 9EW

This QA inspector observed ZPMC qualified welding personnel performing weld repair / correction on Flange Plate X7K of PP83, PP84, and PP85 to maintain the required radius R50mm. The welding process is identified as Shielded Metal Arc Welding (SMAW) and the welders are identified as 205098 and 067588. ZPMC QC is identified as Mr. Li Ming. The welding variables recorded by QC appeared to comply with the applicable WPS: 345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR10731. See the attached pictures.

Outside Yard 9CW

This QA inspector observed ZPMC qualified welding personnel identified as 067752 perform SMAW Welding on OBG Segment, weld joint identified as CA062-004. ZPMC QC is identified as Mr. Li Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1317.

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.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer