

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-013395**Date Inspected:** 20-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. Geng Wei**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.

Outside Yard 10AE

This QA inspector observed ZPMC qualified welding personnel identified as 067665 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 10AE, weld joint identified as SDD17-PP087-177 and 178. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-T-U5-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067656 perform SMAW Welding on OBG Segment 10AE, weld joint identified as SDD17-PP087-183. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-T-U5-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 037723 perform SMAW Welding on OBG Segment 10AE, weld joint identified as SEG060E-120 and 121. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-T-U5-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067589 perform SMAW Welding on

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OBG Segment 10AE, weld joint identified as SEG060E-143 and 144. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-T-U5-FCM-1.

Outside Yard 9DE

This QA inspector observed ZPMC qualified welding personnel identified as 054213 perform SMAW Welding on OBG Segment 9DE, weld joint identified as temporary attachment areas (BP and SP). ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1033.

Magnetic Particle Testing (MT) - Document No's: 005389

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. CA092-004
2. CA091-004

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform Flux Cored Arc Welding (FCAW) welding on OBG Segment 12BE, weld joint identified as DP3020-PP114.5-022 and 023. 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-T-2233-Tc-U4b-F and WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3020-PP114.5-180 and 181. 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-T-2233-Tc-U4b-F and WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3020-PP113.5-113 and 114. 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-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 200113 and 044772 perform SMAW Welding on OBG Segment 12CE, weld joint identified as SEG3003A-001. ZPMC QC is identified as Mr. Zhou Guo Hui. 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 044774 and 058551 perform FCAW

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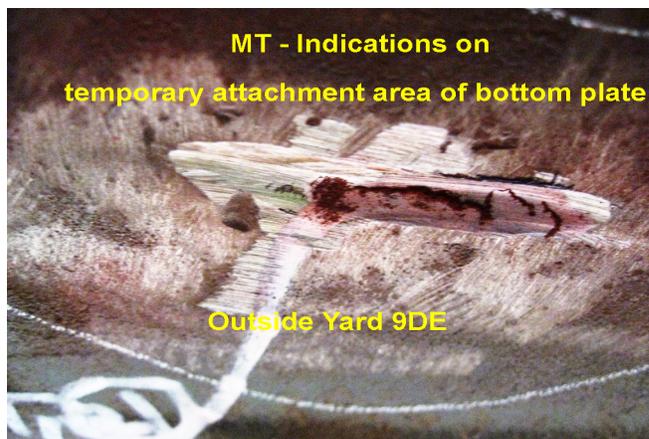
Welding on OBG Segment 12CE, weld joint identified as SEG3003A-002. ZPMC QC is identified as Mr. Zhoug Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 204730 perform FCAW Welding on OBG Segment 12CW, weld joint identified as SEG3006*-007. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045246 perform SMAW Welding on OBG Segment 12CW, weld joint identified as SEG3005H-007. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 047864 perform SMAW Welding on OBG Segment 12CW, weld joint identified as SEG3005H-017. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-Tc-U4b-FCM-1. 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

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Reviewed By: McClendon, Timothy

QA Reviewer