

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-013398**Date Inspected:** 29-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.

Outside Yard 9EW

This QA inspector observed ZPMC qualified welding personnel identified as 045133 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 9EW, weld joint identified as SEG057C-005. ZPMC QC is identified as Mr. Li Ming Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11280.

This QA inspector observed ZPMC qualified welding personnel identified as 066038 perform SMAW welding on OBG Segment 9EW, weld joint identified as SSD13A-PP083-128. ZPMC QC is identified as Mr. Li Ming Gang. 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 Welding Repair Report (WRR) B-WR11314.

This QA inspector observed ZPMC qualified welding personnel identified as 045133 perform SMAW welding on OBG Segment 9EW, weld joint identified as SEG057B-005. ZPMC QC is identified as Mr. Li Ming Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11287.

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This QA inspector observed ZPMC qualified welding personnel identified as 066038 perform SMAW welding on OBG Segment 9EW, weld joint identified as SEG057C-025. ZPMC QC is identified as Mr. Li Ming Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11283.

Outside Yard 9DE

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW welding on OBG Segment 9DE, weld joint identified as SP586-001-130, 101, 133, 105, 137, 109, 141, 113, 145, 117, 149, 121, 125 and 153. 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-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform FCAW welding on OBG Segment 9DE, weld joint identified as SP586-001-129, 102, 134, 106, 138, 110, 142, 114, 146, 118, 150, 122, 126 and 154. 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-T-2132.

Outside Yard 9DW

This QA inspector observed ZPMC qualified welding personnel identified as 069896 and 067609 perform SMAW welding on OBG Segment 9DW, weld joint identified as SEG055A-032. ZPMC QC is identified as Mr. Tang Ya Jun. 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 Welding Repair Report (WRR) B-WR11439.

This QA observed ZPMC MT personnel found 13no's of longitudinal and transverse crack on deck panel longitudinal diaphragm to Floor beam flange joint fillet weld. The segment is identified as a 9CW and Panel point is identified as a PP76. See the attached picture.

Visual Inspection after Blast

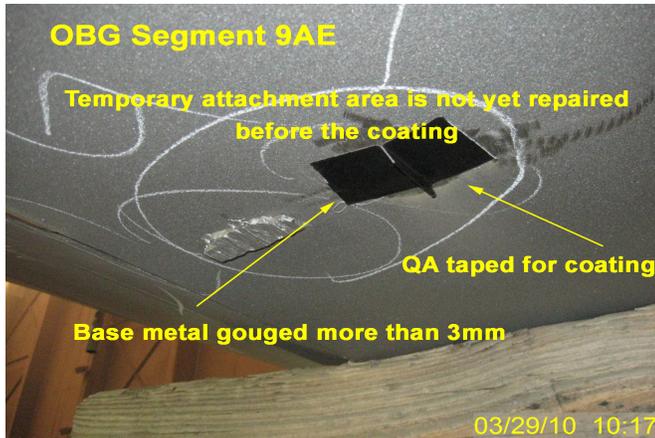
Segment 9AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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