

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013455**Date Inspected:** 09-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu hua ji**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-004 ,006 located on PCMK SEG3004A of 12AW welder is identified as 047864, 045246. ZPMC QC is identified as Mr. Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint 2G-003 located on PCMK CA3009 of 12BW welder is identified as 045175. ZPMC QC is identified as Mr. Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-003 located on PCMK CA3006 of 12AW welder is identified as 202122. ZPMC QC is identified as Mr. Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F

FCAW welding of weld joint 1G-221 located on PCMK SSD16-PP104 of 11DE welder is identified as 058551. ZPMC QC is identified as Mr. Zhang guo hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4C-F.

FCAW welding of weld joint 3G-021 located on PCMK SEG072* of 11DE welder is identified as 055491. ZPMC QC is identified as Mr. Zhang guo hui . The welding variables recorded by QC appeared to Comply with the

WELDING INSPECTION REPORT

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WPS-B-T-2233-B-U2-F.

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 X37 bracket plate. The weld designations reviewed are as follows:

CA65-043,047,005.

CA59-059,107,055.

CA061-071,109,067.

SEG55D-056,050,051.

CA77-020,025,026.

CA59-047,043,105.

SEG63E-047,052.

CA74-077,070,072.

SEG63D-055,058,060.

SEG059E-062,063,059.

OUTSIDE SHOP

ZPMC make drill holes in Hand rails is appeared to comply with the contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Outside Shop
ZPMC performing drill holes in Hand rails



BAY#14
ZPMC QC MT personnel performing MT on X37 bracket welds

Summary of Conversations:

No relevant Conversation.

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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Kumar, Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon, Timothy	QA Reviewer
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