

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-013701**Date Inspected:** 30-Apr-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 9DW**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.

Magnetic Particle Testing (MT) - Document No's: 005616

This QA inspector performed MT of approximately 100% 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 Segment 9DW. The weld designations reviewed are as follows:

DP098-001 – 062 ~ 087

DP125-001 – 081 ~ 114

DP152-001 – 100 ~ 141

DP179-001 – 100 ~ 141

DP206-001 – 100 ~ 120

SSD10-PP80-003, 004

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062738 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB012-054-001, 019 and 020. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared

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to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062807 perform FCAW Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB012-052-001, 019 and 020. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform FCAW Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB012-050-001, 019 and 020. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Suspender Bracket, weld joint identified as SB014-054-025, 031, 037, 043, 049, 055, 061, & 067. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Ultrasonic Testing (UT) - Document: 005628

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 USPL1-U Ribs Splice Plate. The weld designations reviewed are as follows:

1. USPL1-452-001, 002
2. USPL1-454-001, 002
3. USPL1-505-001, 002
4. USPL1-515-001, 002
5. USPL1-522-001, 002
6. USPL1-529-001, 002
7. USPL1-534-001, 002
8. USPL1-536-001, 002
9. USPL1-543-001, 002
10. USPL1-551-001, 002
11. USPL1-555-001, 002
12. USPL1-557-001, 002
13. USPL1-558-001, 002
14. USPL1-560-001, 002
15. USPL1-561-001, 002
16. USPL1-562-001, 002
17. USPL1-563-001, 002
18. USPL1-564-001, 002
19. USPL1-565-001, 002
20. USPL1-567-001, 002
21. USPL1-569-001, 002

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- 22. USPL1-570-001, 002
- 23. USPL1-571-001, 002
- 24. USPL1-572-001, 002
- 25. USPL1-573-001, 002
- 26. USPL1-574-001, 002
- 27. USPL1-578-001, 002
- 28. USPL1-580-001, 002
- 29. USPL1-581-001, 002
- 30. USPL1-582-001, 002
- 31. USPL1-584-001, 002
- 32. USPL1-585-001, 002
- 33. USPL1-586-001, 002
- 34. USPL1-587-001, 002
- 35. USPL1-588-001, 002

Visual Inspection after Blast

OBG Segment 9EW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior 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.

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
