

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-013724**Date Inspected:** 21-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Liqian/Li yanhua**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 4F-152/153 located on PCMK SEG072D of segment 11DE welder is identified as 067752. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-FCM-1.

FCAW welding of weld joint 2G-057 located on PCMK SEG3003M of segment 12CE welder is identified as 214945. ZPMC QC is identified as Mr. Guo pan. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-135 located on PCMK SEG3003N of segment 12CE welder is identified as 214945. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2232-Tc-U4b-F.

SMAW welding of weld joint 4G-230 located on PCMK SSD16-PP104 of segment 11DE welder is identified as 037723. ZPMC QC is identified as Mr. Guo pan. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM.

OUTSIDE YARD

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9DW

SMAW welding of repair weld joint 4F-156/157 located on PCMK SEG055D of segment 9DW welder is identified as 045268.ZPMC QC is identified as Mr.Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-repair and WR-12046.

10CE

Side plate T-ribs Splice hole matching work is going as per contract documents.

9DE

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 Segment 9DE –X37 plates. The weld designations reviewed are as follows: NWIT-005564
SEG056D-005,006,007,066,067,080.
SEG056E-036,037,063,066,011,014.
CA066-025,026,029,030,061,062,085,090.

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

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.

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