

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013726**Date Inspected:** 24-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**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

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 Diaphragm of segment 12CW. The weld designations reviewed are as follows: NWIT-005589.

SEG3006E-131

SEG3006B-130

SEG3006C-148

SEG3006G-151

SEG3006D-127

SEG3006F-145

SEG3006B-131

SEG3006C-147

SMAW welding of weld joint 4F-128 located on PCMK SSD17A-PP105 of segment 11DE welder is identified as 037723. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114.

FCAW welding of weld joint 1G-022 located on PCMK SEG3001* of segment 12AE welder is identified as

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048038.ZPMC QC is identified as Mr.Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-222(3)1T-2.

FCAW buttering welding of weld joint 3G-128 located on FL-1 and FL2-2 flange connecting plate X5C of segment 12AE @ PP109 welder is identified as 058551.ZPMC QC is identified as Mr.Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-repair and B-WR12220.

BAY#19

FCAW welding of weld joint 2G-055 located on PCMK SB014-052 of Lift 8 welder is identified as 062749. ZPMC QC is identified as Mr.Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 1G-001 located on PCMK USPL1-562 of U ribs splice welder is identified as 062761.ZPMC QC is identified as Mr.Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

OUTSIDE SHOP

10BW

FCAW welding of weld joint 3F-129 located on PCMK CA073 of segment 10BW welder is identified as 066413. ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

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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