

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-013728**Date Inspected:** 27-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:** Xu tao/ 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.

BLAST SHOP-1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9EW External Bottom panel; Side panel and Deck panel from panel point PP77 to PP79 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

OUTSIDE SHOP

SMAW welding of weld joint 3F-037 located on PCMK CA075 of segment 10BE welder is identified as 043667. ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

SMAW welding of weld joint 4F-116 located on PCMK SEG064D of segment 10CE welder is identified as 049339.ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4G-132 located on PCMK SSD20-PP101 of segment 11CE welder is identified as 0043661.ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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SMAW welding of weld joint 4F-133 located on PCMK SSD20-PP102 of segment 11CE welder is identified as 054013.ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

BAY#14

FCAW welding of weld joint 2F-153 located on PCMK DP3046-001 of segment 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-2132.

FCAW welding of weld joint 3G-089 located on PCMK DP3048-001 of segment 12AW welder is identified as 201215.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 3F-022 located on PCMK DP3048-001 of segment 12AW welder is identified as 204739.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

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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