

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-013735**Date Inspected:** 05-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**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.

Bay 13

This QA inspector observed ZPMC qualified welding personnel identified as 206623 perform Flux Cored Arc Welding (FCAW) Welding on Traveler Rail, weld joint identified as 20TR2-006-015. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11042.

This QA inspector observed ZPMC qualified welding personnel identified as 044830 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-008-011. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11060.

This QA inspector observed ZPMC qualified welding personnel identified as 044830 perform FCAW Welding on Traveler Rail, weld joint identified as 20TR2-005-015. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair, which is used as per Welding Repair Report (WRR) B-WR11037.

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Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3030-001-273, 278, 283 and 288. ZPMC QC is identified as Mr. Wang Xu. 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 044790 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3030-001-117, 112, 127, and 132. ZPMC QC is identified as Mr. Wang Xu. 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 048038 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3030-001-313, 318, 157 and 162. ZPMC QC is identified as Mr. Wang Xu. 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 044790 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3031-001-095, 100, 105 and 110. ZPMC QC is identified as Mr. Wang Xu. 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 214945 perform FCAW Welding on OBG Segment 12BE, weld joint identified as DP3032-001-169, 174, 073 and 078. ZPMC QC is identified as Mr. Wang Xu. 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 050696 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12AE, weld joint identified as SEG3001F-014. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 055359 perform SMAW Welding on OBG Segment 12AE, weld joint identified as SEG3001G-014. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2213-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 055564 perform SMAW Welding on OBG Segment 12AE, weld joint identified as SEG3001T-049 and 050. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Visual Inspection after Blast

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Segment 9BW

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
