

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-013778**Date Inspected:** 15-Mar-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:** Gong Wei**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG Segment 12BW, weld No.SEG3005B-015/016. The welder is identified as #045227. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 2F position for the OBG Segment 11DW, weld No.SSD021-PP106.5-049. The welder is identified as #204730. ZPMC QC is identified as Mr. Tao Wei The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 4G position for the OBG Segment 12BW, weld No.SEG3005J-008. The welder is identified as #037996. ZPMC QC is identified as Mr. Tao Wei The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 12BW, weld No.SEG3005D-007. The welder is identified as #066361. ZPMC QC is identified as Mr. Tao Wei The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

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SMAW in the 4G position for the OBG Segment 12BW, weld No.SEG3005E-007. The welder is identified as #067589. ZPMC QC is identified as Mr. Tao Wei The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

During random visual inspection the QA inspector observed in segment 12BE that ZPMC personnel fit up the Floor Beam FB3013 at Panel Point PP113.5 at bike path side which was bent from weld area approximately 70mm. The QA Inspector informed to the ZPMC QC Inspector for repair the bent area need engineer approval. For details please refer attached photo.

During random visual inspection the QA inspector observed in segment 12BW that ZPMC personnel installed the Floor Beam FB3082-003 at Panel Point PP114 at cross beam side which was not Green Tagged.

During random visual inspection the QA inspector observed in segment 9DE the ZPMC performing Carbon Arc Back Gouging for "T" joint joining between stiffeners to Stiffener at crossbeam side PP80.5 to PP81 without any information. After that the QA Inspector visually Checked the Gouged area and found one crack like indication in weld area .The weld number is identified as SSD17-PP81-146.This QA Inspector informed to ZPMC QC personnel to provide critical weld repair report for repair that mention weld area.For more information see the attached photo.

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

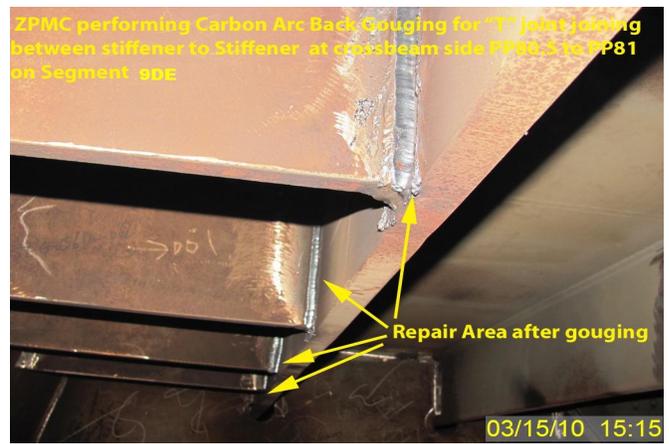
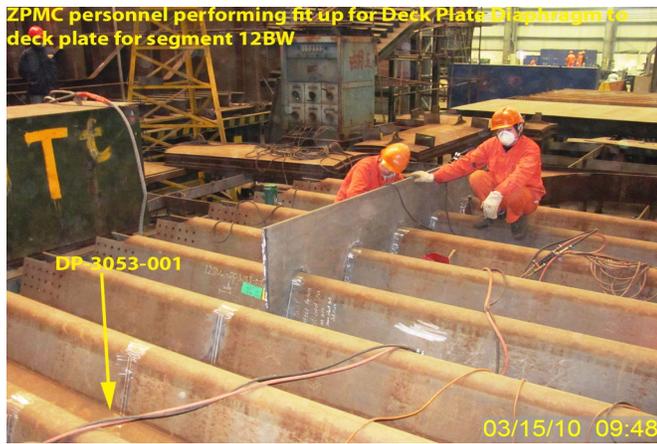
Summary of Conversations:

No relevant conversations



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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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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