

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-013819**Date Inspected:** 15-Jan-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:** As identified below**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**Summary of Items Observed:**

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

Bay 19-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Suspender Bracket welds SB007-040-001 and 005. ZPMC welder was identified as 062752 and 062788. ZPMC QC was identified as Zhou Cheng. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Bay 14-

Shielded Metal Arc Welding (SMAW) repair of OBG Segment 11 EW edge panel to side panel corner assembly weld, CA091-003. ZPMC welders were identified as 045246 and 205718. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-Repair.

Shielded Metal Arc Welding (SMAW) of OBG Segment 11 EW FL1 floor beam flange to FL2-1 floor beam flange welds, SSD13A-PP108-127 and SSD13A-PP107-127. ZPMC welder was identified as 051318 and 047864. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8BE Lower interior section from panel point 66 to 67. Areas requiring light grinding were marked for ZPMC personnel. The location of areas requiring weld repair were recorded and placed on on the punchlist for future repair.

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

Summary of Conversations:

As identified within the contents of this report.

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.

Inspected By:	Viars,Larry	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------