

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-013855**Date Inspected:** 18-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:** 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.

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This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member was identified as OBG Segment 12AW Bottom Panel to Side Panel welds. The weld identification numbers are as follows:

SEG3004-004, 006, 010 and 014.

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 12AE corner assembly diaphragm to edge panel fillet weld, CA6501C-023. ZPMC welder was identified as 044801. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Caltrans QA Inspector performed Magnetic Particle Testing (MT) OBG segment 12BW longitudinal diaphragm to floor beam weld SEG3005D-163 backgouge area 1390 mm area from the bottom of the weld up. No relevant indications were noted. Please see the attached photo below for further detail.

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

WELDING INSPECTION REPORT

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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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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