

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-013881**Date Inspected:** 07-May-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:** Zhou zhonghai / Zhou cheng**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.

BAY#14

SMAW welding of weld joint 4G-007 located on PCMK SEG3003M of Segment 12CE welder is identified as 067752. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 2F-009 located on PCMK SEG3001H of Segment 12AE welder is identified as 217805. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

During in process inspection tack weld of weld joint fit-up is identified as SEG3003B-002 and SEG3003D-002 which is connecting Deck panel diaphragm to deck panel diaphragm complete joint penetration weld in segment 12CE, the tack weld welded outside the groove and also the width of the tack weld is 20mm in width and 100mm in length. This is informed to ABF QA Mr. Wang wei nan and ZPMC QC Mr. Guo xing hui for further grinding and MT.

BAY#19

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FCAW welding of weld joint 2G-055 located on PCMK SB015-060 of Lift 7 welder is identified as 062761. ZPMC QC is identified as Mr. Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2F-023 located on PCMK BP017-001 of Lift 13 welder is identified as 062752. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#16

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower Facade. The weld designations reviewed are as follows:
NWIT- 005685.

ND1-A211-6A/B,7A/B,14A/B,15A/B.
SD1-A267-2A/B,5A/B,10A/B,12A/B.
ND1-A266-2A/B,5A/B,10A/B,11A/B.
SD1-A265-2A/B,7A/B,10A/B,11A/B.
ND1-A264-2A/B,5A/B,10A/B,11A/B.
SD1-A263-2A/B,3A/B,10A/B,13A/B.
ND1-A261-2A/B,5A/B,10A/B,11A/B.
SD1-A262-2A/B,5A/B,10A/B,12A/B.
ND1-A259-2A/B,3A/B,10A/B,13A/B.
SD1-A260-2A/B,3A/B,10A/B,11A/B.
ND1-A257-4A/B,5A/B,10A/B,11A/B.

BAY#11

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Shear Plate. The weld designations reviewed are as follows:
NWIT-005687.

ND1-A24A/B-15 to 22.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Shear Plate. The weld designations reviewed are as follows:
NWIT-005680.

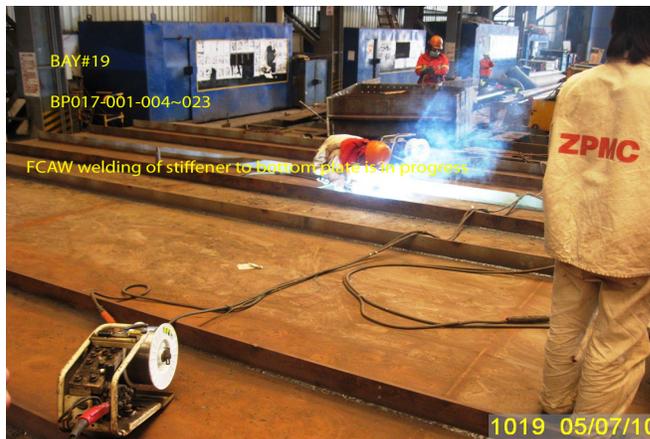
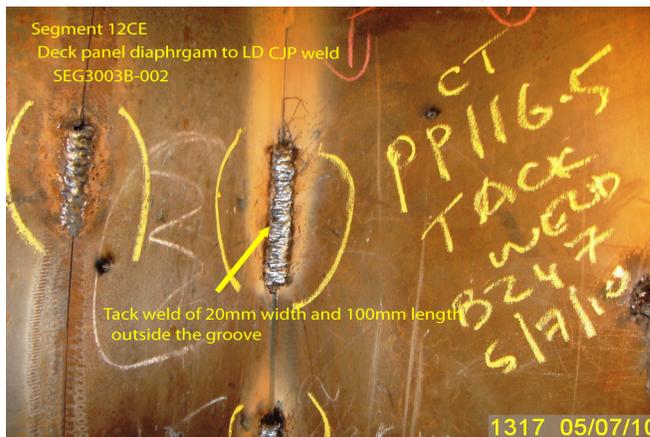
ED1-A27B/E-1 to 18 & 235.

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

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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

Reviewed By: McClendon,Timothy

QA Reviewer