

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-013883**Date Inspected:** 09-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:** Xu tao/ 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

FCAW welding of weld joint 1G-006 located on PCMK SEG3006* of Segment 12CW welder is identified as 066673. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232(1)T-2.

FCAW welding of weld joint 2F-007 located on PCMK SEG3001F of Segment 12AE welder is identified as 044801. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

Corner assembly CA3001 of segment 12AE is in progress.

OUTSIDE SHOP**10AW**

SMAW repair welding of Oversized cope hole located on PCMK PP86, PP87, PP88 of Segment 10AW welder is identified as 067610. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-1G(1F)-Repair-missed drill hole and WR12333.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

10CE

FCAW welding of weld joint 2F-016 located on PCMK CA077 of Segment 10CE welder is identified as 201087. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232.

BAY#19

FCAW welding of weld joint 2G-049 located on PCMK BP026-015 of Lift 13 welder is identified as 062786. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132-Tc-U4b-F.

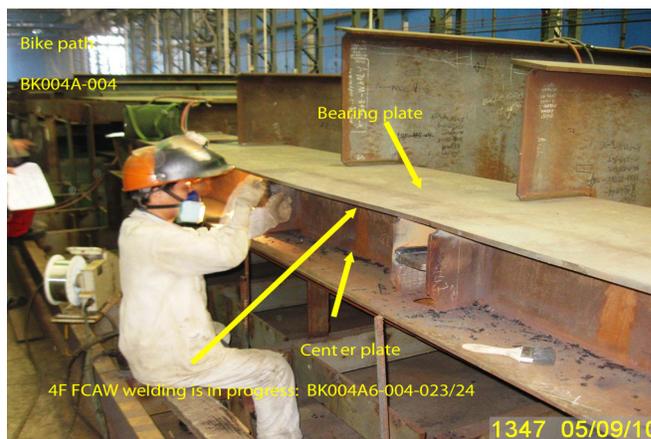
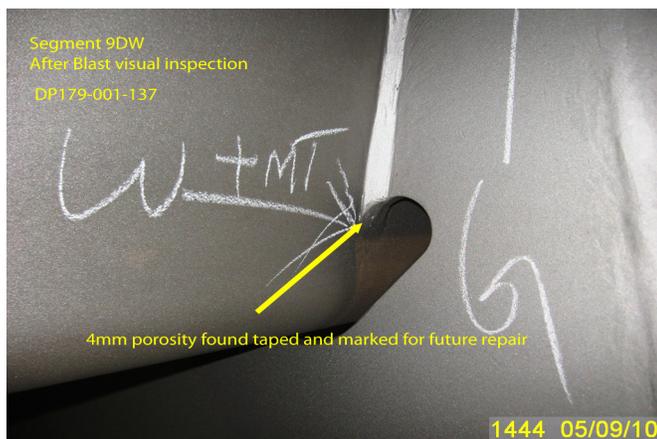
FCAW welding of weld joint 2G-067 located on PCMK SB012-056 of Lift 8 welder is identified as 062788. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132-Tc-U4b-F.

FCAW welding of weld joint 4F-023/24 which is connecting Center plate to bearing plate located on PCMK BK004A6-004 welder is identified as 208641. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2134.

BLAST SHOP#1

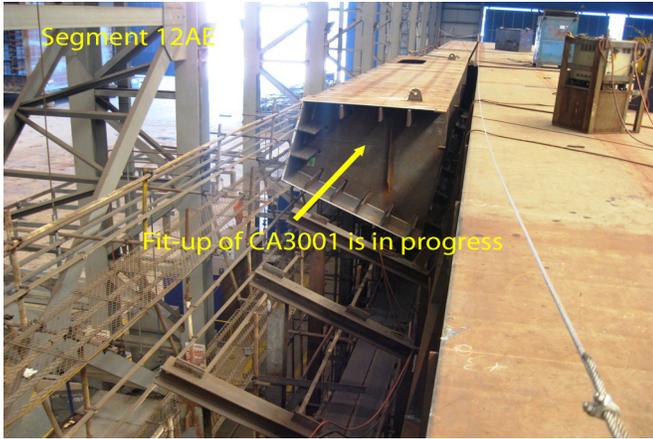
Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9DW internal Deck panel, corner assembly and deck panel diaphragm connecting to floor beam from panel point PP80 to PP82 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel. DP179-001-137, 4mm porosity found taped and marked for future repair.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
