

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-014342**Date Inspected:** 23-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	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:		

Summary of Items Observed:

Welding of FB 3162-001-012. The Welding Procedure was identified as WPS-B-T-2232-Tc-U4b-F. The welder was identified as 050977. ZPMC QC was identified as Zhu Jun. The ZPMC CWI was identified as Tian Lei.

Welding of FB 3162A-001-042. The Welding Procedure was identified as WPS-B-T-2232-Tc-U4b-F. The welder was identified as 214945. ZPMC QC was identified as Zhu Jun. The ZPMC CWI was identified as Tian Lei.

This inspector assisted in the performance of a blast inspection on the West Tower lift 1, from 18M UDD to 18M LDD, to 13M SD to 9M SD to lead end of the shaft in blast shop #2. This inspection was in conjunction with ZPMC inspectors for the detection of non-conformances in base metal and welds after preliminary blasting. Findings during this inspection were marked for rework directly on the steel in chalk.

This inspector performed a 10% QA conventional ultrasonic inspection, UT, on DP 3119-001, DP 3118-001, DP 3123-001, and DP 3120-001 in order to determine lack of penetration, LOP, in the partial joint penetration, PJP, U-rib welds. No indication requiring rework or weld repair was noted by this inspector.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

WELDING INSPECTION REPORT

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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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine, Daniel	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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