

**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-014998**Date Inspected:** 25-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**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW , weld No. BP3072-001-004. The welder is identified as #045265. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U2c-S-2.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 12AW , weld No. SEG-3004G-097. The welder is identified as #045276. ZPMC QC is identified as Mr. Zhong Yong Gang . The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3F position for the OBG Segment 12AW , weld No. SEG-3004C-150/151. The welder is identified as #201215. ZPMC QC is identified as Mr. Zhong Yong Gang . The welding variables recorded by QC appear to comply with WPS-B-T-2133.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

FCAW in the 1G position for the OBG Segment 12AW , weld No. SEG-3004AL-010. The welder is identified as #201215. ZPMC QC is identified as Mr. Zhong Yong Gang . The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

FCAW in the 3G position for the OBG Segment 12CE , weld No. DP3029-001-011. The welder is identified as #044830. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3G position for the OBG Segment 12CE , weld No. DP3027-001-013. The welder is identified as #051356. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

Bay #13

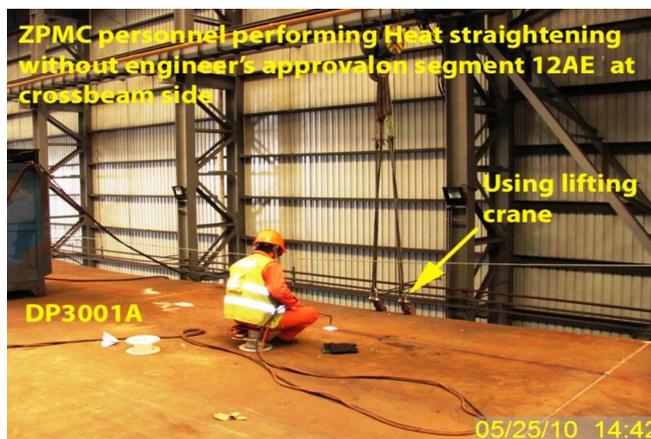
This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AE , weld No. BP3030-001-004. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo Xing Hui . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

During Quality Assurance random in-process observations of the assembly of Orthotropic Box Girder (OBG) segments 12AW, this Quality Assurance Inspector (QA) discovered that after Carbon Arc Back Gouging at vertical joint joining between deck plate diaphragms to deck plate diaphragm found crack like longitudinal Indications. The effected joints are identified as SEG3004J-002,003,004,005 & SEG3004H-001 at PP111 and SEG3004G-001,003,004 & SEG3004F-001,004 at PP111.5. The QA inspector informed the ZPMC QC Mr. Li Ming Yang and ABF QA Mr. Liy Jin Ping to remove the indication and do Magnetic Particle Testing for confirmation at those mention area.

Segments 12AW are located in the Bay 14.

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



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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

No relevant conversations

## 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.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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