

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-015182**Date Inspected:** 26-Jun-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:** Li yan hua / 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 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 2F-084 located on PCMK SP3059-001 of Segment 13AE the welder is identified as 0447740. ZPMC QC is identified as Mr. Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#19

Ongoing Heat straightening of Suspender bracket SB72E is appeared to comply with HSR1 (B)-7126.

During in process visual inspection is found that fabrication of Drip plates Type 1,2,3,4 for Suspender bracket ZPMC started their production but they don't have any weld maps and also no QC welding inspection report on 06-25-2010. But today ZPMC QC Mr. Xu tao showed the weld maps for the drip plate fabrication.

During in process inspection it is found that gap between the drip plates Type-1 and Type-2 Is measured 3mm. It is informed to ZPMC QC Mr. Xu tao for further rectification.

Fit-up of stiffener in Suspender bracket SB72E joint fit-up dimension and tack weld checked with ZPMC QC Mr. Xu tao. The weld joint is identified as SB019-072- 069~076.

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BAY#16

SAW welding of weld joint 1G-001 located on PCMK BP3074-001 of Segment 13AW welder is identified as 045270. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

Back gouging of following repair weld joint 1G-003 located on BP3074-001-003 started, Removal of defects and grinding etc checked with ZPMC QC Mr. Xu tao is appeared to comply with B-WR13670.

OUTSIDE SHOP

12AW

SMAW welding of weld joint 4F-172 located on PCMK SEG3004J of Segment 12AW welder is identified as 047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

12CE

SMAW welding of weld joint 4G-003 located on PCMK SEG3004A of Segment 12CE welder is identified as 044772. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-B-U2-FCM-1

11DE

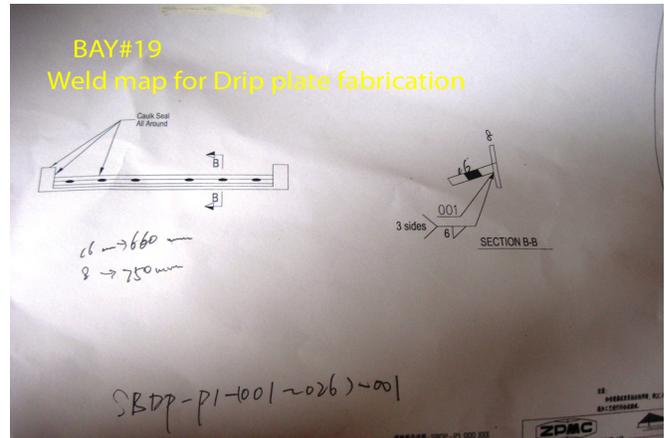
SMAW welding of weld joint 3G-027 located on PCMK SEG072E of Segment 11DE welder is identified as 201087. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b -FCM.

SMAW welding of repair weld joint 3G-042 located on PCMK SEG072B of Segment 11DE welder is identified as 054013. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G (3F)-FCM-repair and B-WR9656.

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

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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
