

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-015269**Date Inspected:** 20-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 yang**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.

Orthotropic Box Girder (OBG) Trial Assembly Areas

Lift 7 (East)

This Quality Assurance (QA) Inspector measured and recorded the dimension and smoothness for the Cope Holes at Corner Assembly at following location after rectification.

Segment 7AE

Cope Hole T1 at Panel Point (PP) 48 Cross Beam Side.

Segment 7CE

Cope Hole T1 at Panel Point (PP) 55 Cross Beam Side.

Segment 7DE

Cope Hole T2 at Panel Point (PP) 58.5 Cross Beam Side.

Segment 9CW

ZPMC bolting personnel performing their initial bolting at PP79 is segment 9CW.

Segment 8CW

This QA inspector observed ZPMC qualified welding personnel performing Shield Metal Arc Welding (SMAW) VT repair welding was performed various locations on the field splice edge and temporary attachment areas counter weight side of segment. Welder is number identified as 068097. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-34

Segment 8CW

WELDING INSPECTION REPORT

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This QA inspector observed ZPMC qualified welding personnel performing Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 046 located at SEG047B counter weight side segment. Welder number is identified 045246. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR1631 procedure.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract 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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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