

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015349**Date Inspected:** 04-Jul-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. 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 Segment**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – Document No: 006120

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 11AE. The weld designations reviewed are as follows:

1. SSD19A-PP95-002
2. SSD19A-PP96-128
3. SEG066C-002
4. SEG066*-018, 015, 014, 023, 032
5. CSD7-PP96-023

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 208939 and 062731 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK004A8-004-072 and 073. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Outside Yard 11CW

This QA inspector observed ZPMC qualified welding personnel identified as 216086 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 11CW, weld joint identified as SSD14-PP103-202. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2211-B-U2-FCM-1

OBG Segment 11DE

This QA inspector observed ZPMC qualified welding personnel identified as 043661 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SSD18A-PP106-048~065. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1. See the attached picture.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 11DE, weld joint identified as SSD18-PP106-015~032. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 062406 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE bottom plate, weld joint identified as BP3032-001-004. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE bottom plate, weld joint identified as BP3033-001-004. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2. See the attached picture.

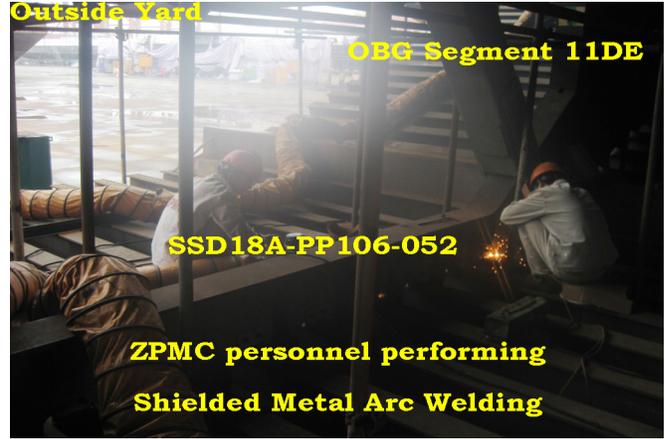
Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AW bottom plate, weld joint identified as BP3073-001-002. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer