

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-015844**Date Inspected:** 17-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Gong wei/Lu li qing**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**Summary of Items Observed:**

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

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 11EE, weld No: SSD19-PP107-064/065. The welder is identified as #067589. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 11DE, weld No: SSD17-PP105-191/192. The welder is identified as #043661. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

Bay #14

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG3004AA-004 located on OBG Segment 12AW Edge plate to Side plate.

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Welder is identified as #051348. ZPMC QC is identified as Mr. Li ping. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 12AW X3S Plate, weld No: SEG3004Y-036. The welder is identified as #047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appear to comply with WPS-B-P-4213-TC-U4B-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG3006M-233 located on OBG Segment 12CW Lifting lug. Welder is identified as #045246. ZPMC QC is identified as Mr. Wang wei ming. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13 Side plate, weld No: SP3099-001-061/062. The welders are identified as #044774/044830. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW longitudinal diaphragm weld No: LD3034-001-007. The welder is identified as #250050. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW longitudinal diaphragm weld No: LD3034-001-003. 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-L2C-S-2.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13CW longitudinal diaphragm weld No: LD3033-001-004. The welder is identified as #250050. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

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

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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