

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-015896**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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. Lv 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 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.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform Submerged Arc Welding (SAW) Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3034-001-007. ZPMC QC is identified as Mr. Li Ming Yang. 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 045265 perform SAW Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3034-001-004. ZPMC QC is identified as Mr. Li Ming Yang. 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 201583 perform Flux Cored Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3034-001-007 and LD3034-001-004. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform SAW Welding on

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Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3033-001-004. ZPMC QC is identified as Mr. Li Ming Yang. 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 201583 perform Flux Cored Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3033-001-004. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA observed ZPMC personnel performing heat straitening on Longitudinal Diaphragm to Longitudinal Diaphragm of OBG Segment 13CW. The joint number is identified as LD3034-001-004 and ZPMC internal HSR report is identified as HSR1 (B)-8802. See the attached picture.

This QA observed ABF personnel performing UT inspection on bottom plate of OBG Segment 13AW. The joint number is identified as BP3074-001-004 and joining member are identified as PL3362C and PL3363C. See the attached picture.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 051348 perform Shielded Metal Arc Welding (SMAW) Welding on edge plate to side plate of OBG Segment 12AW, weld joint identified as SEG3004A-004. 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-345-SMAW-4G (4F)-FCM-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 047864 perform SMAW Welding on X3S plate of OBG Segment 12CW, weld joint identified as SEG3004Y-0036, 029. 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-T-4213-Tc-U4b-2.

This QA inspector observed ZPMC qualified welding personnel identified as 055504 perform FCAW Welding on side plate stiffener of OBG Segment 13AW, weld joint identified as SP3099A-001-011~022. 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-2132.

OBG Segment 11EE

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 11EE, weld joint identified as SSD19A-PP108-002. ZPMC QC is identified as Mr. Li Ping and Welding Repair Report is identified as B-WR11254. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 201087 and 204339 perform SMAW welding on OBG Segment 11EE, weld joint identified SSD29-PP108.5-207 to 243. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general

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compliance with WPS-B-P-2113-FCM-1.

Visual Inspection after Blast

Segment 10AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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



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
