

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-016194**Date Inspected:** 02-Aug-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. Geng Wei**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 Segments**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 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-005. ZPMC QC is identified as Mr. Zhou Lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-005. ZPMC QC is identified as Mr. Zhou Lin. 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 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BW, weld joint identified as SEG3014A-004. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform Flux Core Arc

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Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3014A-004. ZPMC QC is identified as Mr. Zhang Lin. 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 201215 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13CW, weld joint identified as SEG3015A-003. ZPMC QC is identified as Mr. Zhang Lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform Flux Core Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001-094, 095, 193 and 194. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 201583 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001- 127, 128, 343 and 344. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001-106, 107, 139 and 140. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 201583 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001- 232, 233, 175 and 176. 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-2132.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-084-004. 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-2232-Tc-U4b-F.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-005. ZPMC QC is identified as Mr. Zhoug Lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

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This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-005. ZPMC QC is identified as Mr. Zhou Lin. 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 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BW, weld joint identified as SEG3014A-004. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 201215 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3014A-004. ZPMC QC is identified as Mr. Zhang Lin. 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 201215 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13CW, weld joint identified as SEG3015A-003. ZPMC QC is identified as Mr. Zhang Lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform Flux Core Arc Welding (FCAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001-094, 095, 193 and 194. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 201583 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001- 127, 128, 343 and 344. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001-106, 107, 139 and 140. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 201583 perform FCAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3036-001- 232, 233, 175 and 176. 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-2132.

Bay 19

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This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-084-004. 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-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-084-001 and 005. 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-2232-Tc-U4b-F.

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
