

**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-016200**Date Inspected:** 09-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. 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 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.

Ultrasonic Testing (UT) – Document No: 006344

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 11EW. The weld designations reviewed are as follows:

1. SEG 073\*-019, 020, 021, 022, 023, 024, 025, 026

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform Flux Core Arc Welding (FCAW) Welding on Suspender Bracket, weld joint identified as SB016-074-049, 055. 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 062761 perform FCAW Welding on Suspender Bracket, weld joint identified as SB016-074-005, 001. 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

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## WELDING INSPECTION REPORT

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WPS-B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062806 perform FCAW Welding on Suspender Bracket, weld joint identified as SB017-080-001, 005. 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-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062794 perform FCAW Welding on Suspender Bracket, weld joint identified as SB020-080-055, 043. 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 062807 perform FCAW Welding on Suspender Bracket, weld joint identified as SB019-072-025, 031. 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.

Visual Inspection after Blast

Tower – North Shaft, Lift 2

This QA Inspector performed a preliminary random visual inspection on Tower – North Shaft Lift 2 at blast shop 2, after the grit blast of the exterior components of north shaft are inspected such as skin A, B, C, D and E. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied, and also area which required grinding and grinding plus MT are clearly marked by QA on/near the weld and/or base metal. 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.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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