DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016425
Date Inspected: 20-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name: Wu shi guo/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

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

Bay #14

This QA Inspector observed the following work in progress:
SMAW in the 4F position for the OBG Segment 12AW Drain Plate, weld No: OBW12B-004/005. The welder is identified as #067904. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SEG3006W-005 located on OBG Segment 12CW Side panel to Side panel. Welder is identified as #045246. ZPMC QC is identified as Mr. Wang wei ming. Welding was performed according to the weld repair report B-WR14612 and UT report number: B787-UT-14496.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Repair.

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment 13CE Side Plate, weld No: SEG3011A-013. The welder is identified as #044790. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appear to

comply with WPS-B-T-2221-B-L2C-S-2.Please see the attached picture.

Bay #19

This QA Inspector observed the following work in progress:
FCAW in the 4F position for the Bike path weld No: BK004A6-008-023/024. The welder is identified as #208641. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2134.

This QA Inspector observed the following work in progress:
FCAW in the 4F position for the Bike path weld No:BK004A6-012-035/036. The welder is identified as #208633. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2134. Please see the attached picture.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SB017-080-049 located on OBG Segment Suspender Bracket SB80W. Welder is identified as #062765. ZPMC CWI is identified as Mr. Xu Tao. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-Repair.

Magnetic Particle Testing:-

Bay #16

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 13. The weld designation reviewed is as follows:

LD3031-001-007,010,012,013,014,019,021,022
LD3032-001-62,63,86,87,98,99,104,105
LD3033-001-07,08,10,11,18,19,20,21

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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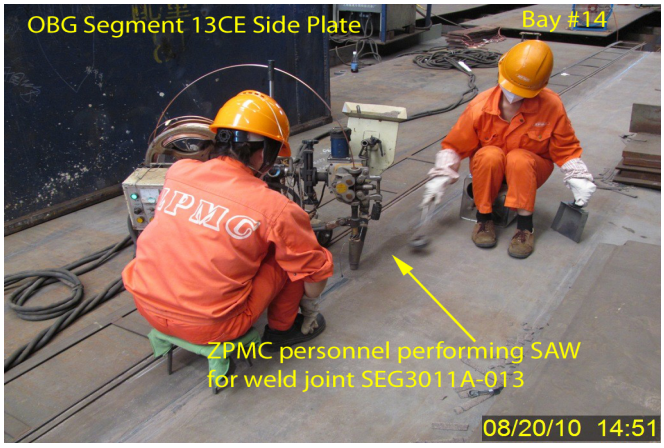

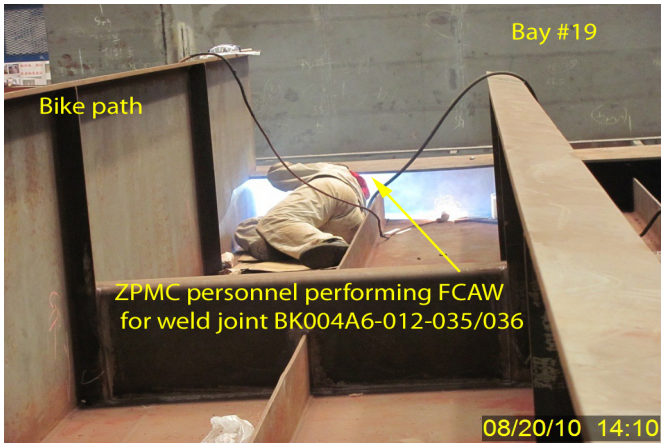

Summary of Conversations:

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 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
Reviewed By:	McClendon,Timothy	QA Reviewer