

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-016435**Date Inspected:** 24-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), Changxing Island **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

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 12AE X3P Plate, weld No: SEG3001L-057. The welders are identified as #201087. ZPMC CWI is identified as Mr. Wu shi guo. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 3F position for the OBG Segment 12AE X3P Plate, weld No: SEG3001M-061. The welder is identified as #215553. ZPMC CWI is identified as Mr. Wu shi guo. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG074A-010 located on Side panel to Corner Assembly of OBG Segment 11EE. Welder is identified as #043661. ZPMC CWI is identified as Mr. Wu shi guo. Welding was performed according to the weld repair report B-WR14760 and UT report number: B787-UT-14725. The welding variables

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recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Repair. Please see the attached picture.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 12AW X8E Plate, weld No: SEG3004Y-054. The welders are identified as #047866. ZPMC QC is identified as Mr. Wang xiang pin. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 13CE Side Panel, weld No: SEG3011A-014. The welder is identified as #044790. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

Bay #19

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: SB016-076-004 located on OBG Segment Suspender Bracket SB76W. Welder is identified as #062794. 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-FCAW-2G(2F)-Repair. Please see the attached picture.

Visual Inspection after Blast

Segment 11AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Exterior components of the Deck panel, Side panels and Bottom panel 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 generally comply with applicable contract documents.

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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
