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

Bay Area Branch
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Contract #: 04-0120F4
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-016481
Date Inspected: 26-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

Out Side Yard

This QA Inspector observed the following work in progress:
SMAW in the 4G position for the OBG Segment 12AE Lifting Lug at panel point 111, weld No: SEG3001J-252. The welder is identified as #044772. ZPMC CWI is identified as Mr. Wu shi guo. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1. 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: SEG3004K-047. The welder is identified as #047866. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U4B-F. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 3G position for the OBG Segment 12AW X8E Plate, weld No: SEG3004G-054. The welder is

identified as #201215. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-T-2233-TC-U4B-F. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 3G position for the OBG Segment 11DW, weld No: SSD25-PP106-186. The welder is identified as #202122. ZPMC QC is identified as Mr. Wang wei ming. 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:
SAW in the 1G position for the OBG Segment 13BW Side Panel, weld No: SEG3014N-002. The welder is identified as #045270. ZPMC QC is identified as Mr.Xia chuan hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 13BE and 13CE Side Panels.

SEG3009M-002
SEG3011A-002

Visual Inspection after Blast

Segment 11AE

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Side panels and Bottom panels 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.

WELDING INSPECTION REPORT

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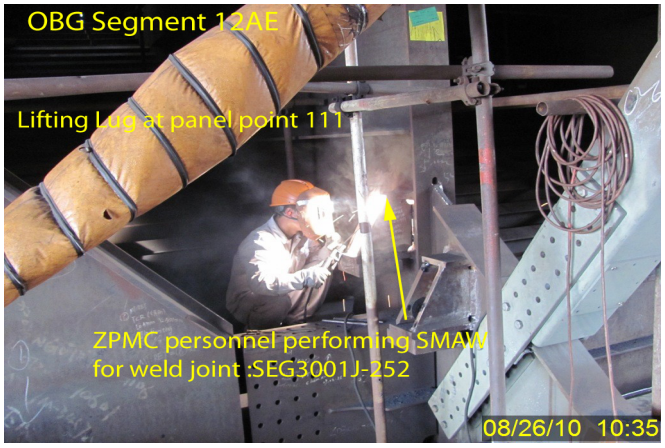

Summary of Conversations:

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