

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-016483**Date Inspected:** 21-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

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|------------------------------------|-----------------------------|----------------------------------|--------------|----|
| CWI Name: | Mr. Geng Wei and 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.

Magnetic Particle Testing (MT) - Document No's: 006451

This QA inspector performed 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 members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB018-092-051,053,054,063,065,066,027,029,030,039,041
2. SB017-090 051,052,054,057,059,060,063,065,028,030,039
3. SB017-090-041,045,048,021,023,033,035,002,003,069,071

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12CW, weld joint identified as OBW12C-004, 005. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044790 perform Flux Core Arc

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Welding (FCAW) Welding on OBG Segment 13AE, weld joint identified as SEG3007AE-001. ZPMC QC is identified as Mr. Guo Xing Hui. 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 personnel performed Magnetic Particle Testing (MT) on OBG Segment 13CW Side plate, weld joint identified as SP3112A.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 208632 perform Flux Core Arc Welding (FCAW) Welding on Bike Path, weld joint identified as BK004A3-010-056, 057. 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-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 208641 perform FCAW Welding on Bike Path, weld joint identified as BK004A6-008-035, 036. 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-2134.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW Welding on Bike Path, weld joint identified as BK004A8-008-023, 024. 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-2134.

This QA inspector observed ZPMC qualified welding personnel identified as 260562 perform FCAW Welding on Bike Path, weld joint identified as BK004A3-010-045, 046. 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-2132.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on OBG Suspender brackets, weld joint identified as SB019-072-001.

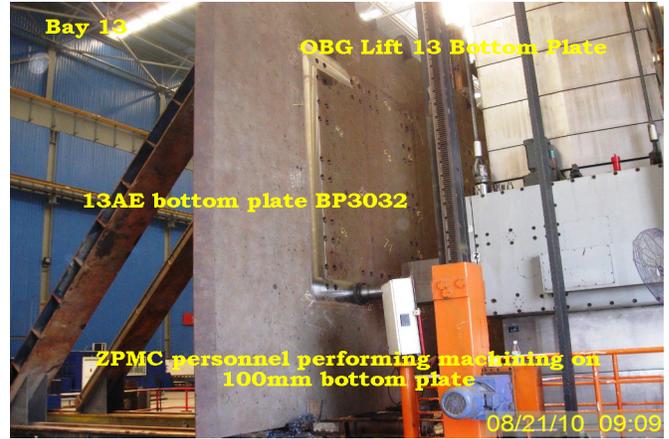
Bay 13

During random Quality Assurance Visual review of OBG Segment 13 lift Bottom Plates, this Quality Assurance Inspector (QA) observed machining of 100mm bottom plate at bay 13. The bottom plate is identified as OBG segment 13AE bottom plate BP3032. The bottom plate is identified as SPCM. See the attached pictures

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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