

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-016912**Date Inspected:** 12-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:** Huang Min**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG suspender Bracket SB72E, weld No. SB019-072-011. The welder is identified as #062807. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 1G position for the OBG suspender Bracket SB78W, weld No. SB016-078-005. The welder is identified as #062757. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW in the 1G position for the OBG suspender Bracket SB76W, weld No. SB016-076-005. The welder is identified as #062755. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW in the 2G position for the OBG suspender Bracket SB78E, weld No. SB019-078-037. The welder is identified as #062783. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC

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appear to comply with WPS-B-T-2232-Tc-U4b-F.

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG segment 12BW, weld No. SEG3005D-254/255. The welder is identified as #045175. ZPMC QC is identified as Mr. Wag Wei Ming . The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-P5-F.

FCAW in the 3G position for the OBG segment 12BW, weld No. SEG3005E-255. The welder is identified as #045227. ZPMC QC is identified as Mr. Wag Wei Ming . The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-P5-F.

Bay #7

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Cross Beam CB18, weld No. BP9001A-001-022. The welder is identified as #053748. ZPMC QC is identified as Mr. Wang Liang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 2G position for the OBG lift 14, weld No.SP3121-001-001. The welder is identified as #048625. ZPMC QC is identified as Mr. Guo Pan . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

Magnetic Particle Testing (MPT) for Bike Path at Bay#8

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Bike Path. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designation are as follows

BK004A3-061-012,013,014,038,047,048,038,047,048

BK004A7-061-003,009,005,011,015,016,017,018,074,051,052,053,054,039,045,041,047,027,028,029,030,12,013,
014

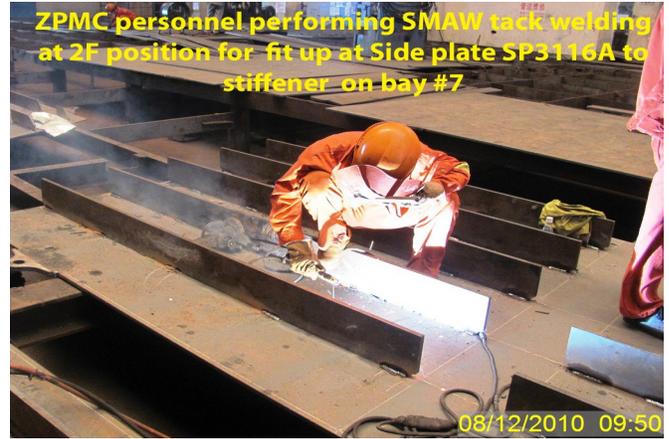
BK004A6-061-068,074,112,094,084

BK004A4-061-068,069,070,001,002,003

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 conversations

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: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer