

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-016913**Date Inspected:** 13-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 #7

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG lift 14, weld No.SP3140-001-099/100. The welder is identified as #062447. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

Bay #4

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Deck Panel repair weld, weld No.DP3144-001-001. The welder is identified as #062265. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

SMAW in the 2G position for the OBG Traveler rail weld repair, weld No.DP3144-001-001. The welder is identified as #049861. ZPMC QC is identified as Mr. Shen Jian Guo. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-REPAIR.

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Bay #3

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG lift 13, weld No.FB3283-001-002. The welder is identified as #217805. ZPMC QC is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

Magnetic Particle Testing (MPT) for Floor Beam at Bay#3

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

The Weld Designations are as follows

FB3131-001-015,016,017,18,23,24,35,36,39,47,48
FB3102-001-009,10,17,24,23,48,49,58,59
FB3139-001-11,12,13,14,24,57,35,36,39,39,40,45,46
FB3147-001-24,57,35,36,006,39,40,45,46
FB3135-001-15,16,17,18,35,36,23,39,40,47,48

Ultrasonic Testing (UT) for Floor Beam at Bay#3

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 floor beam weld joints.

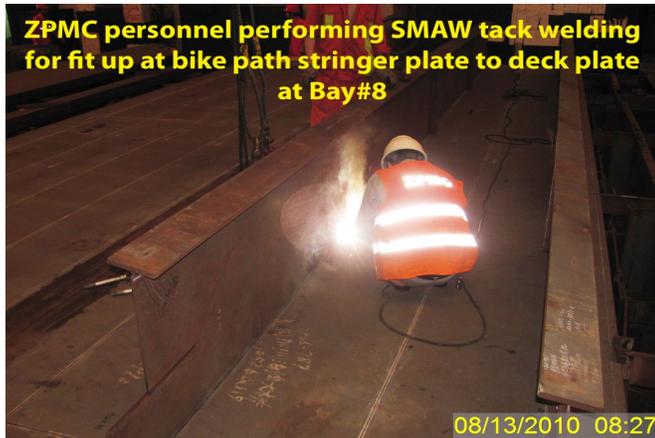
The welds designation reviewed are as follows:

FB3147-001-038
FB3135-001-038
FB3131-001-037
FB3139-001-037
FB3151-001-038
FB3102-001-056
FB3293-001-001,002
FB3280-001-001,002
FB3263-001-001~004

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
