

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017180**Date Inspected:** 21-Sep-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

CWI Name:	Mr. Geng Wei & 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 Bike Path and Segment	

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.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13CW, weld joint identified as SEG3013-005. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 066439 perform Flux Core Arc Welding (FCAW) welding on vertical plate of OBG Segment 13BE, weld joint identified as VP3004-001-006. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform Flux Core Arc Welding (FCAW) welding on vertical plate of OBG Segment 13BE, weld joint identified as VP3005-001-007 and 008. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform Flux Core Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Welding (FCAW) welding on vertical plate of OBG Segment 13BE, weld joint identified as VP3004-001-002, 003. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045143 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13AW, weld joint identified as LD3031-001-065. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1910.

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13AW, weld joint identified as LD3033-001-038. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1910.

This QA inspector observed ZPMC qualified welding personnel identified as 037944 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1-009-013, 014, 015 and 016. ZPMC QC is identified as Mr. Guo Pan. 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 066912 perform FCAW welding on steel barrier of OBG Component, weld joint identified as W5-SB1-001-007, 008, 009, 010, 011 and 012. ZPMC QC is identified as Mr. Guo Pan. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

OBG Segment 12AE

This QA inspector observed ZPMC qualified welding personnel identified as 068501 perform FCAW welding on OBG Segment 12AW, weld joint identified as SEG3003B-021, 022, 023, 024 and 025. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-213.

This QA inspector observed ZPMC qualified welding personnel identified as 068801 perform FCAW welding on OBG Segment 12AW, weld joint identified as SEG3003C-058, 059, 060, 061, 062 and 063. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-213.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062762 perform Flux Core Arc Welding (FCAW) welding on Suspender bracket, weld joint identified as SB020-86-055, 043, 067 and 031. ABF

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Suspender bracket, weld joint identified as SB020-90-067, 055, 043 and 031. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW welding on Suspender bracket, weld joint identified as SB020-88-012 and 013. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 062786 perform FCAW welding on Suspender bracket, weld joint identified as SB017-86-001, 004. ABF QC is identified as Mr. Peng Wen Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U4b-F.

This QA observed ZPMC personnel performing flame straightening by oxygen acetylene on OBG Bike Path BK004A-003 deck panel to deck panel CJP weld, which is used as per HSR(1)-5812. The joining deck panels are identified as BKPL1 and BKPL2. The joint number is identified as BK004A-003-009. See the attached pictures.

Visual Inspection after Blast

Segment 11CW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11CW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies 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. See the attached pictures.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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