

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015240**Date Inspected:** 30-Jun-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:** Li Ming Yang**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 Components**Summary of Items Observed:**

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

Bay#19

During random visual inspection of the suspender bracket in OBG fabricating bay#19, this QA inspector observed several discontinuities like under fill, notches, gouging marks and spatters at the cope hole locations. The locations are clearly marked on the suspender brackets. The suspender brackets are identified as, SB48E, SB54W and SB60E.

ZPMC personnel will rectify the issues and will submit NWIT for visual inspection of the suspender brackets.

Bay#19

During random visual in process inspection of bike path, this QA inspector observed following issues:

This QA inspector observed weld buttering was performed by ZPMC personnel on the end of the stringer plates BKX8A, BKX8C, BKX9A, BKX9C and BKX10A and X7F stiffener.

The bike path is identified as BK004A-004.

According to the shop drawing the stringer plates length is 9202mm + 395mm bearing plate (both side).

The actual length of the stringer plates are 9~12mm short at east end.

The material is ASTM A709M-345 grade non SPCM.

ZPMC personnel need to perform required NDT work after grinding on the weld buttering locations.

The weld buttering was performed in accordance with WRR# B-WR13848.

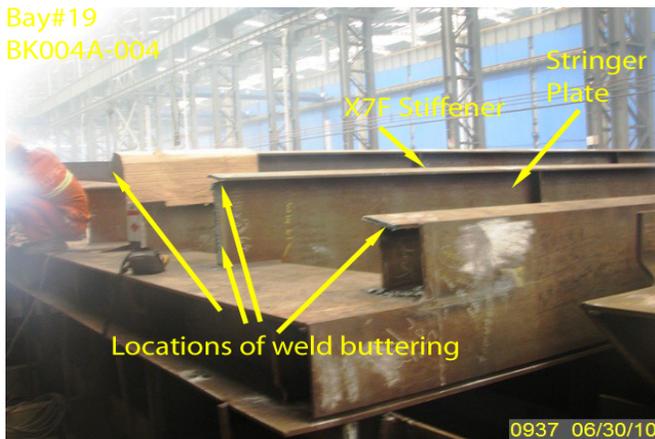
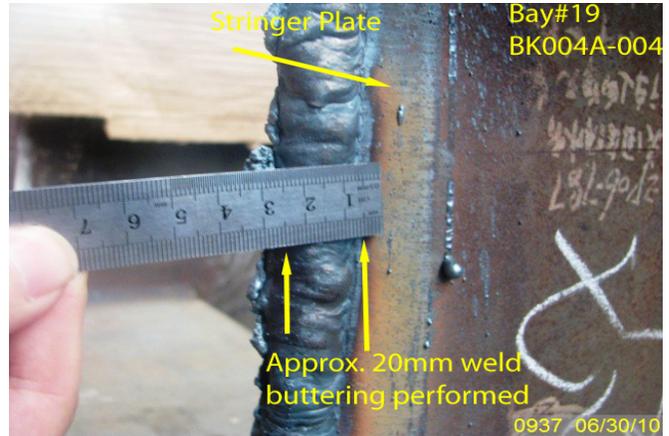
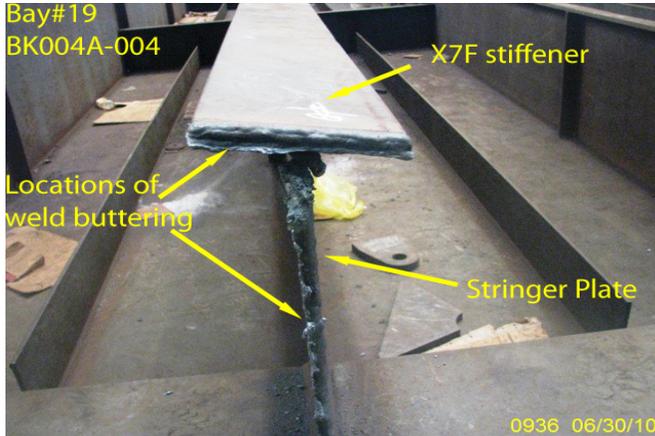
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Welder is identified as 062807 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-3G(3F)-Repair and WPS-345-FCAW-1G(1F)-Repair-1.

For further information, please see attached pictures below

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



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: Patel, Hiranch

Quality Assurance Inspector

Reviewed By: McClendon, Timothy

QA Reviewer
