

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017367**Date Inspected:** 18-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang jie**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

This QA inspector performed MT 15% of weld areas 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 Bike path. The weld designations reviewed as follows.

BK004A4-001-008,009,060,075,034,046,071,072

BK004A3-001-021,030,046,018,035,041,060,002

BK004A5-001-008

BK004A6-001-023,035,036

BK004A8-001-024,035,023

FCAW welding of weld is identified as 1G-016 of BK04A2. The welder is identified as 062808. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-L1b-F-1.

FCAW welding of weld is identified as 4G-070 of BK004A6-010. The welder is identified as 208633. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2334-Tc-P4-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld is identified as 3G-086 of BK004A8-010. The welder is identified as 058792. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 2F-090 of BK004A6-011. The welder is identified as 062904. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132 -F.

FCAW welding of weld is identified as 3F-092 of BK004A8-011. The welder is identified as 208632. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-F.

FCAW welding of weld is identified as 4G-167 of BK004A6-004. The welder is identified as 062738. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2334-B-U2-F.

During the Quality Assurance (QA) random observation of the fabrication of OBG Bike path BK004A-010, this Quality Assurance Inspector (QA) discovered the following issue:

-ZPMC welder identified as Mr. Zu Fangrun badge number identified as 208633, welding in a position in which he is not qualified.

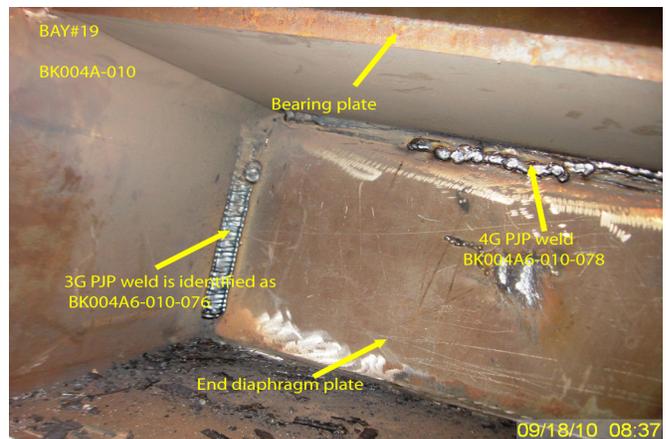
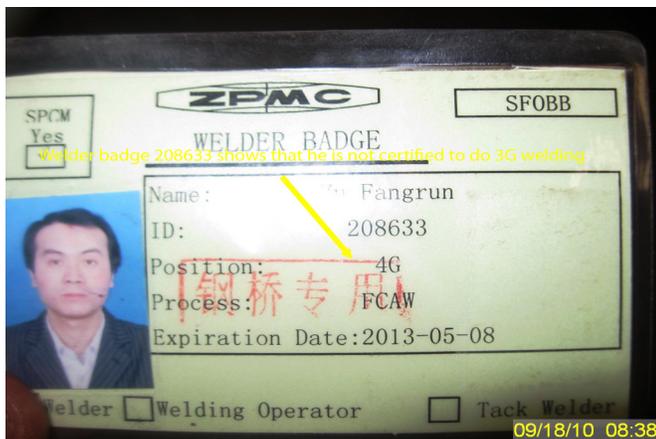
-The welder is qualified to the 4G position.

-The welder was observed by this QA welding in the 3G position.

For more information please see the Incident report

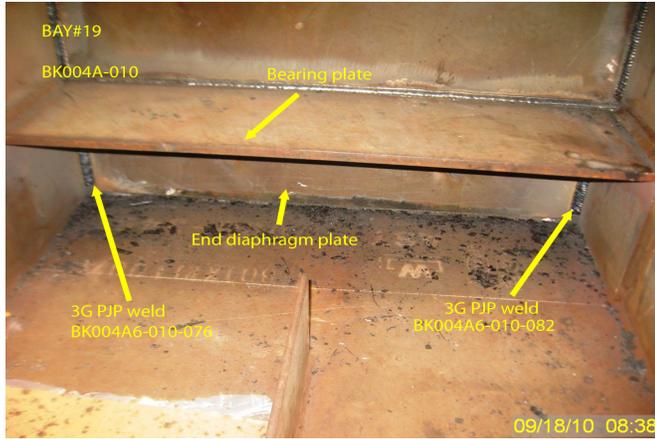
04-0120F4_TL-15_B247_09-18-10_BK004A-010_3G_welding_Not_Certified_Welder

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
