

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017384**Date Inspected:** 08-Oct-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:** 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 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

FCAW welding of weld is identified as 2G-007 of BK004A6-001 for BK004A-001. The welder is identified as 062755. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld is identified as 3G-001 of BK004A8-001 for BK005A-001. The welder is identified as 062806. ZPMC QC is identified as Mr. Guo xing hui. 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 2G-007 of BK006A6-001 for BK006A-001. The welder is identified as 062749. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld is identified as 1G-018 of BK004A2-007 for BK004A-007. The welder is identified as 062734. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1.

FCAW welding of weld is identified as 1G-016 of BK004A2-009 for BK004A-009. The welder is identified as

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062755. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1

FCAW welding of weld is identified as 3G-001 of BK006A8-001 for BK006A-001. The welder is identified as 062786. ABF QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of plug weld is identified as 2G-015 of BK004A2-012 for BK004A-012. The welder is identified as 058792. ABF QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-2-Plug.

During ZPMC MT of bike path bottom cover plate plug welds found lot of cracks as below

Weld no	total no cracks
BK004A2-011-014 (one row 63 plug welds)	10
BK004A2-011-015 (one row 63 plug welds)	32
BK004A2-011-017 (one row 63 plug welds)	15
BK004A2-011-019 (one row 63 plug welds)	30
BK004A2-011-020 (one row 63 plug welds)	20

ZPMC personnel start to grind out the cracks depth 3~5mm in depth and 50~100mm in length.

This is informed to ZPMC QC Mr.Xu tao make necessary documents before go to repair. For more information please see the attached photos.

During in process inspection it is found that fit-up of bottom cover plate with stringer plate Plug weld joints gap comes 4~8mm. ZPMC personnel using 4 ton of weight over the cover plate To make the fit-up. This bike path is identified as BK004A-012. Weld no are as follows.
BK004A2-012-014,015,017,019,020.

This QA inspector performed UT 10% of the weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A1-010-008,006
BK004A3-010-005,009
BK004A5-010-004,007
BK4ASD1-010-006,018,005,021
BK006A3-001-005,009
BK006A5-001-004,007
BK6ASD1-001-005,006,021
BK006A3-002-005,009
BK006A5-002-004,007
BK6ASD1-002-005,018,021
BK004A3-001-005,009
BK004A5-001-004,007

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BK4ASD1-001-005,006

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.

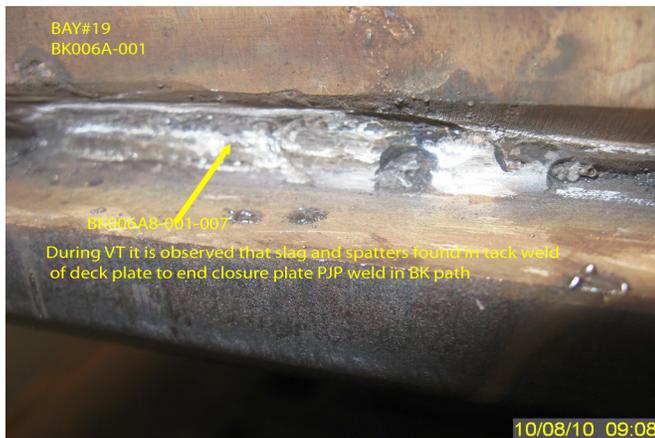
BK4ASD1-010-05,18,21

BK6ASD1-000-05,06,18

BK6ASD1-002-05,06,21

BK4ASD1-001-05,06,18,21

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 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
