

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-021615**Date Inspected:** 05-Mar-2011**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:** Geng Wei**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 Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #005 located on 13AE, SEG3007H. Welder is identified as 068091. ZPMC Quality Control (QC)

Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the

WPS-B-P-2213-B-U2-FCM-1.

Repair welding of a weld joint #018 located on 13AE, SA3066-001 as per the weld repair report # B-WR-20346.

Welder is identified as 20354. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding

variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR-1.

Weld joint #003 located on 13AE, SEG3007J. Welder is identified as 068091. ZPMC Quality Control (QC)

Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2213-B-U2-FCM-1.

Repair welding of a weld joint #004 located on 13AE, SA3067-001 as per the weld repair report # B-WR-20345. Welder is identified as 20354. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR-1.

Flux Cored Arc Welding (FCAW):

Weld joint #081 located on 13AE, SEG3007N. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #008 located on 13AE, SEG3007L. Welder is identified as 068920. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #125 located on 13AE, SEG3007L. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

BAY#13

This QA Inspector observed the following work not in compliance:

Description of Incident:

During dimensional inspection verification on deck drainage plates, this Caltrans Quality Assurance (QA) Inspector observed the following issue:

- The material thickness of 18 deck drainage plates did not comply with the approved drawings.
- According to Section B-B on approved shop drawing #DRG-1, the maximum allowed thickness is 50 mm.
- The thicknesses varied from 66mm and 80mm as measured by this QA.
- The following drainage plates are affected by this condition: 10-127-1, 10-125-3, 10-116-2, 10-116-1, 10-97-3, 10-125-4, 10-127-2, 10-93-3, 10-136-4, 12-152-3, 10-93-4, 10-136-1, 12-167-7, 12-152-2 and 10-93-1.

NOTE: 3 of the plates were inaccessible for identification. The numbers given above are stenciled on the bottom surface nearest the thickest end of the material.

- These components are located in Bay-13.

Applicable reference:

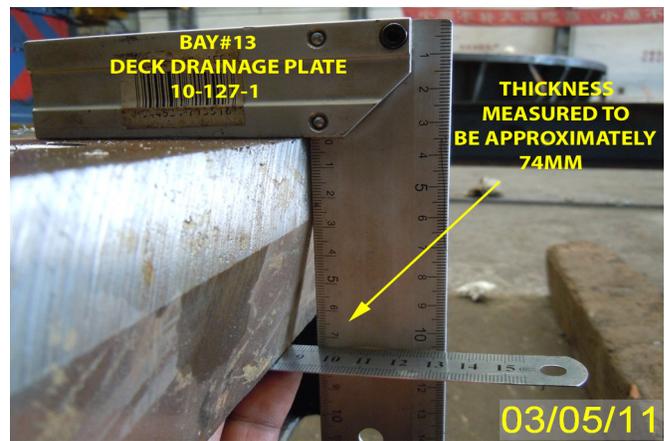
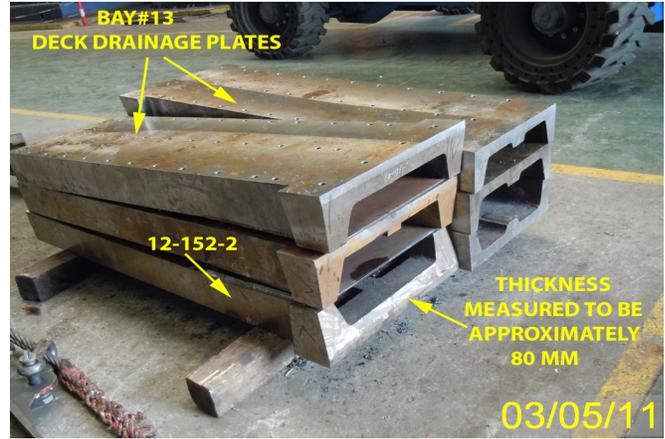
Approved shop drawing: - #DRG-1.

For further information, please see the attached pictures below.

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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer