

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-021759**Date Inspected:** 11-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:** 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 2F-005/006 of BK024A4-001 for BK0024-001. 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-2132-ESAB.

FCAW welding of weld is identified as 1G-011 of SA6031 for SA6031. The welder is identified as 067806. ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

ZPMC QC NDT MT personnel performing magnetic particle testing of BK004A-013 end closure plate PJP weld is in progress.

ZPMC QC NDT MT personnel performing magnetic particle testing of CWR locations on BK004B-001 bottom cover plate plug weld is in progress.

ZPMC personnel start their distortion repair work of Suspender bracket SB106West as per approved B-CWR2779.

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ZPMC personnel performing flame cutting to increase the cope hole size from 25mm to 35 ~40mm in size.

ZPMC personnel performing Heat straightening of suspender bracket SB106West as per approved B-CWR2779 and HSR1(B)-9955 in progress.

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

BK004B2-001-014,015,017,019,020

BK005A2-002-016,018

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



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

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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
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Reviewed By:	Patel,Hiranch	QA Reviewer
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