

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-021760**Date Inspected:** 10-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:** Li yan hua**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-003 of BK024A3-001 for BK0023-001. 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 PJP weld is identified as 1G-005 of SA6530 for SA6530. The welder is identified as 062749. 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.

FCAW welding of PJP weld is identified as 1G-029 of SA6529 for SA6529. The welder is identified as 062783. 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.

FCAW welding of weld is identified as 2F-019 of SA6029 for SA6029. The welder is identified as 062807. ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of weld is identified as 2G-015 of SA6030 for SA6030. The welder is identified as 058782.

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ZPMC QC is identified as Mr.Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 2G-026 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-2232-ESAB.

FCAW welding of weld is identified as 2F-033 of SA6531 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-2132-ESAB.

During random Quality Assurance Visual review of the Cable bracket components, this Quality Assurance Inspector (QA) discovered the following issue:

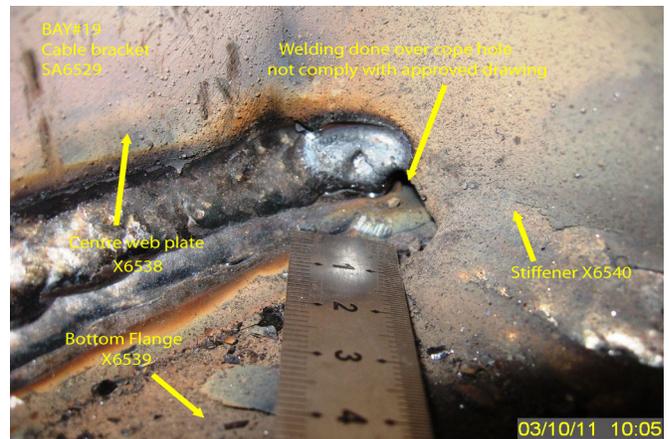
-During the Flux Cored Arc Welding (FCAW) of Cable bracket SA6529, ZPMC personal have welded over the 35mm clipped corners of sub component X6540.

-Cope holes were welded over during the Partial Joint Penetration (PJP) welding, connecting Web Plate X6538 to X6539.

For more information please see the Incident report

04-0120F4_TL-15_B247_03-10-11_SA6529_Weld_over_cope_hole.

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: Patel,Hiranch

QA Reviewer