

**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-022837**Date Inspected:** 19-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 critical weld repair of (Buttering) suspender bracket web plate is identified as X6034A for SA6031. 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-345-FCAW-1G-ESAB-Repair and B-CWR2835.

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6549A for SA6529. The welder is identified as 062783. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-1G-ESAB-Repair and B-CWR2835.

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6550B for SA6530. 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-345-FCAW-1G-ESAB-Repair and B-CWR2835.

FCAW welding of critical weld repair of (Buttering) suspender bracket web plate is identified as X6531A for SA6531. The welder is identified as 058792. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair and B-CWR2835.

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SMAW welding of weld is identified as 1G-014 of SB028-110 for SB110East. The welder is identified as 259906. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

SMAW welding of weld is identified as 1G-022 of SB027-110 for SB110 West. The welder is identified as 259566. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

FCAW welding of weld is identified as 2F-039 of BK005A1-002 for BK005A-002. 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.

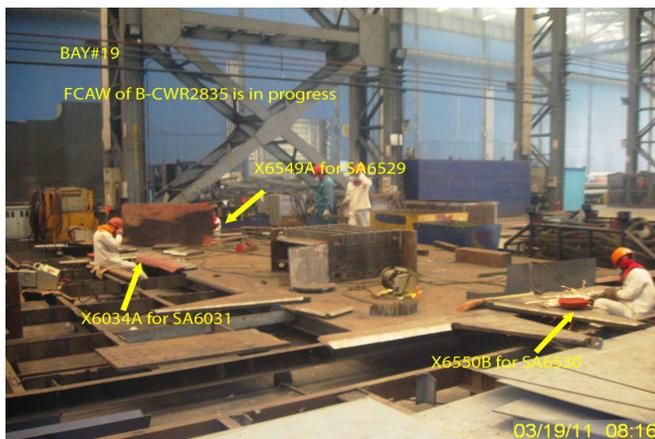
During random in process observations of Orthotropic Box Girder (OBG) Cable brackets SA6031, SA6529, SA6530 this Caltrans Quality Assurance inspector (QA) observed the following issue:

-ZPMC welding personnel performing Base metal weld repairs (Build up) without an approved Certified Welding Inspector (CWI) present for a period exceeding 30 minutes.

-This QA was present in the area from 0815 hrs to 0915 hours, during which time CWR repair welding was being performed.

For more information please see the Incident report of 04-0120F4\_TL-15\_B247\_03-19-11\_CWI\_Absence\_Bay19\_CWR.

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 remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer