

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023424**Date Inspected:** 27-Apr-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 3G-007 of SA6529-001 for SA6529. The welder is identified as 062807. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-088 of SA6529-001 for SA6529. The welder is identified as 062757. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-112 of SA6531-001 for SA6531. The welder is identified as 062739. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-010 of SA6531-001 for SA6531. The welder is identified as 062808. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 1G-022 of SA6030-001 for SA6030. The welder is identified as 062749.

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ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 3G-104 of SA6031-001 for SA6031. The welder is identified as 062806. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

ZPMC personnel performing Heat straightening of Cable bracket is identified as SA6530 as per HSR1 (B)-10329.

ZPMC personnel performing Fit-up of 25mm stiffener plate and side plate and bend side plate is in progress of following bike paths is identified as BK23A and BK25A.

This QA Inspector performed VT and MT on weld metal buttered (CWR-2877) location MT of base metal areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector performed MT without notification for inspection. The members are identified as OBG Suspender bracket.

SB108East – X64BC .

By MT found one linear transverse indication appr 15mm in length.

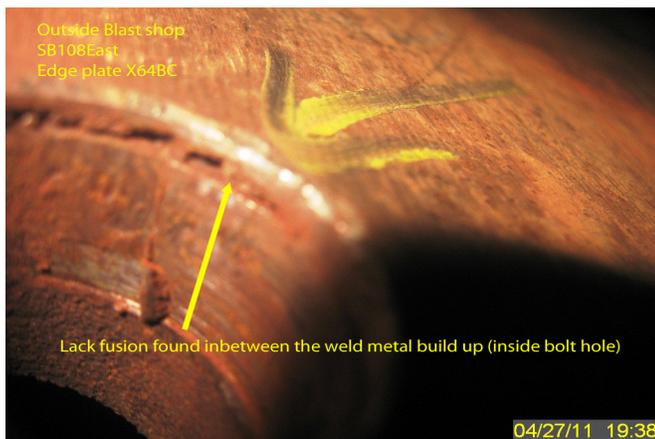
By VT found lack fusion in between weld metal build up area at bolt hole location, drilling chips found inside hole and improper bolt hole. See attached photos for more information.

This QA inspector issued green tag of following suspender brackets after Final VT and NDT completed satisfactorily.

SB110East – 15009.

SB110West – 15008.

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