

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-023414**Date Inspected:** 08-May-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-141 of SA6531-001 for SA6531. 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 2G-070 of SA6531-001 for SA6531. 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-2232-ESAB.

FCAW welding of repair weld is identified as 1G-023 of SA6029-001 for SA6029. 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-345-FCAW-1G(1F)-ESAB-Repair and B-WR20944.

FCAW welding of repair weld is identified as 1G-089 of SA6529-001 for SA6529. The welder is identified as 062749. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-Repair and B-WR20938.

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FCAW welding of repair weld is identified as 1G-007 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-345-FCAW-1G (1F)-ESAB-Repair and B-WR20939.

ZPMC personnel performing Fit-up of bearing plate with stringer plate is in progress of Bike path is identified as BK23A, BK25.

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.

BK25A7-001-130,129,140,167,168,189,190,191.

During UT repair work B-WR20946 ZPMC personnel removed the permanent Backing bar in CJP weld joint.

-After back gouging gap between web plate to top flange was measured approximately 10~15mm for a length of 400mm.

-The removed permanent backing bar and debris trapped inside the bracket.

-The weld is identified as SA6031-001-049.

-The weld is joining Web plate (X6043A) to Top Flange (X6035C).

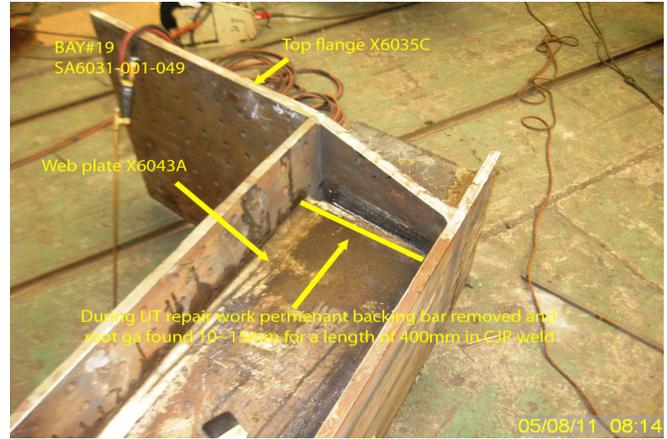
But ZPMC personnel tried and removed the debris and baking bar from inside of bracket again did the fit-up with the same backing bar. Now the root gap found 10~18mm found. See the attached photos for more information.

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