

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-016822**Date Inspected:** 04-Sep-2010**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 / Wang jie**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

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 Suspender bracket. The weld designations reviewed as follows.

SB78W

SB016-078-025,031,043,067,011,018,001,004,005,007,012,032.

ZPMC personnel performing Heat straightening of Bike path stringer plate to bearing plate as per approved HSR1 (B)-8700.

BK004A- 011-017,018,034,035.

BAY#14

SAW welding of weld joint 1G-005 located on PCMK SEG3013AE of Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

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FCAW welding of weld joint 2F-165 located on PCMK CA3015B of Segment 13BW the welder is identified as 201215. ZPMC QC is identified as Mr. Xia chun hui The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

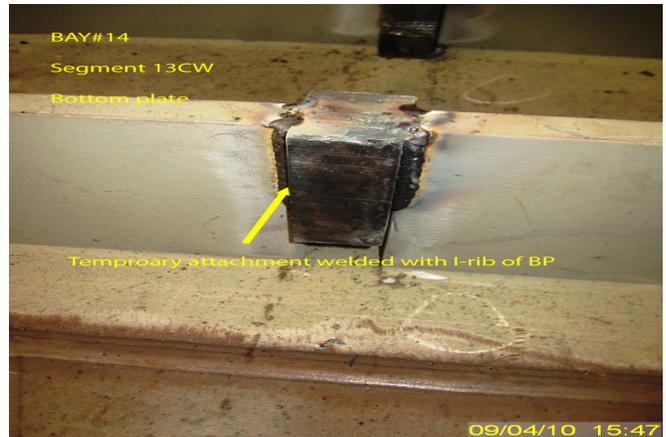
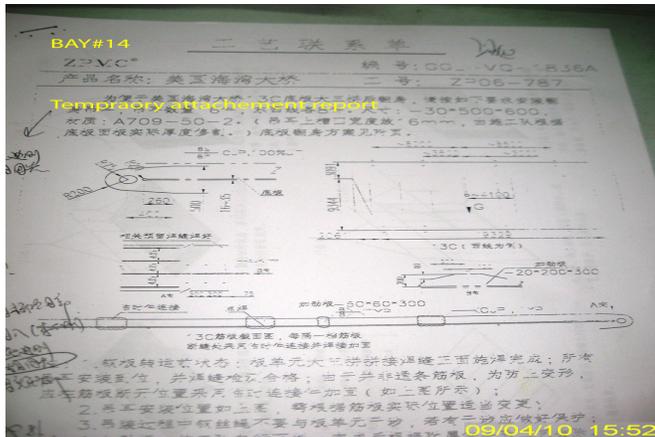
FCAW welding of weld joint 3F-069 located on PCMK CA3016A of Segment 13BW the welder is identified as 047866. ZPMC QC is identified as Mr. Xia chun hui The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

Without any Engineer Approval temporary attachments welded to the I-ribs of Bottom plate in segment 13CW. See the attached photos.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Segment 11AW Interior bottom plate, side plate and longitudinal diaphragm surfaces at the panel point 97 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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:	McClendon,Timothy	QA Reviewer
