

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-017366**Date Inspected:** 17-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:** 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 Bike path. The weld designations reviewed as follows.

BK006A6-001-024,036

BK006A8-001-023,035

BK006A3-001-010

BK006A5-001-005

BK006A4-001-009,023,075,034,049

BK006A4-001-019,030,045,056,071

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A1-004-006

FCAW welding of weld is identified as 4G-008 of BK04A1-002. The welder is identified as 260562. ZPMC QC is

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identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2234-B-U2-F.

FCAW welding of weld is identified as 1G-018 of BK04A2. The welder is identified as 62808. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-L1b-F-1.

FCAW welding of weld is identified as 2F-025 of BK004A3-014. The welder is identified as 062738. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

FCAW welding of weld is identified as 2F-040 of BK004A4-014. The welder is identified as 062761. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

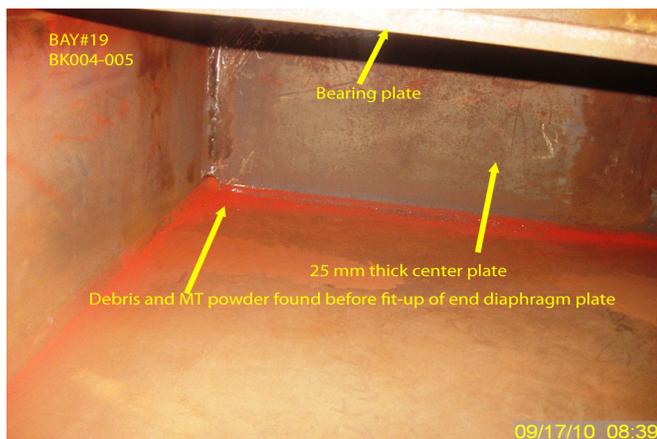
FCAW welding of critical repair weld is identified as 4F-036 of BK004A8-008. The welder is identified as 259566. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-4F-Repair and B-CWR27940.

FCAW welding of weld is identified as 3G-076 of BK004A6-011. The welder is identified as 062904. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-Tc-P4-F.

FCAW welding of weld is identified as 3F-060 of BK004A8-011. The welder is identified as 208632. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133.

ZPMC personnel performing fit-up of intermediate stiffener is identified as BKX11E, BKX11F With Deck plate and bearing plate is in progress. Prior to fit-up they do their cleaning.some location the miss MT powder and debris informed to ZPMC QC Mr. Wang jie to perform cleaning and Visual inspection prior to Fit-up.

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
