

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-017369**Date Inspected:** 21-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**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 2G-031 of SB020-090 for SB90E. The welder is identified as 062749. ABF QC is identified as Mr.Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-22321Tc-U4b-F.

FCAW welding of weld is identified as 2G-055 of SB020-088 for SB88E. The welder is identified as 062783. ABF QC is identified as Mr.Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-22321Tc-U4b-F.

FCAW welding of weld is identified as 2G-043 of SB020-086 for SB86E. The welder is identified as 062762. ABF QC is identified as Mr.Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-22321Tc-U4b-F.

FCAW welding of weld is identified as 2F-026 of SB017-088 for SB88W. The welder is identified as 062752. ABF QC is identified as Mr.Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-F.

FCAW welding of weld is identified as 2F-012 of SB017-086 for SB86W. The welder is identified as 062786.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ABF QC is identified as Mr. Peng wen jun . The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-F

FCAW welding of weld is identified as 3G-082 of BK004A6-003 for BK004A-003. 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-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 2F-072 of BK004A8-003 for BK004A-003. The welder is identified as 062755. 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.

FCAW welding of weld is identified as 2F-052 of BK005A2-003 for BK005A-002. The welder is identified as 062738. 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.

FCAW welding of weld is identified as 2G-164 of BK004A6-012 for BK004A-012. The welder is identified as 062808. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

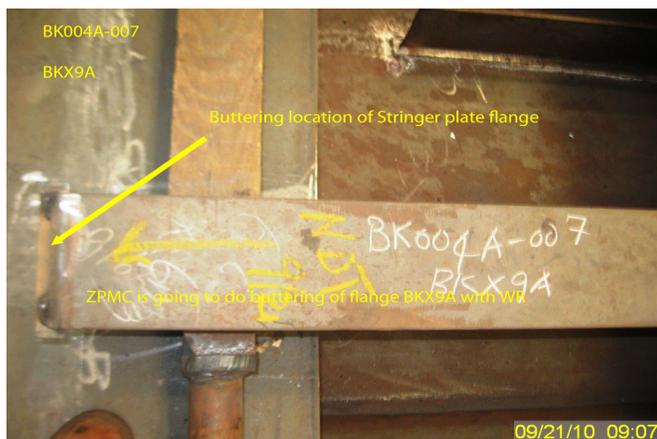
ZPMC need welding repair (WR) report to perform buttering of stringer plate flange is identified as BKX9A of Bike path BK004A-007. This is informed to ZPMC QC MR. Xu tao.

BLAST SHOP # 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Segment 11CW Interior Upper side deck panel, floor beam and corner assembly surfaces in between the panel point 101 to 103.5 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.

3 aligned porosity of 3mm in size found at CSD2-PP103.5-017 @ CW side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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