

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-018310**Date Inspected:** 25-Nov-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:** Sha Zhi**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 1G-003 of BK005A3-002 for BK005A-002. The welder is identified as 062732. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld is identified as 1G-008 of BK005A5-002 for BK005A-002. The welder is identified as 062761. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld is identified as 3G-007 of BK005A5-002 for BK005A-002. 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-2333-Tc-P4-F.

ZPMC has changed joint design CJP to PJP of above mentioned weld joint BK005A5-002-007 of BK005A-002 as per new approved WD. But they wrongly did welding on both sides of the PJP weld joint. This is informed to ZPMC QC Mr. Guo xing hui. For more information please see the attached photos.

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FCAW welding of weld is identified as 2F-045 of BK004B4-001 for BK004B-001. The welder is identified as 208641. 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 3G-003 of SB025-108 for SB108E. The welder is identified as 062762. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

ZPMC personnel performing hand torch preheating up to 140 deg C before go for FCAW Welding of BK005A3-002-043 of BK005A-002. See the attached photos.

ZPMC personnel performing Heat straightening of Bike path is identified as BK004A-013 The weld no is identified as BK004A2-013-016,018 is appeared to comply with HSR1 (B)-9501.

This QA inspector performed VT of BK004A -006 internal weld areas and internal cleaning previously tested and accepted by ZPMC Quality Control personnel. Areas requiring additional grinding and cleaning 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: Patel,Hiranch

QA Reviewer