

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-018507**Date Inspected:** 05-Dec-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

ZPMC welding personnel started to use ESAB flux cored wire for bike path production welds. The bike path is identified as BK004B-001.

FCAW welding of weld is identified as 2G-080 of BK004B6-001 for BK004B-001. The welder is identified as 0627332. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 3G-076 of BK004B6-001 for BK004B-001. The welder is identified as 062739. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 4G-088 of BK004B6-001 for BK004B-001. The welder is identified as 208641. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2234-ESAB.

FCAW welding of weld is identified as 3G-092 of BK004B8-001 for BK004B-001. The welder is identified as 062739. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 4G-078 of BK004B8-001 for BK004B-001. The welder is identified as 208641. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2234-ESAB.

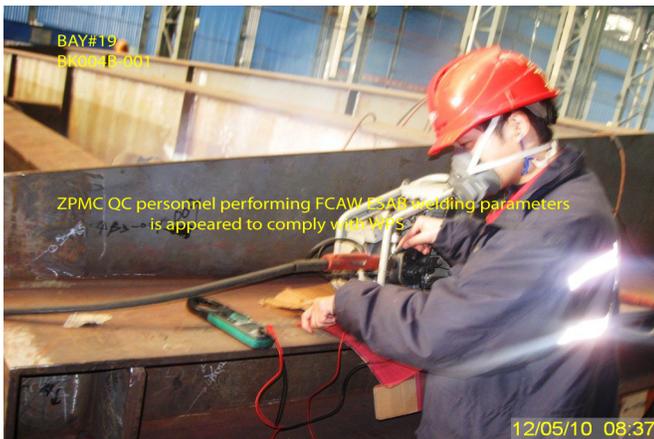
FCAW welding of weld is identified as 2G-100 of BK004B8-001 for BK004B-001. The welder is identified as 062732. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

ABF QC MT personnel performing MT on bike path fillet welds, the bike path is identified as BK004A-013 is in progress.

SMAW welding of critical weld repair weld is identified as 2F-061 of SB018-096 for SB96W. The welder is identified as 259353. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2F-Repair and B-CWR2325.

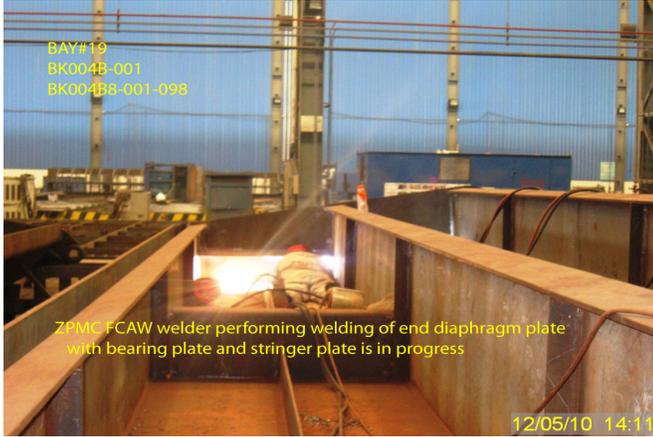
ZPMC personnel performing air carbon arc gouging of fillet weld is identified as BK004A7-014-079/080 due to excess root gap observed during fit-up, but ZPMC performed welding so now They convert fillet weld into CJP as per RFI submittal 200R2 and B-JC106R0.

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:	Patel,Hiranch	QA Reviewer
