

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-018509**Date Inspected:** 03-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

SMAW welding of 2 time repair weld is identified as 4G-021 of BK5ASD1-002 for BK005A-002. 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-4G-Repair and B-WR18035.

ZPMC personnel performing fit-up of closure box side plate in progress of BK004A-013.

ABF QC MT personnel performing MT on bike path fillet welds, the bike path is identified as BK004A-014 in progress.

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 suspender bracket. The weld designations reviewed as follows.

SB025-108-003,004.

SB024-108-003,004.

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. S. Manjunath.

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Math. on the Bike Path bottom panel for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Bike Path is identified as:

BK004A-001; 010; 003 and 008

The QA Inspector measured the flatness using 600mm long straight edge and observed flatness dimensions out of allowable tolerance.

Report was generated and submitted to Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

BAY#16

FCAW welding of weld is identified as 2F-059 of W5-SB1-076 forSB076. The welder is identified as 069712. 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-029 of W5-SB1-075 forSB075. The welder is identified as 201879. 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-106 of W5-SB1-085 forSB085. The welder is identified as 208995. 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.

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



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

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your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer