

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-018625**Date Inspected:** 15-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

FCAW welding of weld is identified as 1G-044 of BK004A1-014 for BK004A-014. The welder is identified as 062808. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

SMAW welding of critical repair weld is identified as 2F-041,054,065 of SB018-098 for SB98W. The welder is identified as 062814. 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-CWR2475.

SMAW welding of critical repair weld is identified as 3F-026,028 of BK004A8-014 for BK004-014. The welder is identified as 062814. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-3F-Repair and B-CWR2474.

SMAW welding of critical repair weld is identified as 4F-129,037 of BK004A8-014 for BK004-014. The welder is identified as 062814. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-4F-Repair and B-CWR2474.

ZPMC personnel performing Heat straightening of bike path deck plate end is in progress. The bike path is

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identified as BK005A-002 is appeared to comply with HSR1 (B)-09894.

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.

BK4A-060-MEP-005,006
BK4A-061-MEP-017,018
BK4A-062-MEP-011,012
BK4A-063-MEP-008,009
BK4A-064-MEP-014,015
BK4A-059-MEP-021,020
BK4A-058-MEP-008,009
BK4A-057-MEP-002,003
BK4A-056-MEP-017,018
BK4A-055-MEP-005,006
BK4A-054-MEP-002,003
BK005A8-002-061,065,076,082,086,092,096,102,063,080,090
BK005A6-002-061,065,076,082,086,092,096,102,063,080,090,100
BK005A8-002-121,123,126,038,122,124,006,009,027,039,003,005,010
BK005A6-002-125,026,038,129,122,127,004,025,027,037,039,008,010

During Quality Assurance random in-process observations of the fabrication of OBG Lift 11 Suspender brackets SB108E, this Caltrans Quality Assurance (QA) inspector discovered the following issue:

- The joint design of Three (3) complete joint penetration weld joints do not comply with the weld details specified on the approved shop drawing.
- According to the approved weld details drawing, the bevel is on the arrow side.
- ZPMC personnel prepare the bevel face on the other side of the arrow.

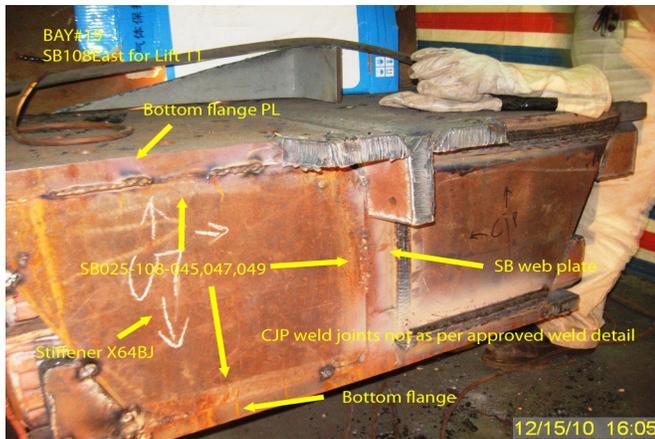
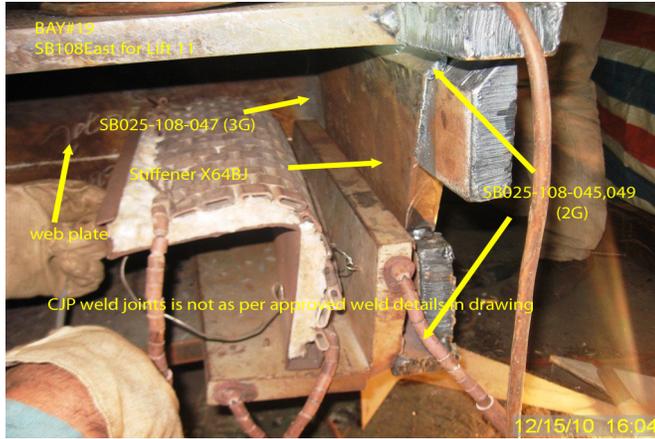
For more information please see the incident report

04-0120F4_TL-15_B247_12-15-10_ift11_SB108E_CJP_welds_not_as_per_weld_details

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