

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-019118**Date Inspected:** 29-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 repair weld is identified as 1G-004 of SB022-106 for SB106 West. The welder is identified as 037996. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and WR19242.

SMAW welding of repair weld is identified as 1G-004 of SB023-106 for SB106 East. The welder is identified as 067520. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and WR19295.

SMAW welding of repair weld is identified as 1G-018 of SB025-108 for SB108 East. The welder is identified as 259906. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and WR19498.

SMAW welding of repair weld is identified as 1G-014 of SB024-108 for SB108 West. The welder is identified as 259566. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and WR19513.

FCAW welding of repair weld is identified as 3G-005 of SB023-104 for SB104 East. The welder is identified as

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062761. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and R19285.

SMAW welding of weld is identified as 4F-100,105 of BK004A4-013 for BK004A-013. The welder is identified as 202338. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2114-FCM-1.

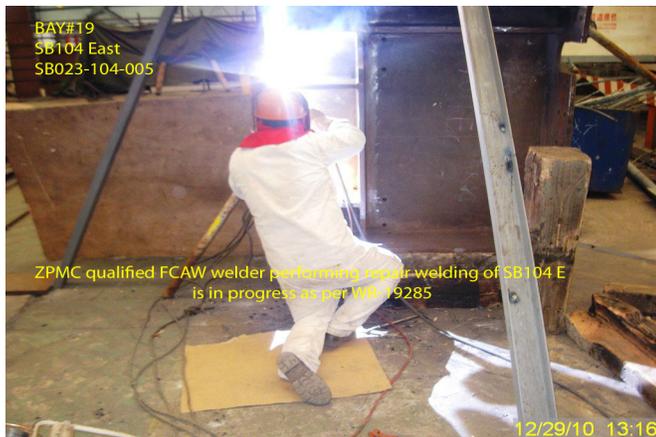
During the Quality Assurance (QA) random observation of the fabrication of OBG Suspender bracket SB108East, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC welder identified as Mr. Sun Chengzhuo badge number identified as 259906, repair welding in a position in which he is not qualified.
- The welder is qualified to the 4G (SMAW) position.
- The welder was observed by this QA repair welding in the 2G position.

For more information please see the Incident report

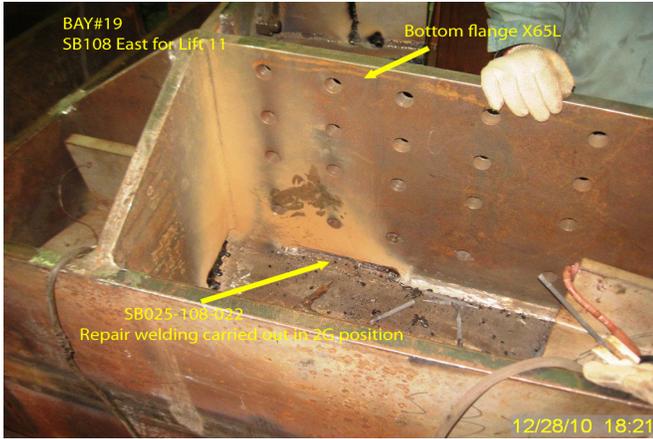
TL-15_B247_12-29-10_SB108_East_2G_Repair_welding_Not_Certified_Welder

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