

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-019119**Date Inspected:** 28-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 2G-013 of SB022-106 for SB106 West. The welder is identified as 066155. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and WR19245.

SMAW welding of repair weld is identified as 2G-023 of SB022-106 for SB106 West. The welder is identified as 067707. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and WR19247.

SMAW welding of repair weld is identified as 2G-006 of SB023-106 for SB106 East. The welder is identified as 066416. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and WR19297.

SMAW welding of repair weld is identified as 1G-005 of SB023-106 for SB106 East. The welder is identified as 066002. 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 WR19296.

SMAW welding of repair weld is identified as 1G-001 of SB024-108 for SB108 West. The welder is identified as

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259566. 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 WR19510.

SMAW welding of repair weld is identified as 1G-001 of SB025-108 for SB108 East. The welder is identified as 259906. 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 WR19496.

FCAW welding of repair weld is identified as 3G-005 of SB022-104 for SB104 West. The welder is identified as 058792. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and R19488.

FCAW welding of repair weld is identified as 3G-029 of SB023-104 for SB104 East. 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-345-FCAW-3G-ESAB-Repair and WR19291.

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.

BK004B2-001-016,018.

BK004A2-013-016,018.

During the Quality Assurance (QA) random observation of the fabrication of OBG Bike path BK004A-013, this Quality Assurance Inspector (QA) discovered the following issue:

-ZPMC welder identified as Mr. Hou benli badge number identified as 062752, welding in a position in which he is not qualified.

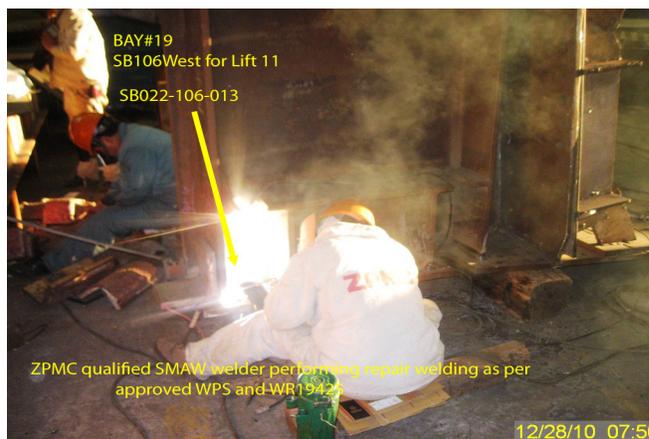
-The welder is qualified to the 3G (FCAW) position.

-The welder was observed by this QA welding in the 4F position.

For more information please see the Incident report

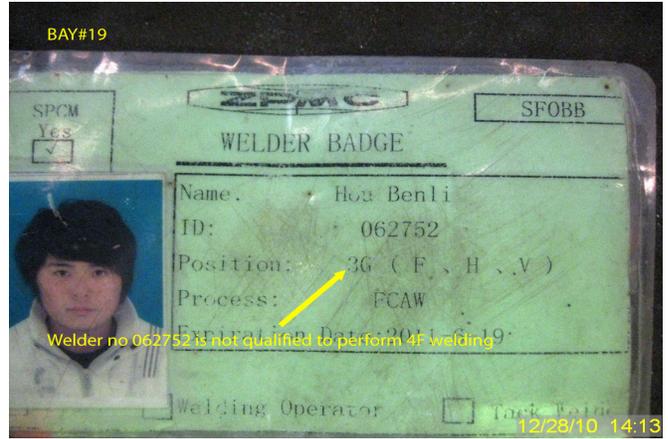
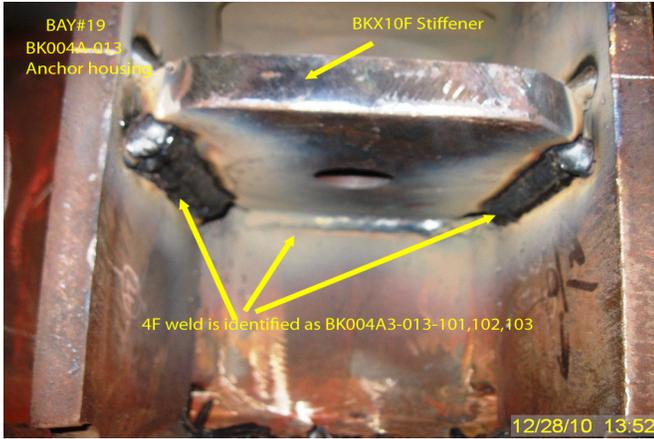
04-0120F4_TL-15_B247_12-28-10_BK004A-013_4F_welding_Not_Certified_Welder.

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