

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-019127**Date Inspected:** 19-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 4G-044 of BK004A1-013 for BK004A-013. 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-4G-Repair and B-WR19209.

SMAW welding of critical repair weld is identified as 1G-014,105,017 of BK004A2-006 for BK004A-006. 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(1F)-Repair and B-CWR2508.

ABF QC MT personnel performing MT of Suspender bracket bottom bearing plate fillet welds is identified as SB98W, SB98E and 102W.

While ZPMC personnel performing UT of Lift 11 suspender brackets is identified as SB104E,W and SB106E,W found 100% rejection of welds. Some of the weld joints repair found entire length of the weld joints. For more information please see the attached photos.

ZPMC personnel performing Heat straightening of deck plate ends of bike path is identified as BK004A-014 is appeared to comply with HSR1 (B)-9311.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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.

BK004A6-013-150,151,159,128,004,006,025,027,003,005,010,082,086,096,090,100,078,088

BK004A8-013-121,126,038,129,004,009,037,003,005,010,082,086,096,102,080,090,078,

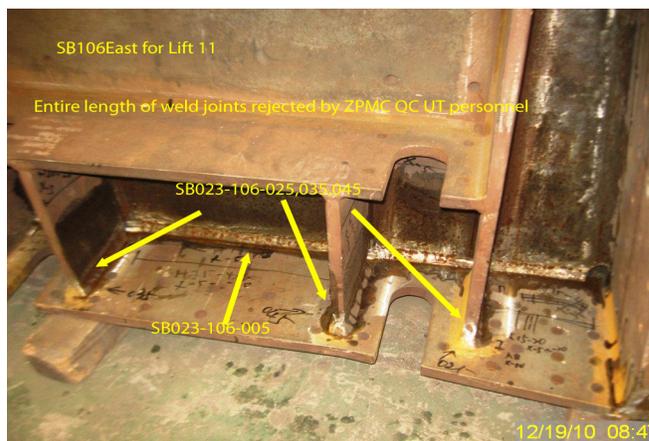
BK004B6-001-150,151,159,128,004,006,011,039,003,008,010

BK004B8-001-123,125,126,028,038,129,004,009,037,039,005

BK004A6-014-150,151,155,125,161,152,157,006,011,025,037,010

BK004A8-014-123,126,028,038,122,004,011,027,039,003,008

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer