

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-019328**Date Inspected:** 15-Jan-2011**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:** Li yan hua**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 critical repair (R3) weld is identified as 1G-004 of SB023-106 for SB106 East. The welder is identified as 066418. 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 CWR-2747.

SMAW welding of critical repair (R4) weld is identified as 1G-001 of SB025-108 for SB108 East. The welder is identified as 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 CWR-2731.

ABF QC NDT MT personnel performing MT of suspender bracket Step 1 and 2 SB108 West is in progress.

ZPMC QC NDT UT personnel performed UT of fourth time repair welds on suspender bracket SB104 west, they found reject able indications (fifth time). The welds are identified as SB022-104-002,004,005. ZPMC need to make CWR to go before repair work informed to ZPMC QC Mr.Guo xing hui.

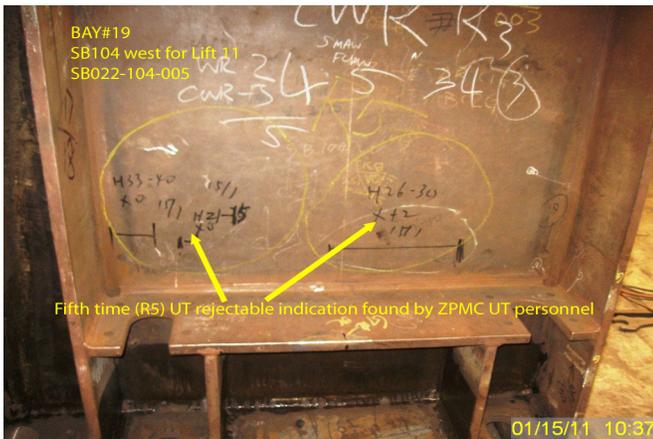
ZPMC personnel pre-heat up to 60 deg temperature before back gouging of SB104West. The welds are identified as SB022-104-002,004,005.

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ZPMC QC NDT UT personnel performed UT of third time repair welds on suspender bracket SB106 west, they found reject able indications (fourth time). The welds are identified as SB022-106-004,005. ZPMC need to make CWR to go before repair work informed to ZPMC QC Mr.Guo xing hui.

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 your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer