

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-022817**Date Inspected:** 13-Apr-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

ZPMC QC NDT UT personnel performing UT of suspender bracket SB110 East R1 repair welds is in progress.

During their UT they found R2 reject able indication on following welds

SB027-110-014,022,055.

ZPMC QC NDT MT personnel performing MT of stringer plate to deck plate fillet welds is in progress of bike path is identified as BK023A-001.

During in process visual inspection it is found that fit-up of stringer plates vertical stiffener is identified as BKX96 of stringer plates BKX100C is connecting the top plate of bike path BK0024A-001, the fillet weld root gap is measured more than 5mm. the weld joint is identified as BK024A4-001-180/181 and 182/183. This is marked near by the weld joint and informed to ZPMC QC Mr.Guo xing hui for change of joint configuration approval from engineer.

This QA inspector performed Flatness check of Edge plate of suspender bracket SB110West along with ABF QC Mr.Peng wen jun. measured dimension recorded is appeared to comply with

Project contract requirement.

Flatness measured: Min =0mm and Max=2mm.

ZPMC qualified SMAW welder is identified as 259653 performing tack welding of fit-up for traveler rail support

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(TB3001) for Bike path is checked with ZPMC QC Mr.Li ping is appeared to comply with WPS-B-P-2112.

ZPMC grinding personnel performing grinding on weld metal build up of suspender bracket is identified as SB108East is in progress as per B-CWR2877. Before grinding following details are measured and recorded for future reference along with ZPMC QC Mr.Guo xing hui as follows

Length of build up =1100mm

Width of build up =550mm

Thickness of build up= 2 ~6mm.

Green tag issued for (STEP-12) following bike paths after NDT and dimensional inspection carried out successfully.

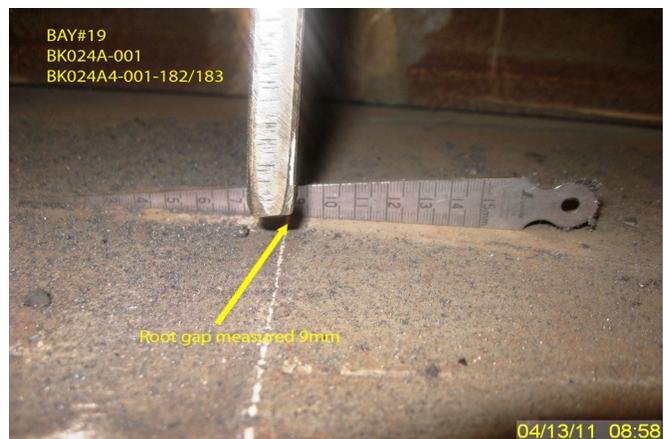
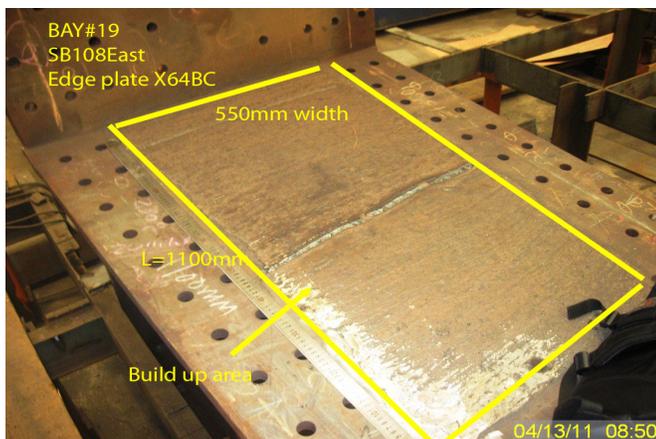
BK004A-014 -014895.

BK004A-013 -014894.

BK005A-002 -014897.

BK004B-001 -014900.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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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
