

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-022818**Date Inspected:** 12-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

SMAW welding of critical repair weld (Buttering) on Edge plate X664BC for SB108 East. The welder is identified as 259566. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-CWR2877.

SMAW welding of repair weld is identified as 1G-051 of SB027-110 for SB110 East. The welder is identified as 259066. ZPMC QC is identified as Mr. Li ping. The welding variables -Repair and recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-WR20645.

SMAW welding of repair weld is identified as 1G-035 of SB027-110 for SB110 East. The welder is identified as 259066. ZPMC QC is identified as Mr. Li ping. The welding variables -Repair and recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-WR20645.

ZPMC QC NDT UT personnel performing UT of suspender bracket SB110 West R1 repair welds is in progress. 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 BKX99A is connecting the top plate of bike path BK0024A-001, the fillet weld root gap is

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measured more than 5mm. the weld joint is identified as BK024A4-001-142/143 and 164/165. This is marked near by the weld joint and informed to ZPMC QC Mr.Li ping for change of joint configuration approval from engineer. 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.

BK25A2-001-012,013

BK25A6-001-033,034,088,093,156,157

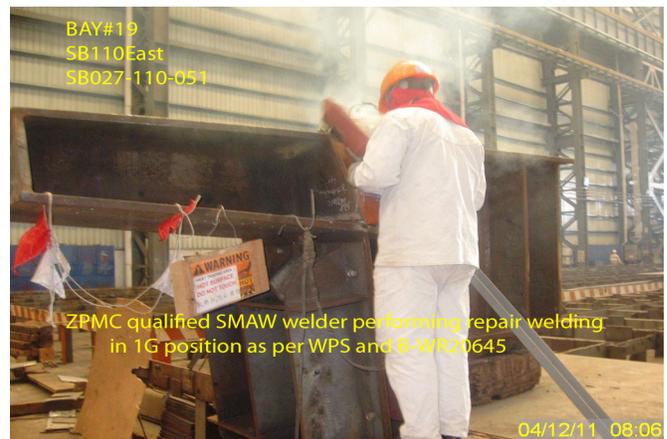
BK25A3-001-003,002,015,016

BK25A6-001-029,030,036,089,090,159

BK24A4-001-011,004,006,014

BK24A6-001-041,042,095,081,119,239,046,083,130,233

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

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your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer