

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-022819**Date Inspected:** 10-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

FCAW welding of weld is identified as 1G-041 of SA6531-001 for SA6531. The welder is identified as 062783. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 2G-127 of SA6531-001 for SA6531. The welder is identified as 062749. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

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. Guo xing hui. 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-014 of SB027-110 for SB110 East. The welder is identified as 259066. ZPMC QC is identified as Mr. Guo xing hui. The welding variables -Repair and recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-WR20645.

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ZPMC QC NDT UT personnel performing UT of suspender bracket SB110 West. During their UT they found reject able indication on the following welds. This is the first time repair (R1).

SB26-110-014,022,001.055,011,026.

ZPMC personnel performing heat straightening of cable bracket is identified as SA6529 is in progress.

ZPMC personnel performing Fit-up and drilling of bearing plate is identified as X65A/B and X65AF2/F4 for suspender bracket is identified as SB106E/W in progress.

ZPMC personnel performing Fit-up of stringer plate with Deck plate is in progress of Bike path BK024A-001.

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