

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-022821**Date Inspected:** 08-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 3G-089 of SA6529-001 for SA6529. The welder is identified as 058792. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 2F-019 of SA6529-001 for SA6529. The welder is identified as 058792. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

FCAW welding of repair (R2) weld is identified as 3G-016 of SA6530-001 for SA6530. 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-345-FCAW-2G-ESAB-Repair and B-WR120624.

FCAW welding of weld is identified as 2F-016 of BK025A3-001 for BK25A-001. 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-2132-ESAB.

ZPMC QC NDT MT personnel performing MT of bike path stringer plate BK24A-001 fillet weld is in progress.

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ZPMC QC NDT MT personnel performing MT on critical weld repair location of cable bracket is identified as SA6531 and SA6031 web plates is appeared to comply with the approved CWR is identified as B-CWR-2835.

ZPMC QC NDT MT personnel performing MT of cable bracket SA6531 welds is in progress.

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 Cable bracket. The weld designations reviewed as follows.

SA6530-001-107,087,090,080.

SA6031-001-083,087,090,080.

SA6531-002-118,119,121,125,122,123,126.

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