

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-022825**Date Inspected:** 02-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 repair weld is identified as 3G-137 of SA6030-001 for SA6030. The welder is identified as 062783. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and B-WR20557.

FCAW welding of repair weld is identified as 3G-137 of SA6029-001 for SA6029. The welder is identified as 062749. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and B-WR20556.

ZPMC personnel performing Heat straightening of Cable bracket is identified as SA6529 in progress as per HSR1 (B)-10216.

ZPMC personnel performing grinding of cable bracket is identified as SA6529 is in progress is appeared to comply with contract document.

ZPMC QC NDT UT personnel performing UT of cable bracket is identified as SA6530. During their UT they found reject able indications (R2) on weld as follows

SA6530-001-106

ZPMC QC NDT UT personnel performing UT on base metal buttered location of cable bracket web plate is

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identified as X6041A/B , X6042A/B for SA6029 and SA6030 in progress as per B-CWR2835.

This QA inspector performed joint dimensional inspection of flatness check with ABF QA Mr. Peng wen jun on Suspende bracket SB106 East, West and SB108 East after critical weld repair (CWR) and Heat straightening carried out. See the attached photos.

Flatness check of edge plate	Min	Max
108East		
X-axis	0	4
Y-axis	0	3
106East		
X-axis	0	3
Y-axis	0	4
106West		
X-axis	0	6.5
Y-axis	0	8.5

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



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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
