

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-022826**Date Inspected:** 01-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 2G-086 of SA6530-001 for SA6530. The welder is identified as 062808. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-ESAB-Repair.

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 SA6029 is in progress is appeared to comply with contract document.

ZPMC QC NDT UT personnel performing UT of cable bracket is identified as SA6530, SA6030 and SA6029.

During their UT they found reject able indications (R1) on weld as follows

SA6530-001-105,106.

SA6030-001-137.

SA6029-001-137.

ZPMC QC NDT MT personnel performing MT of cable bracket is identified as SA6031 weld is in progress.

During their MT they found linear reject able indications on welds as follows

SA6031-001-089 / Y=240mm, Length =15mm & Y=400 , L=10mm.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SA6031-001-056 / Y=840mm, Length=12mm & Y=230, L=10mm.

These locations marked on nearby weld and informed to ZPMC QC Mr. Li ping to make CWR before go to perform repair.

ZPMC personnel performing carbon arc air gouging on UT repair location SA6530 is in progress.

This QA inspector performed joint dimensional inspection flatness check with ABF QA Mr. Peng wen jun on Suspender bracket SB104East and West which already painted. Measured distortion more than 2mm on some location. This is informed to CT engineer for review and further action. See the attached photos.

SB104East – distortion 3~5mm.

SB104West – distortion 2~4mm.

This is QA inspector performed the dimension of the Suspender bracket SB104 East and west cable hole diameter (in mm) as follows. See the attached photos.

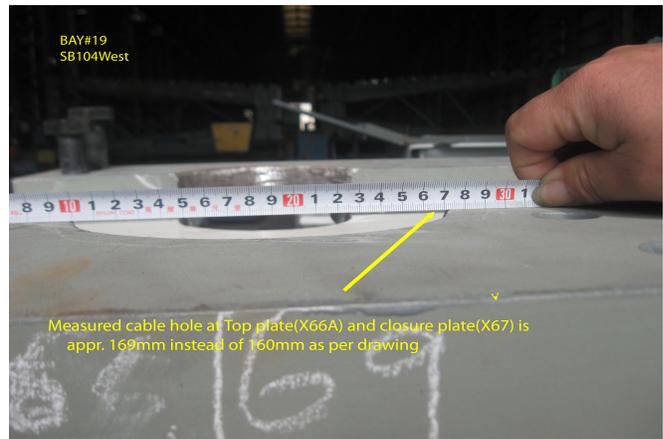
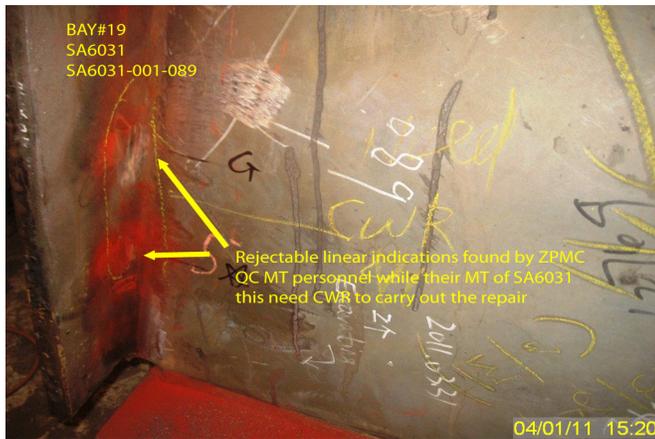
SB104 East

	Min	Max	Required
Top plate (X66A) -	165	166	160
Middle plate (X64C)-	100	105	100
Bottom plate (X64BA)-	104	106	100

SB104 West

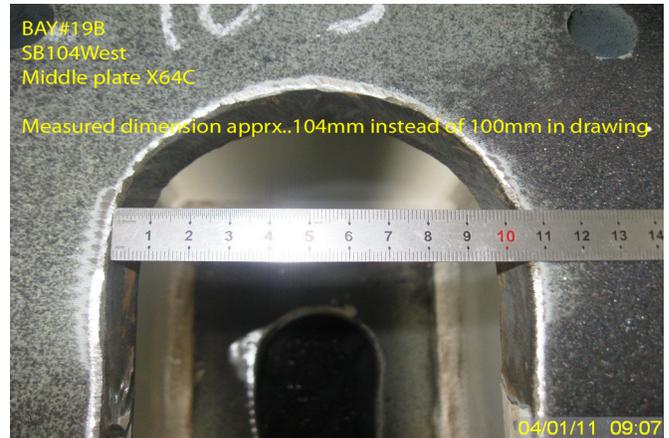
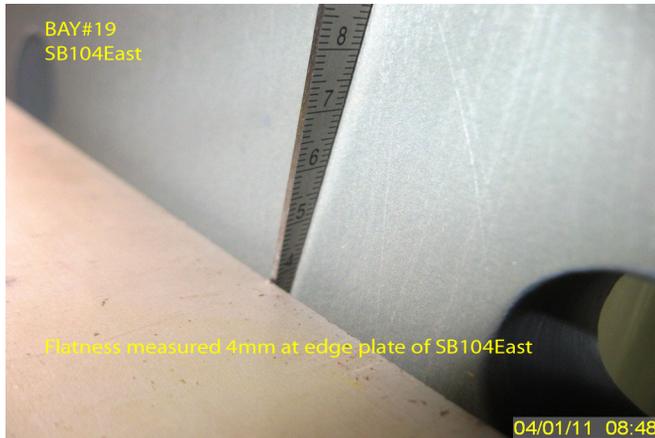
	Min	Max	Required
Top plate (X66A) -	164	169	160
Middle plate (X64C)-	102	104	100
Bottom plate (X64BA)-	100	106	100

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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