

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-022827**Date Inspected:** 31-Mar-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-137 of SA6029-001 for SA6029. The welder is identified as 058792. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-ESAB.

SMAW welding of repair weld is identified as 2G-089 of SA6031-001 for SA6031. 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-2G-Repair and B-WR20548.

ZPMC personnel performing Heat straightening of Cable bracket is identified as SA6530 in progress as per HSR1 (B)-10223.

ZPMC personnel performing grinding of cable bracket is identified as SA6030 is in progress as per contract document.

ZPMC While performing UT of cable bracket is identified as SA6031-001-056,087 they found reject able indications they make WR20535 (R2) for further repair.

ZPMC QC personnel performing Flatness checking of edge plate of suspender bracket is identified as SB106 East and SB106 West, they measured distortion is more that 2mm to 6mm is not appeared to comply with project specification.

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Back gouging of cable bracket UT reject able location is in progress the cable bracket is identified as SA6031-001-089,056

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