

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-022831**Date Inspected:** 26-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:	Sha Zhi	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

SMAW welding of weld is identified as 1G-022 of SB027-110 for SB110East. The welder is identified as 259906. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

SMAW welding of weld is identified as 1G-014 of SB026-110 for SB110 West. The welder is identified as 259956. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4b-1.

FCAW welding of weld is identified as 3G-089 of SA6530-001 for SA6530. The welder is identified as 062806. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 2G-118 of SA6531-001 for SA6531. 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-B-T-2232-ESAB.

ZPMC personnel performing Heat straightening of Cable bracket is identified as SA6030 in progress as per HSR1

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(B)-10223.

ZPMC QC NDT UT personnel performing Re Ultrasonic testing of bike path deck plate weld after heat straightening is identified as BK004B1-001-009.

ZPMC grinding personnel performing grinding of cable bracket is identified as SA6031, SA6029, SA6530 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 Bike path. The weld designations reviewed as follows

BK023B-001-026,027,053,055,022,051,052,066

BK023C-001-023,051,055,075,077,020,021,049,074,090,093

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