

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-022833**Date Inspected:** 24-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-001 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-001 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-2214-Tc-U4b-1.

FCAW welding of weld is identified as 1G-116 of SA6030-001 for SA6030. 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-B-T-2231-ESAB.

FCAW welding of weld is identified as 3G-102 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-B-T-2233-ESAB.

FCAW welding of weld is identified as 2G-064 of SA6029-001 for SA6029. The welder is identified as 062783.

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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.

FCAW welding of weld is identified as 1G-088 of SA6031-001 for SA6031. The welder is identified as 062807. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-ESAB.

FCAW welding of weld is identified as 3G-003 of SA6531-001 for SA6531. 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-2233-ESAB.

ZPMC personnel performing Heat straightening of Bike path stringer plate flange is identified as BK102B for BK023A-001 is in progress as per HSR1 (B)-10212.

ABF QC NDT MT personnel performing MT after root pass welds of cable bracket is identified as SA6530 is in progress.

ZPMC QC NDT personnel performing UT of bike path deck plate weld is identified as BK024A-001-008 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

BK004B3-001-064

BK004B4-001-084

BK004B1-001-041,042,040,036,030,031

BK004B1-001-005,006,008,038,001,020,004,013

BK004A3-013-073

BK004A4-013-079

BK004A1-013-041,042,030,035,033

BK004A1-013-005,006,008,038,001,010,004,013

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path.

The weld designations reviewed as follows

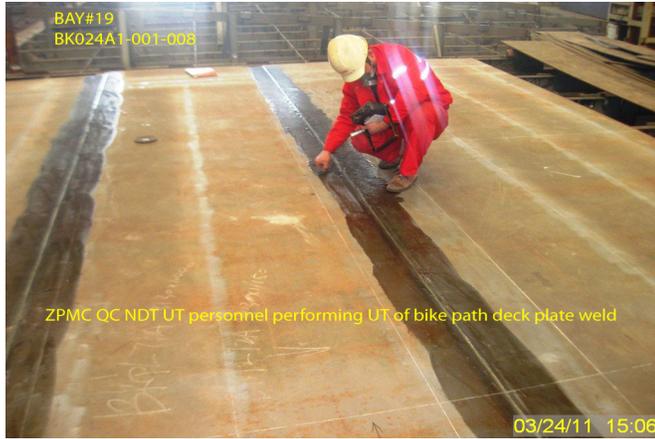
BK023A1-001-013

BK025A1-001-009

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