

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-023200**Date Inspected:** 24-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 weld is identified as 2F-053/054 of SA6529-001 for SA6529. 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-2132-ESAB.

FCAW welding of weld is identified as 3G-027 of SA6029-001 for SA6029. The welder is identified as 062757. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-063 of SA6029-001 for SA6029. The welder is identified as 062783. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-038 of SA6031-001 for SA6031. The welder is identified as 062806. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 3G-051 of SA6031-001 for SA6031. The welder is identified as 062808.

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ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

SMAW welding of critical repair weld (Buttering) on Edge plate X64A for SB106 West. 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-1G-Repair and B-CWR2877.

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.

BK5ASD1-002-022.

During random in-process visual inspection of OBG Cable bracket, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

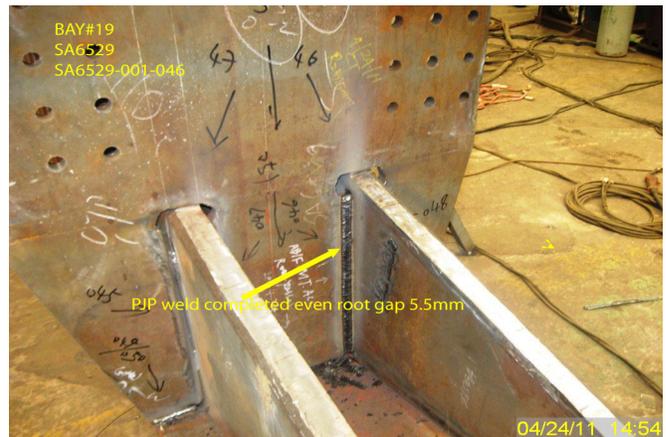
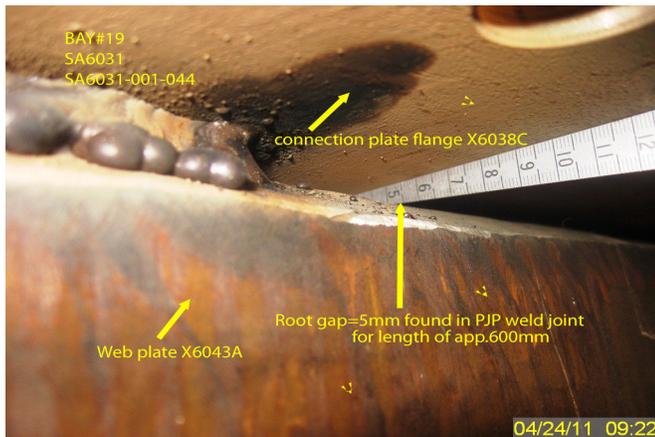
An excessive Root gap was measured in PJP weld joints at the Web plate that connects the Side connection plate and the Bottom flange plate in following cable brackets for Lift-12.

SA6029, SA6529, SA6531.

For more information please see the Incident report

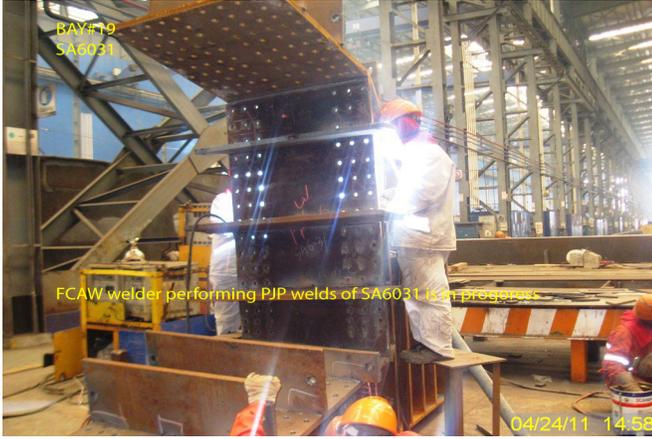
04-0120F4_TL-15_B247_04-24-11_Excess Root gap in PJP Welds _Cable bracket for Lift-12

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
