

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-023201**Date Inspected:** 22-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: Zheng zhi wei
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 3G-130 of SA6030-001 for SA6030. The welder is identified as 062807. 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 2G-132 of SA6030-001 for SA6030. The welder is identified as 062807. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

ABF QC NDT MT personnel performing root pass MT of PJP weld joint is identified as SA6030-001-130,131 and 132 is in progress.

SMAW welding of critical repair weld (Buttering) on Edge plate X64B for SB106 East. The welder is identified as 259566. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-CWR2877.

FCAW welding of critical repair weld (Buttering) on web plate X6042A/B for SA6030. The welder is identified as 062807. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with the WPS-345-FCAW-2G-Repair and B-CWR2938.

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 suspender bracket. The weld designations reviewed as follows.

SB027-110-001,014,024,032,033,039,047,051,055,030,009,011,013,020,003,005,006

SB027-110-021 ; 10mm linear transverse crack found IR made for this incident.

During random in-process visual inspection of OBG Bike path, Caltrans Quality Assurance (QA) Inspector discovered the following issues:

-ZPMC personnel performing weld repair due to closure box misaligned 20mm of dimension without the prior approval of the Engineer.

-The misalignment was found during fit-up of bike path BK04A-055 and BK005A-002

For more information please see the Incident report of

1851-04-0120F4_TL-15_B247_04-22-11_BK005A-002_Weld_repair_work_without_Engineer_Approval.

During the Quality Assurance (QA) Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB110 East, this Quality Assurance Inspector (QA) discovered the following issue:

- One transverse crack that measured approximately 10mm in length.

-The weld is identified as SB027-110-021.

For more information please see the Incident report of

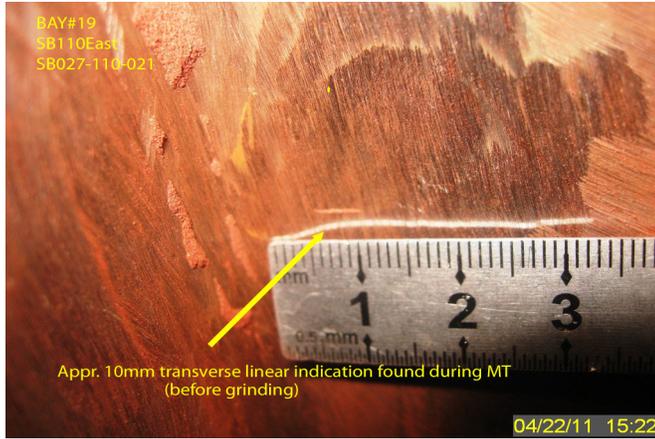
04-0120F4_TL-15_B247_04-22-11_SB110_East___Missed_MT_indication

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 |
