

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-023768**Date Inspected:** 15-May-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 4F-106 of BK24A6-001 for BK24A. The welder is identified as 208641. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2134-ESAB.

FCAW welding of weld is identified as 4F-066 of BK24A8-001 for BK24A. The welder is identified as 208632. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2134-ESAB.

FCAW welding of weld is identified as 4F-009 of BK24A6-001 for BK24A. The welder is identified as 208641. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2134-ESAB.

FCAW welding of weld is identified as 4F-110 of BK24A8-001 for BK24A. The welder is identified as 208632. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2134-ESAB.

ZPMC qualified SMAW welder is identified as 202338 performing VT repair touch up welding

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On bike path is identified as BK25A is in progress.

ZPMC QC NDT MT personnel performing MT on welds of cable bracket is identified as SA6030 is in progress.

ZPMC personnel performing grinding of bike path fillet welds is in progress of BK23 and BK25.

ZPMC personnel performing gas cutting and grinding of cope hole edges to make it smooth and radius as per drawing.

ZPMC QC NDT UT personnel found fourth time reject able indication while performing UT on B-CWR 2979 weld is identified as SA6530-001-007.

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 Cable bracket. The weld designations reviewed as follows.

SA6529-001-002,003,005

SA6529-001-086,089,045,048,098,099,100

SA6533A-001-009,010,011

SA6533B-001-013,014,016

SA6530-002-081,082,083

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.

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Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	Patel,Hiranch	QA Reviewer
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