

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-017513**Date Inspected:** 05-Oct-2010**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:	Mr. Yu Dong Ping/ Mr. Zhao Chao			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:	Tower		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy Dock #Tower Trial assembly

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 17, 18 located on 109 mtr. elevation, Skin A, West shaft, Façade plate WSD1-FASA3-2B/E.

Welder is identified as 040690. ZPMC Quality Control Inspector (QC) is identified as Fu Wei min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 -2.

Weld joint # 15, 16 located on 109 mtr. elevation, Skin A, West shaft, Façade plate WSD1-FASA3-2B/E.

Welder is identified as 040614. ZPMC Quality Control Inspector (QC) is identified as Fu Wei min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 -2.

Bay #11

This QA Inspector observed the following work in progress

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Shielded Metal Arc Welding (SMAW):

Weld joint # 12B, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 046769. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 8A, located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 041271. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 16, located on Bike Path BK004A1– 018-016. Welder is identified as 054460. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231- B-L1B-F-1.

Weld joint # 36, 37 located on Bike Path BK004A5– 022. Welder is identified as 053316/ 067138. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 82, located on Bike Path BK004A5– 022. Welder is identified as 066746. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 83, located on Bike Path BK004A5– 022. Welder is identified as 042218. ZPMC Quality Control Inspector (QC) is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Bay #10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 008, located on Bike Path BK004A1– 028. Welder is identified as 056364. ZPMC Quality Control Inspector (QC) is identified as Sun Tiang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – P-2214-B-U2.

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Weld joint # 005, located on Bike Path BK004A1- 028. Welder is identified as 052930. ZPMC Quality Control Inspector (QC) is identified as Sun Tiang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – P-2214-B-U2.

Bay no. 10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 06865.

Magnetic Particle Testing (MT)

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as Bike path components. The weld designations reviewed are as follows:

BK4A-025-8A – Jt. no- 026

BK4A-025-8C – Jt. nos- 019, 020

BK4A-025-10A – Jt. no- 165

BK4A-025-9C – Jt. no- 040

BK4A-025-9A – Jt. nos- 066, 050

BK4A-025-7A,B,C – Jt. nos- 182,169,199

BK4A-025-7P, R – Jt. nos- 042, 061, 062

BK004A6-025 – Jt. no. -113

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

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 Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer