

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-017558**Date Inspected:** 12-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. Qiu Wen		
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:** 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.

Bay #11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 13, 14- located on East shaft, Lift 5, Skin E to Intersection diaphragm plate- ESD1-TL5- 2F/F. Welder is identified as 040723. ZPMC Quality Control Inspector (QC) is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4314-TC-P5-2.

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 018- located on Bike path component BK 004A-018. Welder is identified as 040690. ZPMC

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Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 025, 026- located on Bike path component BK 004A-018. Welder is identified as 040690. ZPMC Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 001- located on Bike path component BK 004-017. Welder is identified as 049220. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333-TC-P4-F.

Weld joint # 002- located on Bike path component BK 004-017. Welder is identified as 049220. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332-TC-P4-F.

Bay #10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 040, 41, located on Bike Path BK007A4– 030. Welder is identified as 057180. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2132.

Weld joint # 043, 44, located on Bike Path BK007A7– 030. Welder is identified as 040302, 057180. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2132.

Weld joint # 178, 179, located on Bike Path BK007A7– 030. Welder is identified as 053869, 052075. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2132.

Weld joint # 51, 52, located on Bike Path BK004A3– 030. Welder is identified as 057180, 040302. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 19, 20- located on Bike Path BK004A7– 030. Welder is identified as 053869, 052075. ZPMC Quality Control Inspector (QC) is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006927

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 a TL 6028 MT report for this date. The member is identified as Tower Façade plate Pad eyes and Manhole hinges. The weld designations reviewed are as follows:

WD1- SFSA3-30 – Jt. no. -078 –Pad eye

WD1- SFSA3-35 – Jt. no. -019 –Pad eye

WD1- SFSA3-35 – Jt. no. -007 -Hinge

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as Bike path -OBG Component. The component and weld designation identified as follows:

BK004A3-027 -025, 026

BK 004A3-027-051, 052

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