

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-017723**Date Inspected:** 21-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:** Qiu Wen**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 & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 06 located on East tower Lift-4 Skin 'E', 119 M backfill plate ESD1 – FESA4 – 2B/F. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – B – U2c – 2.

Weld joint # 06 located on West tower Lift-4 Skin 'E', 119 M backfill plate WSD1 – FESA4 – 4B/F. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – B – U2c – 2.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 04 located on South tower Lift-5 Skin 'B', Mounting plate CAMPSA – 5. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified Li Peng Fei. The welding variables recorded by QC

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appeared to comply with the WPS – B – T – 4114 – 1.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 09 located on Bike Path, BK008A1 – 001. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 2.

Weld joint # 09 located on Bike Path, BK008A1 – 001. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 2.

Submerged Arc Welding (SAW):

Weld joint # 09 located on Bike Path, BK008A1 – 001. Welder is identified as 207745. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW)/Plug Welding:

Weld joint # 15 located on Bike Path BK004A2 – 021. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 2 – PLUG.

Fluxcored Arc Welding (FCAW):

Weld joint # 23 located on Bike Path BK004A8 – 020. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BLAST SHOP#2

This QA Inspector observed the following work in progress

During the Internal pre-blast visual inspection on North tower Lift-3 from 102.5 M elevation to 111.67 M, this Quality Assurance Inspector (QA) discovered the defects required welding and Magnetic particle testing on weld at the following location:

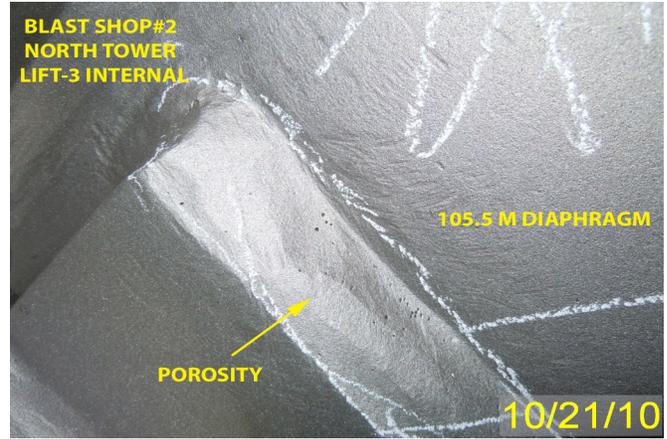
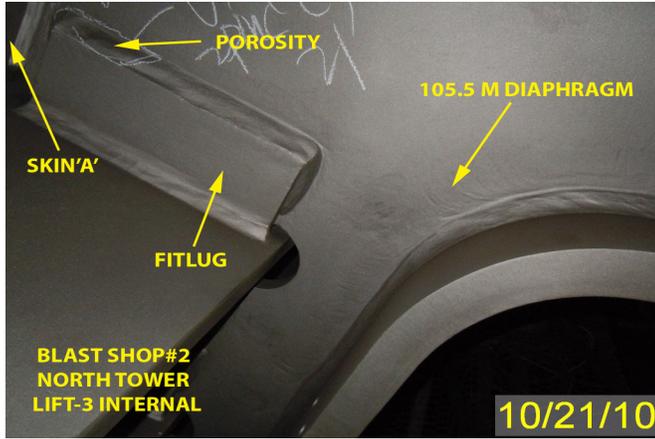
1) Fit-lug to diaphragm weld – POROSITY –Skin ‘A’ 2nd stiffener from skin ‘E’ of 105.5 M diaphragm.

For further information, please see the attached pictures below.

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 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 Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer