

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-018098**Date Inspected:** 06-Nov-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 West tower Lift-4 Skin 'A', 119 M Backfill plate WSD1 – FASA4 – 2B/E. Welder is identified as 202323. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4212 – Tc – U4c – 4.

(See attached photo)

Weld joint # 27 located on East tower Lift-4 Skin 'A', 119 M Backfill plate ESD1 – FASA4 – 2B/E. Welder is identified as 046769. 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 – U2a – 2.

Weld joint # 15 located on South tower Lift-4 Skin 'A', 119 M Backfill plate SSD1 – FASA4 – 1B/E. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4214 – Tc – U4c – 4.

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Weld joint # 05 located on West tower Lift-4 Skin 'A', 119 M Backfill plate WSD1 – FASA4 – 2B/E. 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 – 4212 – Tc – U4c – 4.

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 010 located on Bike Path, BK004A3 – 029. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 010 located on Bike Path, BK004A5 – 029. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Shielded Metal Arc Welding (SMAW):

Weld joint # 144 located on Bike Path, BK004A7 – 031. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 215 located on Bike Path, BK004A7 – 031. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Surface Welding by Shielded Metal Arc Welding (SMAW):

Surface welding / buttering being performed as per the weld repair report B-WR16597 located on bike path stringer plate, BK004 – 029 – 9C. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 3G (3F) – Repair. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 19B located on Lift-5 bracket ND1 – BRSA5 – 2. Welder is identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4b.

Weld joint # 6A located on Lift-5 bracket SD1 – BRSA5 – 1. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the

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WPS – B – T – 3212 – TC – U4b.

Submerged Arc Welding (SAW):

Weld joint # 53A located on East tower Grillage cover plate ESD1 – TL5 – 2B/F. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Weld joint # 58A located on West tower Grillage cover plate WSD1 – TL5 – 4B/F. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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
