

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018115**Date Inspected:** 01-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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 Segment and Bike Path**Summary of Items Observed:**

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

Ultrasonic Testing (UT) – NWIT Document No: 007191

This QA inspector performed UT of approximately 10% of the area 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 Segment 12AE. The weld designations reviewed are as follows:

1. CA3001F-150, 151, 152, 153

Green Tag for OBG Component – Steel Barrier

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control and ABF QA personnel. This QA signed green tag numbers are identified 15173 and 15174. The OBG component are identified as given below

1. W5- SB13A-002
2. W5- SB13-001
3. W5- SB13-002
4. W5- SB3A-001

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5. W5- SB1D-005
6. W5- SB1-007
7. W5- SB1-014
8. W5- SB1C-001
9. W5- SB3-003
10. W5- SB5-001
11. W5- SB5A-001
12. W5- SB8-001
13. W5- SB8-002
14. W5- SB9-001
15. W5- SB12-002
16. W5- SB12-003
17. W5- SB13A-001
18. W5- SB7-001
19. W5- SB10-001

Bay 16

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint W5-SB1-044-063 ~074, 079 and 080 located on OBG steel barrier. Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2133.

SMAW welding of weld joint W5-SB1-044-100 ~105 and 096 located on OBG steel barrier. Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2133.

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK006A1-001-005, 006 001 and 004 located on sole OBG of Bike Path. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK006A1-001-008, 010, 013 and 038 located on sole plate of OBG of Bike Path. Welder is identified as 062739. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

This QA inspector observed ABF and ZPMC personnel performed Magnetic Particle Testing on sole plate of OBG Bike Path BK004A-04 and BK004A-02.

ZPMC personnel performing heat straightening on bottom cover plate of OBG bike path member identified as

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

BK004A-009-014~021. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9501. See the attached pictures.

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



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

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