

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-024016**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Li Yan Hua
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:** OBG**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 #14

This QA Inspector observed the following work in progress

Flux Cored arc welding (FCAW)

Repair welding of Weld joint- 001/ 002 as per WRR no. B-WR-20855, Located on U Rib splice plate X3305K-054. Welder is identified as 045240. ZPMC Quality Control Inspector (QC) is identified as Wang Jun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-Repair.

Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed 100% UT performed by ZPMC Quality Control personnel. The member is identified as OBG Component, U Rib Splice plate. The component and weld designation identified as follows:

X3305K-067 -001, 002
X3305K-016 -001, 002
X3305K-036 -001, 002

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X3305K-077 -001, 002

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 006, 008 Located on Cable Bracket SA6530-001. Welder is identified as 062806. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 047, 048 Located on Cable Bracket SA6031-001. Welder is identified as 062808. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 058, 059 Located on Cable Bracket SA6029-001. Welder is identified as 062757. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 002, 003, Located on Cable Bracket SA6529-001. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 005, 007, Located on Cable Bracket SA6531-001. Welder is identified as 062739. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 181 Located on Bike path panel BK-25A7-001. Welder is identified as 062783. ZPMC Quality Control Inspector (QC) is identified as Li Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 001/ 003, Located on Bike path Hand rails, FS3. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

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Weld joint- 002, Located on Bike path Hand rails, FS2. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

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.



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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
