

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-024020**Date Inspected:** 05-May-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- 003 as per CWR no. B-CWR-2961, Located on Container Box Bracket BK 016-001.

Welder is identified as 044473. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-FCM-Esab-Repair.

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 047/073 Located on Cable Bracket SA6531-001. Welder is identified as 062807. ZPMC Quality

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 059/076 Located on Cable Bracket SA6531-001. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 081 Located on Cable Bracket SA6530-001. Welder is identified as 062739. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09037

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 OBG Lift 13 components. The weld designations reviewed are as follows:

BKA4-001-Jt. nos - 180 to 183,144,145,221to224,160,161,205,208,152,153,010,011,032,033,034,055

BK24A3-001- Jt. nos -019,020,040,041

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 003, Located on Bike path Hand rails, FS19, PP77. 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.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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