

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-024988**Date Inspected:** 11-Jun-2011**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:** Lei/Wen/Shigang/Feng /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:** OBG Bike Path**Summary of Items Observed:**

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

Bay 1

This QA Inspector noted that there are 30 Bike Path Handrail components identified as intermediate BKR-NS-2 that are in various stages of final pick-up and will be ready for final VT soon.

This QA Inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

Bay 5

The following Traveler Rail components are in this bay waiting further processing: 3022TR1-001, 3020TR1-001, 3010TR1-002, 3025TR1-001, 3025TR1-002, 3025TR1-003, 3023TR1-002, 3023TR1-003, 3009TR1-001, 3023TR1-001, 3026TR1-001, and 3007TR2-001.

Bay 6

There are 32 miscellaneous components identified as GGL-MQ-1504-2-2 at the front of this bay, no work is being performed on these components at the time this QA Inspector identified these components.

This QA Inspector observed the following Cross Beam 18 component is in process this bay.

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Bay 7

This QA Inspector observed the following Cantilever Box Bracket Assembly components are in process in this bay: BKSA15, BKSA14 and BKSA18.

Bay 8

This QA Inspector observed 38 U-Rib Backup components are in various stages of fabrication waiting further processing and inspection.

Bay 9

This QA Inspector observed 8 Bike Path Travel Rail components in various stages of fabrication waiting further processing and/or NDT.

This QA Inspector observed 15 Bike Path Handrail components identified as BKR-NS-2 in various stages of fabrication waiting further processing.

This QA Inspector noted that there are 5 Bike Path Handrail components identified as BKR-NS-3 that are in various stages of fabrication.

This QA Inspector noted that there are Bike Path components identified as BK3006, BK3007 and BK3008 that are in various stages of fabrication.

This QA Inspector noted that there are Bike Path components identified as BKSA 13B, BKSA020, BKSA 13A, BKSA011, BKSA016, BK13, and BK22A that are in various stages of fabrication.

This QA Inspector observed 20 U-Rib Backup components are in various stages of fabrication waiting further processing and inspection.

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 004 located on BKSR012-001. Welder is identified as 062265. ZPMC Quality Control (QC) is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 004 located on BKSR012-001. Welder is identified as 059416. ZPMC Quality Control (QC) is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 002 located on BKSR020-001. Welder is identified as 059378. ZPMC Quality Control (QC) is identified as Liu Fawen. The welding variables recorded by QC appeared to comply with the applicable WPS.

Bay 10

The following Bike Paths are in various stages of fabrication waiting further processing and inspection: BK009A-001 and BK010A-001.

In Process Inspection FCAW

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This QA Inspector observed the following work in progress: FCAW welding of weld joint 189 located on BK009A1-001. Welder is identified as 054069. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 153 located on BK009A1-001. Welder is identified as 040365. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11

The following Bike Paths are in various stages of fabrication waiting further processing and inspection: BK011A-001 and BK012A-001.

Bay 19

The following Bike Paths are in various stages of fabrication waiting further processing and inspection: BK023A-001, BK024A-001 and BK025A-001.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09425.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK23A6-001-015

BK23A8-001-011

BK23A5-001-002, 009

BK23A3-001-003, 006

BK23A5-001-181, 184, 187, 190

BK25A8-001-094, 095

BK24-001 - For Green Tag

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09436.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK012A-001 - For Green Tag

Ultrasonic Testing Inspection (UT)

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09425.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BK23A6-001-015

BK23A8-001-011

BK23A5-001-002, 009

BK23A3-001-003, 006

BK23A5-001-181, 184, 187, 190

BK25A8-001-094, 095

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

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer
