

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016506**Date Inspected:** 18-Aug-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 # 4B located on North tower Lift-3 cross bracing gusset plate to doubler strut plate WD – GUSA3 – 3 – 109M – N. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – Tc – U5b – FCM. (See attached photo)

Weld joint # 4B located on South tower Lift-3 cross bracing gusset plate to doubler strut plate WD – GUSA3 – 3 – 109M – S. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – Tc – U5b – FCM.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 35 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 067520. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint # 8A located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 18B located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

BAY#11

This QA Inspector observed the following work in progress
Shielded Metal Arc Welding (SMAW):

Weld joint # 19 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 066674. 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 – U4c.

Weld joint # 35 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 037997. 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 – U4c.

(See attached photo)

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress
Fluxcored Arc Welding (FCAW):

Weld joint # 85 located on Bike Path panel Assembly BK005A6– 002. Welder is identified as 047506. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Weld joint # 84 located on Bike Path panel Assembly BK005A6– 002. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

BAY#12

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006421

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

LIGHT BRACKET

- LB004A – 002 – 001
- LB004 – 002 – 061
- LB003A – 003 – 001
- LB003 – 003 – 037
- LB003A – 002 – 001
- LB003 – 002 – 051

This QA Inspector observed the following work in progress
Fluxcored Arc Welding (FCAW):

Weld joint # 033 located on Light Bracket LB4– 001. Welder is identified as 062259. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 2.

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 Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer