

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-016949**Date Inspected:** 08-Sep-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: Yu Dong Ping
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:** 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 # 19 located on East tower Lift-3, 89 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2C/E. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4214 – Tc – U4c.

Weld joint # 32 located on North tower Lift-3, 99 M cross bracing gusset plate to small doubler plate NSD1 – FASA3 – 1B/E. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4313– Tc – P4. (See attached photo)

Weld joint # 12 located on South tower Lift-3, 89 M cross bracing gusset plate to small doubler plate SSD1 – FASA3 – 1C/E. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4212– B – U2a – 2.

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Weld joint # 25 located on West tower Lift-3, 99 M cross bracing gusset plate to small doubler plate WSD1 – FASA3 – 2B/E. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4214 – Tc –U4c.

Weld joint # 26 located on East tower Lift-3, 89 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2C/E. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4213 – Tc –U4c – 1.

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Submerged Arc Welding (SAW):

Weld joint # 292 located on BP3094 – 001 Welder is identified as 209051. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006614

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

LIFT-5 INTERNAL SPLICE PLATE – GREEN TAG#14324

WSD1 – SPSA5 – 7 – 2A/B; 4A/B

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 19 located on Bottom plate BP3093 – 001. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 32 located on Bottom plate BP3093 – 001. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 27 located on Bottom plate BP3093 – 001. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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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