

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-016960**Date Inspected:** 14-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:** 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.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006664

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designation reviewed as follows:

EDGE PLATE

EP3029 – 001 – 001

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 OBG Component. The weld designation reviewed as follows:

EDGE PLATE – GREEN TAG#13732

EP3029 – 001 – 001

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This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 15 located on Façade Assembly ND1 – SPSA4 – 336A/B. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Yi Chun Fang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 24 located on Façade Assembly ND1 – SPSA4 – 336A/B. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yi Chun Fang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Submerged Arc Welding (SAW):

Weld joint # 002 located on SEG3013AC. Welder is identified as 045240. ZPMC Quality Control (QC) Inspector is identified as Guo Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2. (See attached photo)

Weld joint # 002 located on SEG3013AC. Welder is identified as 207237. ZPMC Quality Control (QC) Inspector is identified as Guo Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006663

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 OBG Component. The weld designation reviewed as follows:

EDGE PLATE

EP3030B – 001 – 055 – GREEN TAG#13703

EP3030C – 001 – 056 – GREEN TAG#13704

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 13A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b. (See attached photo)

Weld joint # 9B located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

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ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 51 located on Bike path BK004A3 – 018. Welder is identified as 053316. 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 – 2132.

Weld joint # 18 located on Bike path BK004A7 – 018. Welder is identified as 040736. 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 – 2132.

Weld joint # 52 located on Bike path BK004A3 – 018. Welder is identified as 049220. 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 – 2132.

Weld joint # 21 located on Bike path BK004A7 – 018. Welder is identified as 042218. 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 – 2132.

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

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Reviewed By: Clifford, William

QA Reviewer