

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-017194**Date Inspected:** 11-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:** Mr. 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**Summary of Items Observed:**

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

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment Bottom Plate, weld No: BP3090-001-110/111. The welders are identified as #044473/052075. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the Tower Façade, weld No: ND1-SFSA4-326A/B-19. The welder is identified as #057258. ZPMC QC is identified as Mr. Yin Chun Fang. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 14 Bottom Plate, weld No: SEG3007AC-001-002. The welder is identified as #044771. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3C-S-2.

WELDING INSPECTION REPORT

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Magnetic Particle Testing:-

Bay #10

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Lift 5 South Tower Grillage. The weld designation reviewed is as follows:

SSD1-TL5-1F-F-13A/B,14/15,16A/B,25A/B,26/27,28A/B.

Bay #11

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Bike Path. The weld designation reviewed is as follows:

9A-BK004A4-021-54

9A-BK004A6-021-112,113

9A-BK004A7-021-059,113,120,203,051,118,200,211

9C-BK004A4-021-29,44,27,28

9C-BK004A6-021-94

9C-BK004A7-021-041,039,190,186,191,102,046,193,105,108

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021 this Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

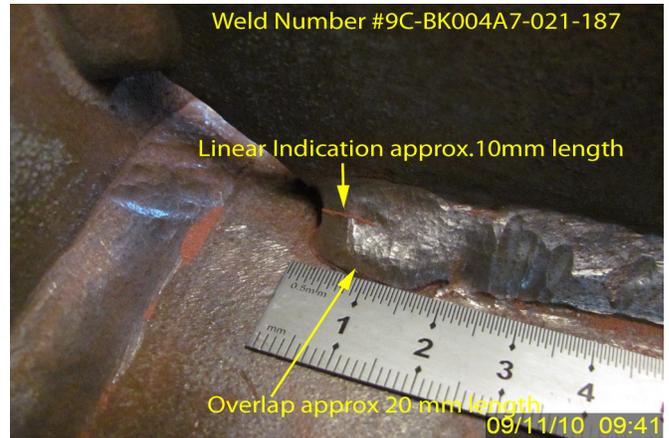
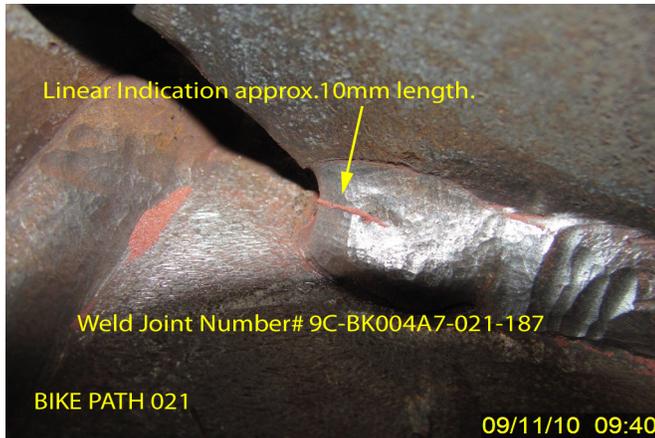
The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

This Quality Assurance (QA) Inspector wrote an Incident Report for MT Indication found in the Bike path021 Stringer Plate. Please reference the Incident Report # 04-0120F4_TL-15_B286_09-11-10_BK021_MT Indication. For further information, please see the attached pictures.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversation.

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 Micheal Ng- 159-2184-5703 , who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer