

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-017431**Date Inspected:** 24-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.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 28 as per the critical weld repair report T-CWR 693 located on South tower Lift-3, 99 M backfill plate SSD1 – 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 – 345+485 – SMAW – 2G (2F) – FCM – REPAIR – 2.

BAY#10**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 134 located on Bike Path BK004A5 – 029. Welder is identified as 052075. ZPMC Quality Control

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

(QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Weld joint # 135 located on Bike Path BK004A5 – 030. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2 – F.

Weld joint # 135 located on Bike Path BK004A5 – 029. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2 – F.

Weld joint # 134 located on Bike Path BK004A5 – 030. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 12A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 054460. 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 – 3213 – Tc – U4b.

Weld joint # 8A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 044541. 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 – 3213 – Tc – U4b.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 135 located on Bike Path BK004A5 – 017. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – B – U2.

BACKING BAR SURVEY ON LIFT-5 TOWER SHAFTS AT BAY#10 & 11

During survey the following discrepancies found on lift-5 tower shafts: -

EAST TOWER LIFT-5:

1. Approximately 1 metre length of backing bar removed after buckling (ESD1-TL5-2B-F#19)

WEST TOWER LIFT-5:

1. Backing bar buckled (WSD1-TL5-4B-F#04)
2. Backing bar not fused approximately 1 metre in length (WSD1-TL5-4B-F#07) and not continuous between the

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

welds (WSD1-TL5-4B-F#07&36)

3. Backing bar is not continuous between the welds (WSD1-TL5-4B-F#08&35)

For further information see attached pictures:

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



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
