

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017436**Date Inspected:** 30-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:** Xu Le Feng**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 # 11 located on South Tower 89 M elevation skin 'A' to Façade plate SSD1 – FASA3 – 1C/E. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified as Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 2.

Weld joint # 10 located on South Tower 89 M elevation skin 'A' to Façade plate SSD1 – FASA3 – 1C/E. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 2.

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY NORTH & TOWER LIFT-3&4

This QA Inspector carried out the dimensional verification on North and South Tower lift-3 & 4 to check the misalignment and gap between the interior splice plates and longitudinal stiffeners of skin 'A', 'B', 'C', 'D' & 'E'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 26 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9343.

Fluxcored Arc Welding (FCAW):

Weld joint # 14 located on Bike Path BK004A4 – 032. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 15 located on Bike Path BK004A4 – 032. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 01A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 12A located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 07A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 08A located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. 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

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Fluxcored Arc Welding (FCAW):

Weld joint # 44 located on Bike Path BK004A4 – 023. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Weld joint # 41 located on Bike Path BK004A4 – 020. Welder is identified as 066746. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 53 located on Bike Path BK004C3 – 024. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Weld joint # 14 located on Bike Path BK004A4 – 020. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

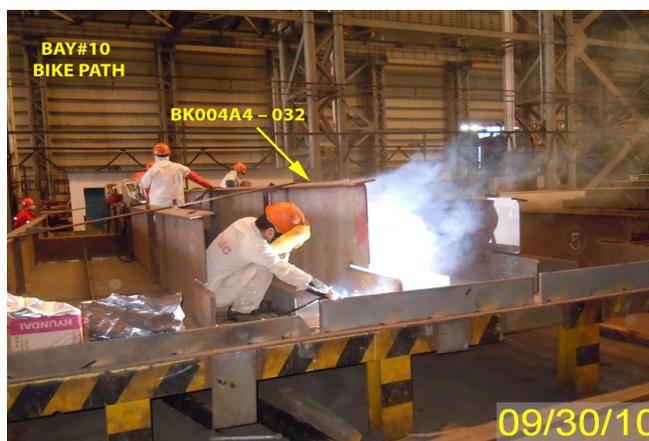
Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as OBG Component. The component designation is identified as follows:

BIKE PATH – BK4A5 – 018 – 008

(See the attached photo)

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------