

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-017536**Date Inspected:** 08-Oct-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

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

This QA Inspector carried out joint dimensional verification along with ABF personnel Mr. Li kwei inside North Tower to confirm the misalignment readings recorded between the longitudinal stiffeners of lift-3 & 4 on skin 'C' & 'D'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

BAY#10

This QA Inspector observed the following work in progress

Magnetic Particle Testing (MT)

This QA inspector performed MT approximately 200 mm length from top of the weld on the backing bar, which was welded full length to the base material. During the process two transverse indications were found on top of the weld. As per ZPMC QC personnel the top and bottom 50 mm of the lift-5 grillage will be machined. The member is identified as TOWER Component. The weld designation reviewed as follows:

WELDING INSPECTION REPORT

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LIFT-5 NORTH TOWER

NSD1 – TL5 – 3B/F – 02

(See attached pictures)

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 44 located on Bike Path, top cover plate to side plate BK004A1 – 028. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 4G (4F) – Repair.

Repair welding of weld joint # 44 located on Bike Path, top cover plate to side plate BK004A1 – 028. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 4G (4F) – Repair.

Witness of Ultrasonic Testing (UT)

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

BIKEPATH COMPONENT

BK004A1 – 028 – 044

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 14B located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040610. 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 # 07B located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040614. 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 # 11B located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040610. 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.

BAY#12

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#12

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 03 located on U-rib splice plate SA3111B – 019. Welder is identified as 062259. ZPMC Quality

WELDING INSPECTION REPORT

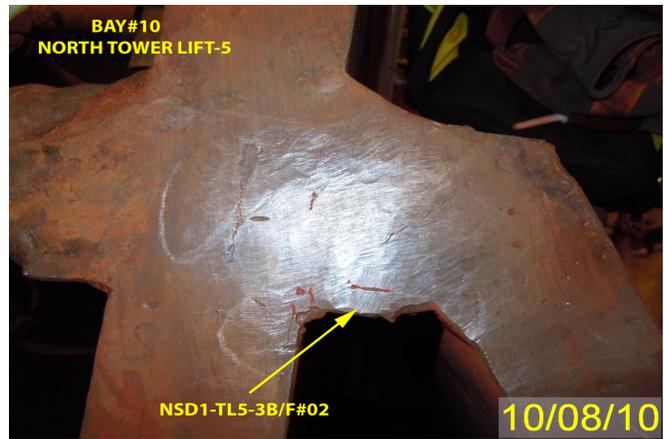
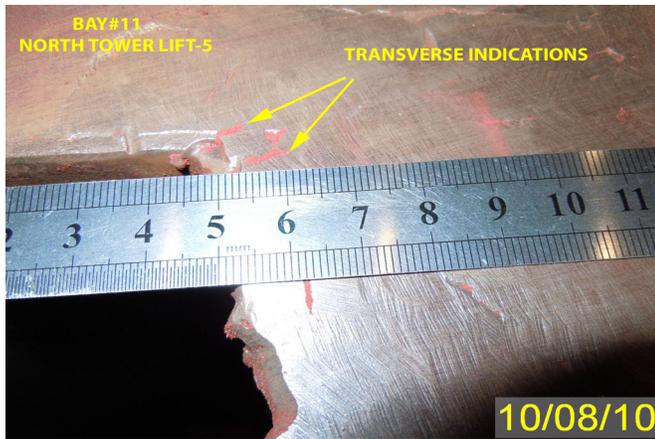
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Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Weld joint # 02 located on U-rib splice plate SA3111A – 025. Welder is identified as 062265. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 04 located on U-rib splice plate SA3111B – 008. Welder is identified as 062259. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

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
