

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-017556**Date Inspected:** 10-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: Mr. Qiu Wen
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**Summary of Items Observed:**

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

Bay #10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 044, located on Bike Path BK004A8- 025. Welder is identified as 056364. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS - B - P - 2214-B-U2.

Weld joint # 043, located on Bike Path BK004A8- 025. Welder is identified as 052493. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS - B - P - 2214-B-U2.

Weld joint # 13, 14, located on Bike Path BK004A8- 025. Welder is identified as 053869. ZPMC Quality

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Control Inspector (QC) is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 41, 42 located on Bike Path BK004A8– 025. Welder is identified as 052075. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Bay #11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 3A, located on Back strip of Bike path Component BKPL. Welder is identified as 040655. ZPMC Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 3A, located on Back strip of Bike path Component BKPL. Welder is identified as 054460. ZPMC Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Repair welding of Weld joint # 008, located on Bike path component BK004A5-018.. Welder is identified as 053316. ZPMC Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – 345-FCAW- 2G (2F)- Repair.

Weld joint # 56, 57, 60, located on Bike path component BK 004A-021. Welder is identified as 042218. ZPMC Quality Control Inspector (QC) is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 71, 72, 75, located on Bike path component BK 004A-021. Welder is identified as 040759. ZPMC Quality Control Inspector (QC) is identified as Zhao Mao Mao. 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 Bike path -OBG Component. The component and weld designation identified as follows:

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

BK004A4-020 -040, 041
BK 004A5-020-042, 043

Bay #12

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 005 located on U Rib splice plate –SA3114C-032. Welder is identified as 059418. ZPMC Quality Control Inspector (QC) 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 # 005 located on U Rib splice plate –SA3114C-033. Welder is identified as 059403. ZPMC Quality Control Inspector (QC) 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 # 005 located on U Rib splice plate –SA3114C-023. Welder is identified as 059403. ZPMC Quality Control Inspector (QC) 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 # 005 located on U Rib splice plate –SA3114C-027. Welder is identified as 059403. ZPMC Quality Control Inspector (QC) is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232- TC-U4B-F.

Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed 10% UT performed by ZPMC Quality Control personnel. The member is identified as U Rib, Splice plate of OBG component. The component and weld designation identified as follows:

SA3114A-008-001, 002
SA3114A-006-001, 002
SA3114A-005-001, 002

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006909

Magnetic Particle Testing (MT)

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG U Rib Splice plate components. The weld designations reviewed are as follows:

SA3084A- 022 – Jt. nos. -001, 002

SA3051A- 006 – Jt. nos. -001, 002

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer
