

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-017560**Date Inspected:** 16-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. Yu Dong Ping**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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 114- located on Bike path component BK 004A6-017. Welder is identified as 054460. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – TC-U4C-F.

Weld joint # 114- located on Bike path component BK 004A8-017. Welder is identified as 046769. ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – TC-U4C-F.

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Weld joint # 043- located on Bike path component BK 004A1-023. Welder is identified as 040759. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B –T – 2232 –B-U2-F.

Weld joint # 016, 017- located on Bike path component BK 004A5-023. Welder is identified as 049220. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B –T – 2132.

Weld joint # 022, 023- located on Bike path component BK 004A5-023. Welder is identified as 040759. ZPMC Quality Control Inspector (QC) is identified as Shao Hai Lang. 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:

BK004A8-017 -072,
BK 004A6-017-073

Bay #10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair of Skin A Doubler plate cavity , located on 89 mtr. elevation of North shaft, Lift 3. Welder is identified as 040365. ZPMC Quality Control Inspector (QC) is identified as Sun Zhi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW -3G (3F) -Repair.

Repair of Skin A Doubler plate cavity , located on 99 mtr. elevation of North shaft, Lift 3. Welder is identified as 056364. ZPMC Quality Control Inspector (QC) is identified as Sun Zhi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW -3G (3F) -Repair.

Repair of Skin A Doubler plate cavity , located on 109 mtr. elevation of North shaft, Lift 3. Welder is identified as 052930. ZPMC Quality Control Inspector (QC) is identified as Sun Zhi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW -3G (3F) -Repair.

Weld joint # 044- located on Bike Path BK004A1– 026. Welder is identified as 052493, 500363. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Cai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2214 –B –U2.

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This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 043- located on Bike Path BK004A6– 028. Welder is identified as 057258. ZPMC Quality Control Inspector (QC) is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 –TC-U4C-F.

Weld joint # 067, 114- located on Bike Path BK004A6– 028. Welder is identified as 057258. ZPMC Quality Control Inspector (QC) is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – TC-U4C-F.

Weld joint # 043- located on Bike Path BK004A1– 026. Welder is identified as 053869, 040302. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Cai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 –B –U2-F.

Weld joint # 044- located on Bike Path BK004A1– 026. Welder is identified as 052085, 057180. ZPMC Quality Control Inspector (QC) is identified as Yu Zhi Cai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 –B –U2-F.

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.

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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