

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-017563**Date Inspected:** 19-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Xu Le Feng
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 #11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 044- located on Bike path component BK 004A1-023. Welder is identified as 040759. ZPMC Quality Control Inspector (QC) is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231-B-U2-F.

Bay #14

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

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ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 145, 146- located on Lift 13 Component CA3013C. Welder is identified as 044774. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Repair Weld joint # 124- located on Lift 13 Component SEG 3007H . Welder is identified as 044795. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW -2G (2F) –Repair -1. The WRR found to be B-WRR-16005.

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 38, 39 located on Lift 13 Component CA 3013C. Welder is identified as 048047. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113-FCM-1.

Weld joint # 135, 136 located on Lift 13 Component CA 3013C. Welder is identified as 200113. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113-FCM-1.

Blast shop # 2

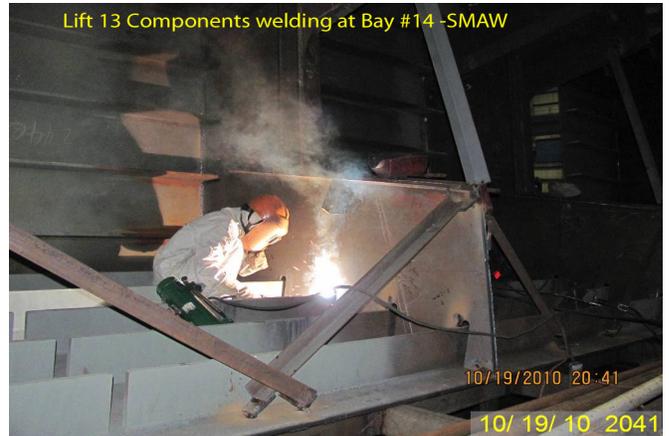
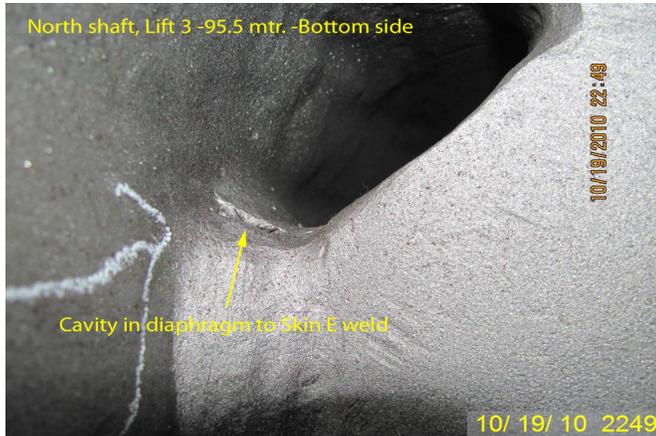
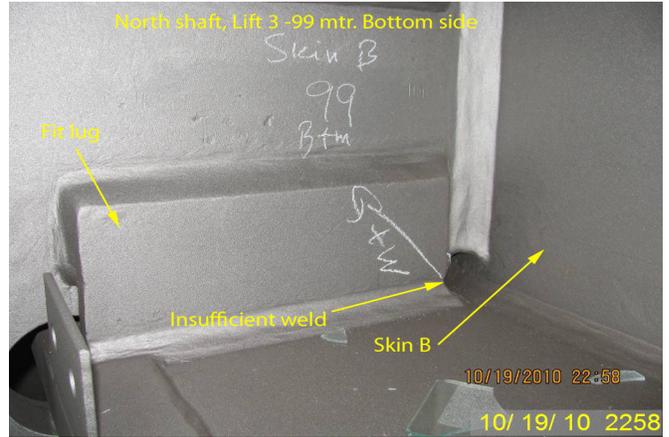
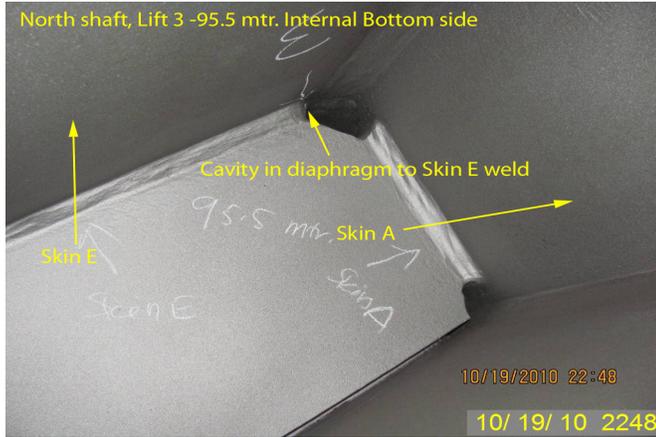
This QA inspector, Baskar Govindarajan, performed Post blast Visual inspection of internal surfaces of North tower, Lift 3. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 83 to 99 mtr. Double diaphragm Bottom side Elevation. This inspection was carried out along with QA Inspector Mr. George Goulet (B 218) and Mr. Mike Hasler (B 293). All the marked points shown to ZPMC inspector Mr. Li Peng Fei and ABF Inspector Mr. Wang Jiang Hua. All the weld repair areas (3 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector. Incident report rose for the same.

For further information see below pictures:-

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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.

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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
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Reviewed By:	Clifford, William	QA Reviewer
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