

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-017565**Date Inspected:** 21-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. Wang Jie		
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 #19

This QA Inspector observed the following work in progress

Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 011 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Peng Wen Jun who was present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) - 9501.

This QA Inspector observed the following work not in compliance:

Description of Incident:

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During the Quality Assurance Inspection at Bay no. 19 and Blasting shop, this Quality Assurance Inspector (QA) discovered the following issue:

- Bike path # BK 004A -004 –found washed and Degreased at Bay no. 19 –East end Without Engineer’s approval.
- Green tag for final approval has not been issued for this Bike path.
- The notification number for Washing and Degreasing was found to be 4667.
- This Bike Path Component was moved to Blasting shop #1 for Blast and paint.

Applicable reference:

In Contract Change Order CCO77

Section 3.2. “Prior to submitting components for formal acceptance the contractor shall implement in-process verification that shall include the following;

Section 3.2.2. “All contract required non-destructive examination (NDE) has been performed and is documented on the component as being acceptable.”

Section 3.2.4. “All critical and non-critical weld repairs have been completed and re-inspected by the original method of inspection and are documented on the component as being acceptable.”

Section 3.3. “The QA approval form shall be issued for the following subassemblies;
i. “Segment assembly before painting and lift assembly.”

This QA notified ABF inspector identified as Mr. Peng Wen Jun, of the above issue and that an incident report will be generated.

Bay #16

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 058, 059- located on Crash Barrier –W5-SB1A-001. Welder is identified as 201074. ZPMC Quality Control Inspector (QC) is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 061, 062- located on Crash Barrier –W5-SB1A-018. Welder is identified as 201879. ZPMC Quality

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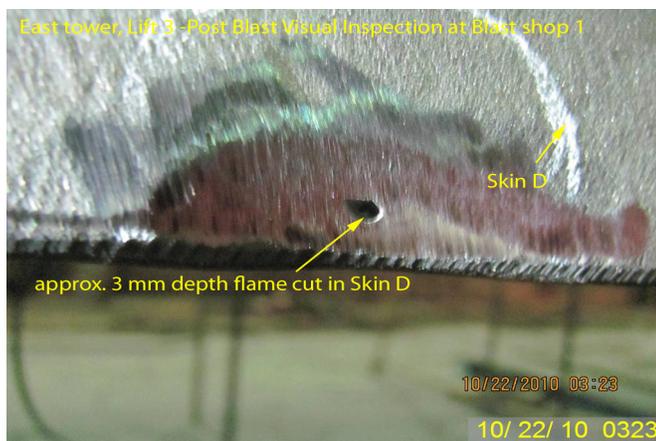
Control Inspector (QC) is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Blast shop # 2

This QA inspector, Baskar Govindarajan, performed Post blast Visual inspection of External surfaces of East 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 114 mtr. This inspection was carried out along with QA Inspector Mr. Paul Dawson (B 254). All the marked points shown to ZPMC inspector Mr. Sun Zhi Wang and ABF Inspector Mr. Wang Jiang Hua. All the weld repair areas (2 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector. Incident report rose for the same.

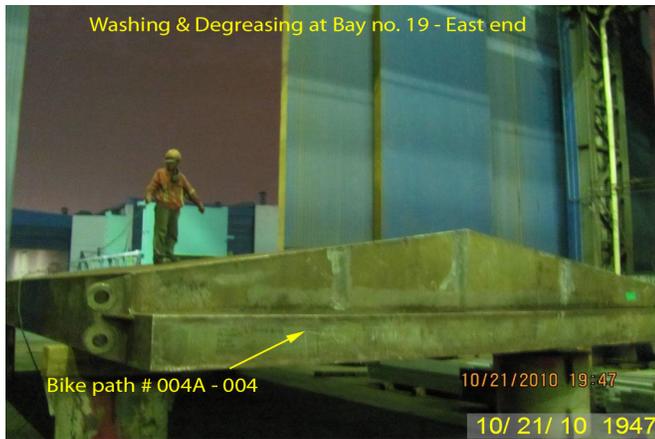
For further information see below pictures:-

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