

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017733**Date Inspected:** 30-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:** Xu Le Feng, 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:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11, OBG BIKE PATH (NWIT # 07172)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A3-018-009

BK004A5-018-004, 007

BAY 11, TOWER STRUT ANGLE

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-SA4-68-143M-3-1A/B

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This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

FCAW welding of weld joints 001 & 002 located on GGL-MQ-1958-11.

Welder is identified as 040533. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

OBG BIKE PATH

FCAW welding of weld joint 009 located on BK004A3-026.

Welder is identified as 053869. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4c-F.

FCAW welding of weld joint 007 located on BK004A5-026.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4c-F.

BAY 11

FCAW welding of weld joints 001 & 002 located on GGL-MQ-1958-55.

Welder is identified as 040723. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

OBG BIKE PATH

FCAW welding of weld joint 020 located on BK004A2-053.

Welder is identified as 205649. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-2-PLUG.

FCAW welding of weld joint 043 located on BK005A1-003.

Welder is identified as 053316. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4c-F.

FCAW welding of weld joint 044 located on BK005A1-003.

Welder is identified as 040759. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

SMAW welding of weld joints 015 & 016 located on BK004A6-023.

Welder is identified as 040655. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

SMAW welding of weld joints 053 & 054 located on BK004A6-023.

Welder is identified as 040655. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

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OBG BIKE PATH, BK004A-018

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Di Kun Lun was performing Magnetic Particle Testing (MT) on the plug welds of bottom cover plate of OBG bike path. The weld designations are identified as BK004A2-018-014, 015, 017, 019, 020. During inspection lot of MT linear indications were found on plug welds by ZPMC NDT personnel. This issue discussed with ZPMC CWI Mr. Xu Le Feng and ZPMC agreed to perform the repair by approved contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
