

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-017736**Date Inspected:** 28-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:** Qiu Wen**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 & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 4A located on East tower Lift-4 Skin 'E', 119 M Cross bracing gusset plate WD1 – GUSA3 – 3 – 119M – E. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U5b – FCM.

Weld joint # 4A located on West tower Lift-4 Skin 'E', 119 M Cross bracing gusset plate WD1 – GUSA3 – 3 – 119M – W. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U5b – FCM.

BAY#10**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

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Fluxcored Arc Welding (FCAW):

Weld joint # 01 located on U-rib splice plate GGL – MQ – 1958 – 13. Welder is identified as 052763. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F. (See attached photo)

Weld joint # 02 located on U-rib splice plate GGL – MQ – 1958 – 19. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 02 located on U-rib splice plate GGL – MQ – 1958 – 13. Welder is identified as 052763. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 01 located on U-rib splice plate GGL – MQ – 1958 – 19. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 11A/B located on Lift-5 Bracket SD1 – BRSA5 – 1 as per the weld repair report #T-WR3732. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1.

Repair welding of weld joint # 12A/B located on Lift-5 Bracket SD1 – BRSA5 – 1 as per the weld repair report #T-WR3733. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 027 located on Bike Path, BK004ASD1 – 021. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 40 located on Bike Path BK004C – 024. Welder is identified as 040758. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 34 located on Bike Path BK004A3 – 020. Welder is identified as 056316. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS –

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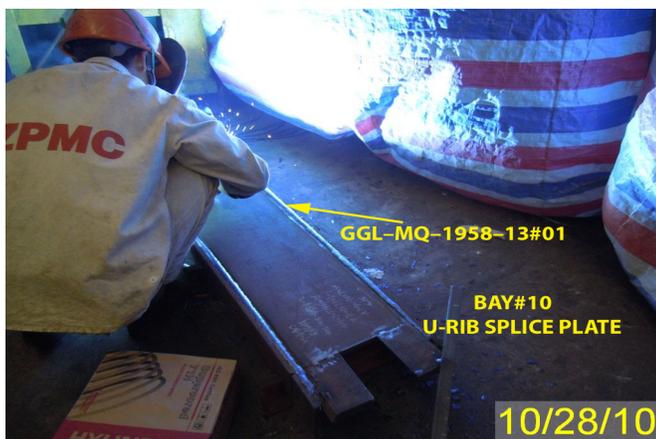
B – T – 2132.

Weld joint # 41 located on Bike Path BK004C – 024. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 004 located on Bike Path, BK004ASD1 – 021. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Repair welding of base material according to the weld repair report #B-WR14888 located on Bike path plate BKPL1A, BKPL2A. Welders are identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer