

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017742**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:** 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.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 58A located on North tower Grillage cover plate NSD1 – TL5 – 3B/F. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Weld joint # 70B located on South tower Grillage cover plate SSD1 – TL5 – 3B/F. Welder is identified as 040414.

ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1. (See attached photo)

Weld joint # 47A located on North tower Grillage cover plate NSD1 – TL5 – 3B/F. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 001 located on U-rib splice plate GGL – MQ – 1958 – 17. Welder is identified as 040533. 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 # 002 located on U-rib splice plate GGL – MQ – 1958 – 19. Welder is identified as 040533. 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 # 009 located on Bike Path, BK004A3 – 026. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

Weld joint # 007 located on Bike Path, BK004A5 – 026. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

Weld joint # 005 located on Bike Path, BK004A3 – 026. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

Weld joint # 004 located on Bike Path, BK004A5 – 026. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

BAY#11

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 124 located on Bike Path BK004A7 – 022. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Fluxcored Arc Welding (FCAW):

Weld joint # 043 located on Bike Path, BK005A1 – 003. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

Weld joint # 043 located on Bike Path, BK005A1 – 003. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

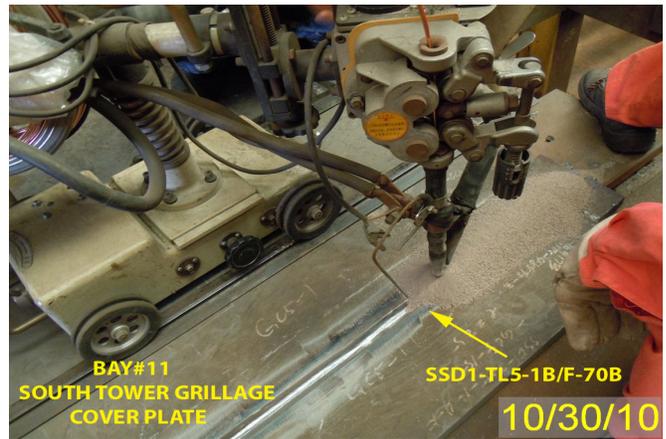
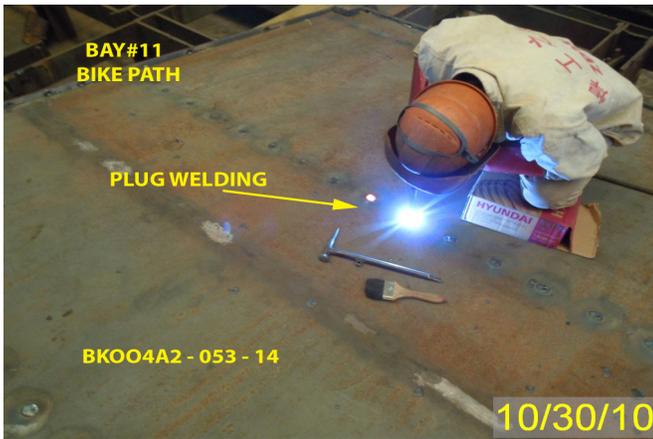
Fluxcored Arc Welding (FCAW)/Plug Welding:

Weld joint # 14 located on Bike Path BK004A2 – 053. Welder is identified as 205649. 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 – 2 – PLUG. (See attached photo)

Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004 - 24 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Yu dong Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9669.

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