

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-017943**Date Inspected:** 16-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 tao**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of plug weld is identified as 2F-019 of BK006A2-002 for BK006A-002. The welder is identified as 058792. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-2-plug.

FCAW welding of weld is identified as 3G-112 of BK004A5-009 for BK004A-009. The welder is identified as 062786. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld is identified as 1G-018 of BK006A2-001 for BK006A-001. The welder is identified as 062732. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-L1b-F-1.

FCAW welding of weld is identified as 1G-003 of BK4ASD1-005 for BK004A-005. The welder is identified as 062755. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4c-F.

FCAW welding of weld is identified as 1G-023 of BK4ASD1-012 for BK004A-012. The welder is identified as

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062739. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4c-F.

This QA inspector performed VT of cleanliness of welds and internal areas of Bike path closure box before install the top cover plate BK004A-002,008,001. Areas requiring additional grinding and cleaning were marked by QA and repaired by ZPMC personnel.

During random Quality Assurance visual review of the Bike path components, this Quality Assurance Inspector (QA) discovered the following issue:

ZPMC personnel performing weld repair of Linear Longitudinal and Transverse Indications measuring approximately 05mm to 20mm without the prior approval of the Engineer or an approved CWR.

The linear longitudinal and linear transverse indications found on the Plug welds by ZPMC Magnetic particle testing. The Bike path is identified as BK004A-002. The welds are identified as BK004A2-002-014,017,019. This is informed to ZPMC QC Mr. Xu tao. He stopped the welding and preparing CWR to get Engineer approval.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK4SD1-001-009,011,013,016,019,020

BK4SD1-008-009,013,016,019,020

BK4SD1-010-009,010,011,015,019,020

BK004A2-009-016,018

BK004A3-009-025,026

BK004A4-009-066,067

BK004A6-009-029,154,151,155

BK004A8-009-121,125,041

BK004A3-007-025,026

BK004A4-007-014,015

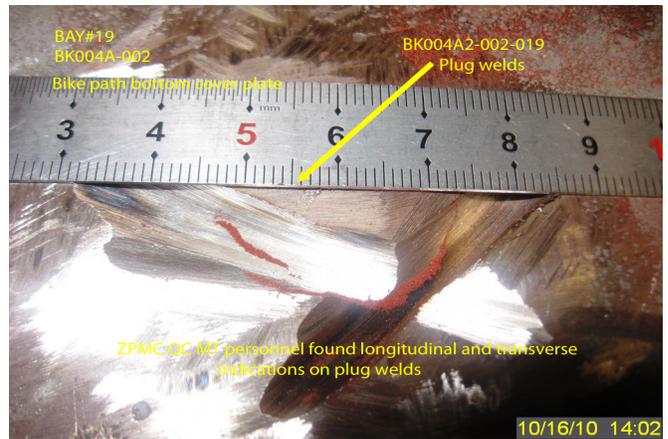
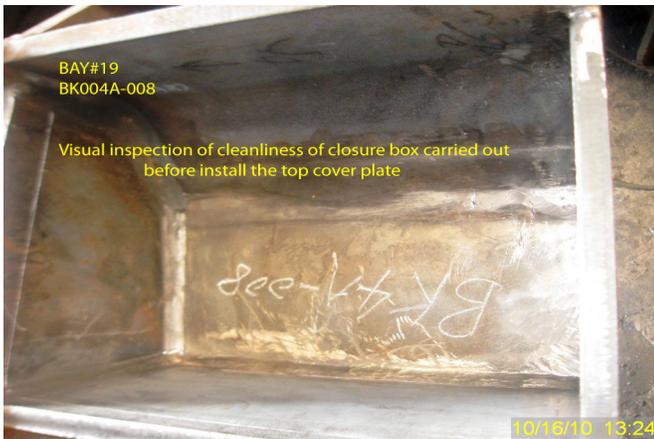
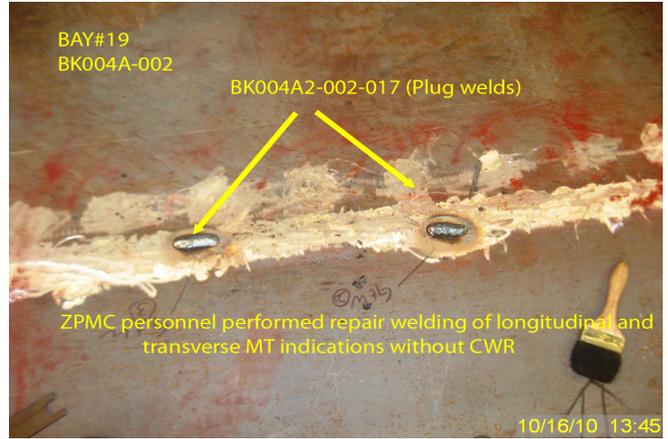
BK004A6-007-150,029,041

BK004A8-007-123,126,029

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

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Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer
