

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-018088**Date Inspected:** 06-Nov-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, Xu Le Feng**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

This QA inspector performed random Visual Testing of an area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A-020 (GREEN TAG NO. 13842, STEP 10)

BAY 10, OBG BIKE PATH (GREEN TAG NO. 13759)

This QA inspector performed green tagging for the weld joints of bearing stiffener to end plate of OBG bike path (step # 5). The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A3-027-002, 010

BK004A5-027-002, 008

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

BAY 11

OBG BIKE PATH, STRINGER PLATE

FCAW welding of weld joint 161 located on BK008A7-002.

Welder is identified as 205649. ZPMC QC is identified as Mr. Wang Chuan Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 068 located on BK008A6-002.

Welder is identified as 040723. ZPMC QC is identified as Mr. Wang Chuan Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2131.

TOWER BRACKET

SMAW welding of weld joint 019B located on ND1-BRSA5-2.

Welder is identified as 040724. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-Tc-U4b.

SMAW welding of weld joint 006A located on SD1-BRSA5-1.

Welder is identified as 044541. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b.

TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 053A located on ESD1-TL5-2B/F.

Welder is identified as 040699. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

OBG BIKE PATH, BOTTOM COVER PLATE REPAIR (B-CWR2163, REV. 0)

SMAW welding of weld joints 014, 015, 017, 019, &020 located on BK004A2-053.

Welders are identified as 202100 & 040655. ZPMC CWI is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

TOWER GRILLAGE COVER PLATE

During random in process inspection this QA inspector observed the melt through on the weld during root pass by SAW welding process of the weld joint ESD1-TL5-2B/F-062A. This issue has been discussed with ZPMC CWI Mr. Xu Le Feng and ZPMC agreed to do the repair as per contract document and approved repair procedure.

BAY 10

OBG BIKE PATH, BEARING PLATE

FCAW welding of weld joint 010 located on BK004A3-029.

Welder is identified as 040302. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4c-F.

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FCAW welding of weld joint 002 located on BK004A5-029.

Welder is identified as 053869. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4c-F.

TOWER FACADE

SMAW welding of weld joint 032 located on ND1-SFSA4-090-6.

Welder is identified as 040365. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

SMAW welding of weld joint 012 located on ND1-SFSA4-711-1.

Welder is identified as 040581. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

OBG BIKE PATH, BK004A-029, B-WR16597

During random in process inspection this QA inspector observed that ZPMC personnel were performing buttering of approximately 5~6mm on the edge of stringer plates of OBG bike path according to ZPMC inspection report ZP06-787-J-B-1810. Welder is identified as 040268. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-REPAIR.

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/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad, Umesh

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer