

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-018091**Date Inspected:** 03-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**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 # 19 located on North tower Lift-4 Skin 'A', 119 M Backfill plate NSD1 – FESA4 – 3B/F. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified Zhong Bei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2313 – Tc – P4.

Weld joint # 06 located on South tower Lift-4 Skin 'E', 119 M Backfill plate SSD1 – FESA4 – 1B/F. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified Zhong Bei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 3212 – B – U2a – 2.

(See attached photo)

Weld joint # 16 located on North tower Lift-4 Skin 'A', 119 M Backfill plate NSD1 – FESA4 – 1B/E. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Zhong Bei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4212 – Tc – U4c – 4.

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BAY#10

This QA Inspector observed the following work in progress

Submerged Arc Welding (SAW):

Weld joint # 42B located on North tower Grillage cover plate SSD1 – TL5 – 1B/F. Welder is identified as 0503060. 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 # 59B located on North tower Grillage cover plate SSD1 – TL5 – 1B/F. Welder is identified as 0503060. 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.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 098 located on Bike Path, BK004A6 – 025. Welder is identified as 040583. 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 – 2332 – Tc – P4 – F.

Weld joint # 034 located on Bike Path, BK004A4 – 026. Welder is identified as 052075. 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 – 2132.

Weld joint # 102 located on Bike Path, BK004A8 – 025. 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 – 2333 – Tc – P4 – F.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ABF Quality Control personnel. The member is identified as OBG Component. The component designation is identified as follows:

BIKE PATH : BK004A2 – 028 – 016; 018

(See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 19B located on Lift-5 bracket ND1 – BRSA5 – 2. Welder is identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Submerged Arc Welding (SAW):

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Weld joint # 69B located on East tower Grillage cover plate ESD1 – TL5 – 2B/F. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

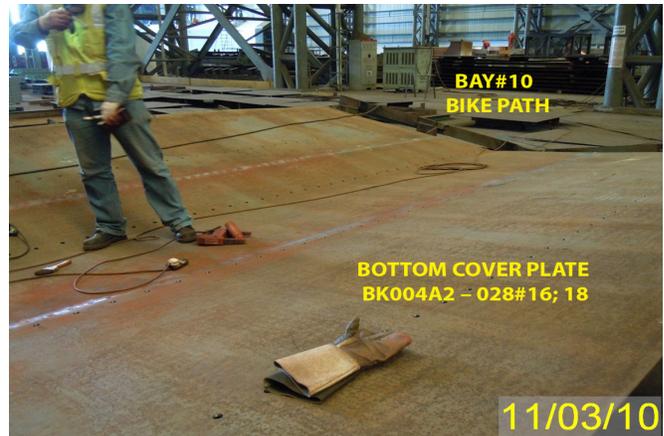
This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 016 located on Bike Path, BK005A2 – 003. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F – 1.

Weld joint # 018 located on Bike Path, BK005A2 – 003. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F – 1.

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
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Reviewed By:	Clifford,William	QA Reviewer
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