

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-018341**Date Inspected:** 16-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: | Zhao Chen Sun | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | | |
|----------------------------------|-----|----|-----|
| CWI Present: | Yes | No | |
| Rod Oven in Use: | Yes | No | N/A |
| Weld Procedures Followed: | Yes | No | N/A |
| Verified Joint Fit-up: | 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

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-2021-040. Welder is identified as 040458. 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 – 2231 – Tc – U4b – F.

Weld joint # 002 located on U-rib splice plate, GGL-MQ-2021-024. Welder is identified as 057180. 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 – 2232 – Tc – U4b – F.

Shielded Metal Arc Welding (SMAW):

Repair welding of base material according to the weld repair report #B-WR14889 located on Bike path BK4A1-026. Welder is identified as 056364. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The

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welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 15A located on Lift-5 bracket SD1 – BRSA5 – 1. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – TC – U4b – 1.

Weld joint # 19B located on Lift-5 bracket SD1 – BRSA5 – 1. Welder is identified as 054460. 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.

MEASUREMENTS OF TOWER STRUTS

This QA Inspector carried out the measurements on Tower Struts of lift-4 to check the length, flange to flange distance, stiffener to stiffener distance, fillet weld termination at the cope hole of stiffeners and distance from bolt hole to edge of the strut. Measurements were recorded on the data sheet and submitted to the assigned task leader. The identified component designations reviewed are as follows.

TOWER STRUTS

1. WD1-STSA4-5-119M-1
2. SD1-STSA4-5-119M-1
3. ND1-STSA4-10-119M-1
4. ND1-STSA4-10-119M-2
5. ED1-STSA4-10-119M-1
6. ED1-STSA4-10-119M-2
7. WD1-STSA4-5-127M-1
8. SD1-STSA4-5-127M-1
9. ND1-STSA4-6-127M-2
10. WD1-STSA4-5-135M-1
11. SD1-STSA4-5-135M-1
12. ND1-STSA4-6-135M-2
13. ND1-STSA4-6-139M-1
14. ND1-STSA4-6-139M-2
15. SD1-STSA4-5-139M-1
16. ED1-STSA4-6-139M-2

During the survey on the tower struts mentioned above, the following strut length found to be out of tolerance as per the ABF-RFI-1945R01:

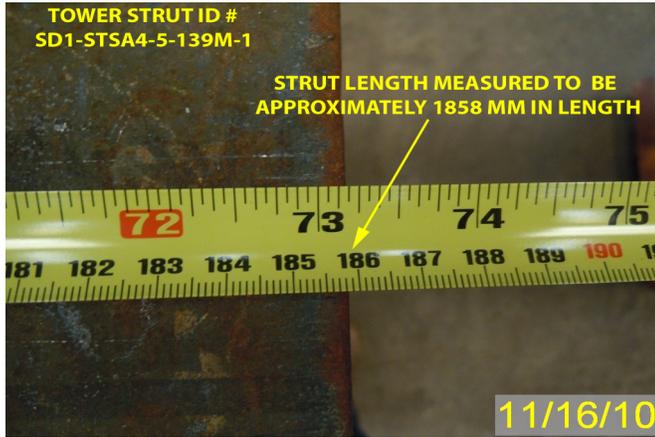
1. SD1-STSA4-5-139M-1 - Measured length is 1858 mm, but required is 1860 mm with the tolerance +20 / -0. (Strut type-3)

For further information please see the below attached pictures.

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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
