

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-018348**Date Inspected:** 17-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:** 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:** 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

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007395

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

SOUTH TOWER LIFT-4 AT 119M ELEVATION, BACKFILL PLATE

SSD1 – FASA4 – 1B/E # 14 ~17

BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 033 located on Façade Channel built-up assembly, ND1-SFSA4-90-3. Welder is identified as 057266.

ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC

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appeared to comply with the WPS – B – T – 2132.

Weld joint # 012 located on Façade Channel built-up assembly, ND1-SFSA4-710-2. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 002 located on Façade Channel built-up assembly, ND1-SFSA4-38. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Shielded Metal Arc Welding (SMAW):

Weld joint # 032 located on Façade Channel built-up assembly, ND1-SFSA4-90-3. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Weld joint # 014 located on Façade Channel built-up assembly, ND1-SFSA4-710-2. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Weld joint # 010 located on Façade Channel built-up assembly, ND1-SFSA4-9. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Witness of Magnetic Particle Testing (MT)

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

BIKE PATH : BK004A5 – 032 – 018; 019; 58; 59; 38~41

(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 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. (See attached photo)

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, BK008A2 – 002. Welder is identified as 053316. ZPMC Quality Control

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(QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – L1b – F – 1.

Weld joint # 017 located on Bike Path, BK004A3 – 019. Welder is identified as 040723. 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 – 2132.

Weld joint # 018 located on Bike Path, BK008A2 – 002. 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 – 2231 – B – L1b – F – 1.

Weld joint # 023 located on Bike Path, BK004A6 – 019. Welder is identified as 205649. 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 – 2132.

BAY#12

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007392

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

U-RIB SPLICE PLATE

SA3061A-001-001

SA3061B-013-003

SA3061B-012-003

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

U-RIB SPLICE PLATE

SA3061A-001-001

SA3061B-013-003

SA3061B-012-003

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

U-RIB SPLICE PLATE – GREEN TAG#15490

SA3061B-007-003

SA3061B-008-003

SA3061B-009-003

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SA3061B-010-003

SA3061B-011-003

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