

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-018361**Date Inspected:** 20-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. 007426

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 TOWER Component. The weld designation reviewed as follows:

WEST AND EAST TOWER MANHOLE HINGE OF 139 M ELEVATION

DA4-5-3,4-W-139M

DA4-5-3,4-E-139M

OPEN YARD (NEAR TO OBG TRIAL ASSEMBLY YARD)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007427

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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 TOWER Component. The weld designation reviewed as follows:

TOWER LADDER

ESD1-LASA4-2

SSD1-LASA4-3, 4

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 13 located on Bike Path BK004A2 – 025. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132. (See attached photo)

Weld joint # 08 located on Bike Path BK004A2 – 025. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 02 located on Bike Path BK004A2 – 025. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 44 located on Bike Path BK004A1 – 032. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Weld joint # 48 located on Bike Path BK004A8 – 032. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 44 located on Bike Path BK004A1 – 032. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Weld joint # 105 located on Bike Path BK004A6 – 032. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY#11

This QA Inspector observed the following work in progress

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Shielded Metal Arc Welding (SMAW):

Weld joint # 2B 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.

Repair welding of weld joint # 6B located on Lift-5 bracket ND1 – BRSA5 – 2 as per the weld repair report T-WR3772. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – REPAIR – 1. (See attached photo)

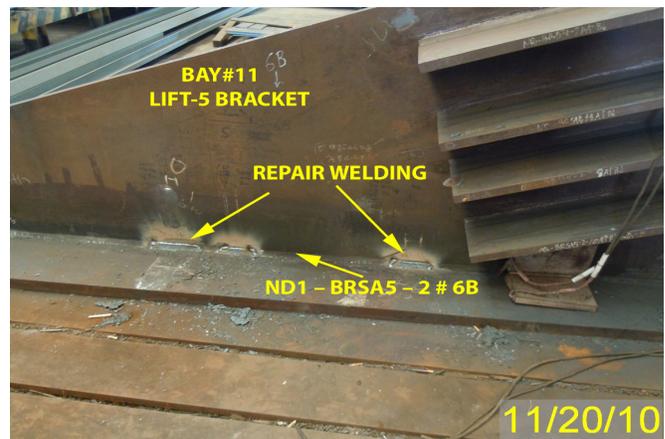
Weld joint # 3B located on Lift-5 bracket SD1 – BRSA5 – 1. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Fluxcored Arc Welding (FCAW):

Weld joint # 07 located on Lift-6 Tower Head of skin ‘A’ WSD1 – FCSA6 – 4. Welder is identified as 040723. 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 – 2132.

Weld joint # 08 located on Lift-6 Tower Head of skin ‘A’ WSD1 – FCSA6 – 4. Welder is identified as 053316. 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 – 2132.

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.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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