

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-018364**Date Inspected:** 24-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, Geng Wei**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 10, TOWER FACADE (NWIT # 7474)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

ND1-SFSA4-90-2-002, 003, 004, 006, 027, 028, 031~034

ND1-SFSA4-11-001, 002, 003, 004, 005

ND1-SFSA4-11-008

ND1-SFSA4-43-001, 002

ND1-SFSA4-95-003, 004, 005, 007, 009, 011~014

BAY 14, OBG (NWIT # 7478)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3007L-043, 044
SEG3007K-40

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

Bay 10

OBG BIKE PATH

SMAW welding of weld joint 044 located on BK004A1-033.
Welders are identified as 500363, 056200 & 052493. ZPMC QC is identified as Mr. Li Jun.
The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

BAY 11

TOWER BRACKET REPAIR

SMAW welding of weld joint 006A/B located on NSD1-BRSA5-2.
Welder is identified as 044541. ZPMC QC is identified as Mr. Li Bin.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR.

BAY 14

OBG DECK PANEL DIAPHRAGM TO U-RIB

FCAW welding of weld joints 095 & 096 located on DP3091-001 (13BE).
Welder is identified as 217805. ZPMC QC is identified as Mr. Zhong Guo Hui.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

FCAW welding of weld joints 127 & 128 located on DP3089-001 (13BE).
Welder is identified as 044790. ZPMC QC is identified as Mr. Zhong Guo Hui.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

FCAW welding of weld joints 112 & 113 located on DP3106-001 (13CE).
Welder is identified as 068920. ZPMC QC is identified as Mr. Zhong Guo Hui.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
----------------------	---------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------