

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-018937**Date Inspected:** 02-Dec-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:** Mr. 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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #10

This QA Inspector observed the following work in progress

Tower

Flux Cored Arc Welding (FCAW)

Repair welding of Weld joint # 2 located on Lift 6 Skin plate to stiffener SSD1-FBSA6 -1. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW -2G (2F) -Repair.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07591

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted

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by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as OBG Bike path components. The weld designations reviewed are as follows:

BK004ASD -027 – Jt. nos. -011, 012, 25, 07

BK004A6 -027 – Jt. nos. -002, 165

BK004A8 -027 – Jt. nos. -001, 007

Bay #11

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

Repair of Weld joint # 19A/B as per Welding repair report no. T –WR -3780, located on Lift 5 Bracket SD1 –BRSA5-1. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW -3G (3F) – Repair.

Weld joint # 13, 11 located on West Tower, Lift4, 119 mtr., Skin A, Façade Connection plate WSD1-FASA4 -2 B/E. Welder is identified as 202323. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4311 –TC-P4-1.

Weld joint # 7, 9 located on West Tower, Lift4, 119 mtr., Skin A, Façade Connection plate WSD1-FASA4 -2 B/E. Welder is identified as 202323. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4314 –TC-P4-2.

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 019 located on Bike path BK 004A2 -022, Hole plugging. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 -Plug.

Weld joint # 003, 005 located on Bike path BK 004A6 -019. Welder is identified as 045560. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Weld joint # 152, 153 located on Bike path BK 004A6 -019. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply

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with the WPS – B – P – 2114.

Weld joint # 036, 037 located on Bike path BK 008A5 -002. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 -Esab.

Magnetic Particle Testing (MT)

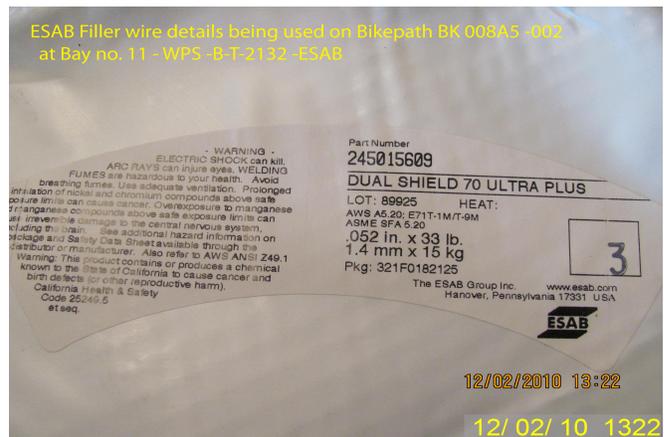
The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07583

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as Tower components, East tower, Lift 4, Grating Brackets in 116 mtr. elevation. The weld designations reviewed are as follows:

GGSA -69PLAN -116mtr.-1 -E – Jt. nos. -03, 04, 06

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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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 Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
