

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-018938**Date Inspected:** 03-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)

Weld joint # 7, 8 located on Lift 6 Skin plate to stiffener SSD1-FBSA6 -1. Welder is identified as 040302, 057258.

ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Shielded Metal Arc Welding (SMAW)

Weld joint # 3, located on Façade plate Manhole cover SD1 –SFSA4 -10A/B. Welder is identified as 040365.

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 -2112.

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Weld joint # 19, 20 located on Façade plate Manhole cover SD1 –SFSA4 -10A/B. Welder is identified as 040581. 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 -2112.

Bay #11

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

Weld joint # 38 located on East Tower, Lift4, Skin E, Ladder support plate ESD1-FASA4 -2 A/E. Welder is identified as 068091. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P - 2112.

Weld joint # 39 located on East Tower, Lift4, Skin E, Ladder support plate ESD1-FASA4 -2 A/E. Welder is identified as 067752. 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 - 4112.

Submerged Arc Welding (SAW)

Weld joint # 19B located on Lift 6 Skin Plate ESD1 –TPSA6 -2. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 –L2C -2.

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 014 located on Bike path BK 004A2 -034, 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.

Flux Cored Arc Welding (FCAW)

Weld joint # 013, 014 located on Bike path BK 008A6 -002. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 - ESAB.

Weld joint # 013, 014 located on Bike path BK 008A8 -002. Welder is identified as 054460. 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 – T – 2132 - ESAB.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07602, 07608

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 OBG Bike path components. The weld designations reviewed are as follows:

BK004ASD1 -022 – Jt. nos. -011, 019, 20, 07, 12

BK004A8 -023 – Jt. no -036

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.



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

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your project.

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