

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-018942**Date Inspected:** 07-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 # 2, 3 located on North Tower, Lift6, Skin to stiffener NSD1 -FCSA6 -3. Welder is identified as 040302, 040533. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS - B - P - 2132 -ESAB.

Shielded Metal Arc Welding (SMAW)

Weld joint # 15 located on Lift6, Manhole cover plate SSD1 -FESA6-1. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS - B - T - 2312 -TC -P4.

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Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Weld joint # 021 located on Bike path BK 004A2 -029. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 -Esab.

Shielded Metal Arc Welding (SMAW)

Weld joint # 008 located on Bike path BK 004A2 -029. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 045, 046 located on Bike path BK 004A4 -031. Welder is identified as 040268, 056364. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07667

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Bike path components. The weld designation reviewed as follows:

BK004ASD1 -027 – Jt. nos. -022, 023, 024, 027, 001, 004, 003, 002

Bay #11

This QA Inspector observed the following work in progress

Tower

Flux cored Arc welding (FCAW)

Weld joint # 05, 06 located on East Tower, Lift6 plate ESD1-FCSA6 -2. Welder is identified as 040704, 053316. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 -Esab.

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Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Weld joint # 037, 038 located on Bike path BK 004C8 -023. 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 – P – 2112 .

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 your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer