

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-018956**Date Inspected:** 12-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

Shielded Metal Arc Welding (SMAW)

Weld joint # 69, 71 located on North Tower, Lift4, Skin B, Façade support plate NSD1- FBSA4 -1A/C. Welder is identified as 040582, 050038. 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 -2114.

Weld joint # 73, 75 located on North Tower, Lift4, Skin B, Façade support plate NSD1- FBSA4 -1A/C. Welder is identified as 040581, 044504. 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 -2114.

Flux cored Arc welding (FCAW)

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Weld joint # 76 located on North Tower, Lift4, Skin B, Façade support plate NSD1- FBSA4 -1A/C. Welder is identified as 053116. 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 -2132 -ESAB.

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Weld joint # 017 located on Bike path BK 004A2 -030. Welder is identified as 066326. 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 -Plug.

Bay #11

This QA Inspector observed the following work in progress

Tower

Flux cored Arc welding (FCAW)

Weld joint # 12 located on West Tower, Lift4, Skin E, Façade support plate WSD1- FESA4 -4 B/F. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 -Esab.

Weld joint # 1 located on West Tower, Lift4, Skin E, Façade support plate WSD1- FESA4 -4 C/F. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 -Esab.

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Weld joint # 012 located on Bike path BK004ASD1 -019. Welder is identified as 044551. ZPMC Quality Control (QC) Inspector is identified as You Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B –P-2113.

Magnetic Particle Testing (MT)

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

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07744

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. The weld designations reviewed are as follows:

ESD1 –FASA4-2B/E – Jt. nos. -9, 10

ESD1 –FASA4-2B/E -3– Jt. nos. -16, 30

ESD1 –FASA4-2B/E -5– Jt. no. – 30,21,22,23,24

ESD1 –FASA4-2B/E -2– Jt. nos. -21, 22, 23, 24

ESD1 –FBSA4-2A/C– Jt. nos. -78, 79, 80, 81

Blast shop #1

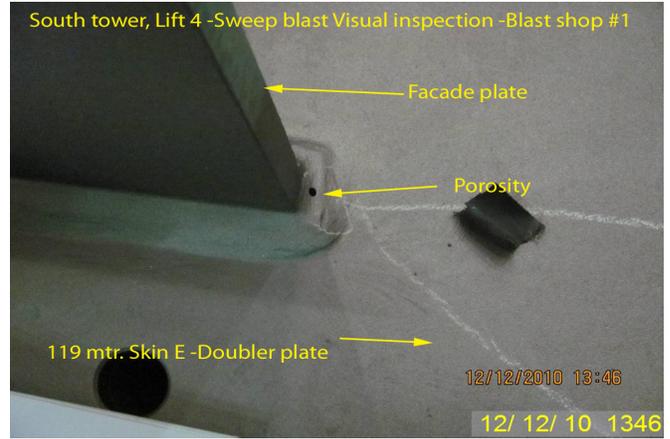
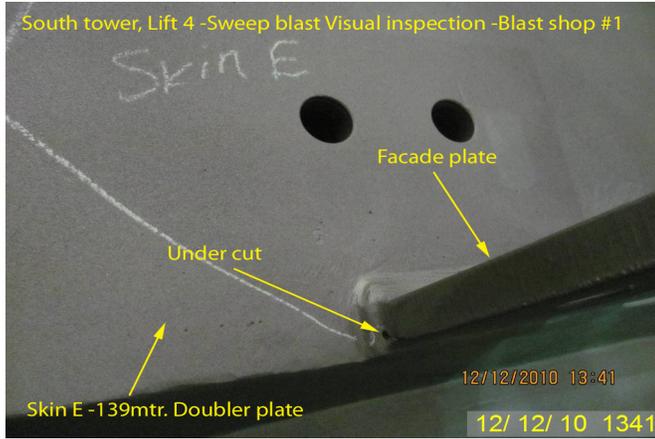
This QA inspector, Baskar Govindarajan, performed Post blast inspection of external surfaces of South tower, Lift 4. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 114 mtr. to 146 mtr. Elevation. This inspection was carried out along with QA Inspector Mr. Robin Sharma (B 309), Mr. Scott (B 319), Mr. Anand Upadhye (B 297), and Mr. Vikram (B 300) . All the marked points shown to ZPMC inspector Mr. Zhao Chen Sun and ABF Inspector Mr. Xing Xiao Guang. All the weld repair areas (9 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector.

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