

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-018963**Date Inspected:** 15-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. Qiu Wen	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 #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Weld joint # 222 located on H Beam to Floor beam SEG 3013R -P.P 117.5 in segment 13AW. Welder is identified as 066734. ZPMC Quality Control (QC) Inspector is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS - B - T - 2233 -Esab.

Repair welding of Weld joint # 030 as per CWR no. B-CWR -2424, located on Deck panel DP3133 in segment 13CW. Welder is identified as 058245. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS - 345 -FCAW -2G (2F) -Esab -Repair.

Repair welding of Weld joint # 049 as per CWR no. B-CWR -2439, located on Deck panel DP3149 in segment 13CW. Welder is identified as 048143. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welding variables recorded by QC appeared to comply with the WPS – 345 –FCAW -2G (2F) –Esab -Repair.

Weld joint # 38, 39 located on Side panel to Floor beam SEG 3007 AD –P.P 120 in segment 13AE. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 -Esab.

Weld joint # 179 located on Longitudinal diaphragm LD3027 to stiffener seg 3011 m –P.P 121.5 in segment 13AE. Welder is identified as 037932. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2114 –FCM -1.

Shielded Metal Arc Welding (SMAW)

Weld joint # 022 located on Side panel to floor beam SEG 3013AD in P.P 120 in Segment 13AW. Welder is identified as 067764. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B –P-2214 –TC –U4B –FCM -1.

Submerged Arc Welding (SAW)

Weld joint # 431PD located on Tie Down seat sub assembly Anchor plate. Welder is identified as 045265. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS – B –T-2321 –B –P3 –S-2.

Blast shop #1

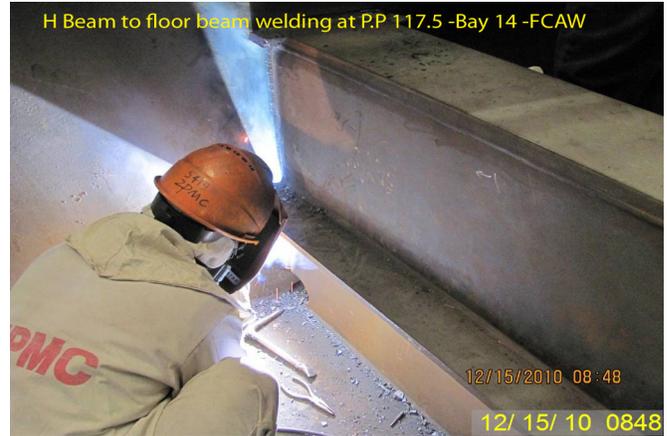
This QA inspector, Baskar Govindarajan, performed Post blast inspection of internal surfaces of East tower, Lift 4 from 131 mtr. to 146 mtr. elevation. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower . This inspection was carried out along with QA Inspector Mr. Sandeep Kumar (B 227), Mr. Anand (B 297), Mr. Vikram (B 300), Mr. Shailesh (B 295) and Mr. Robin (B309) . All the marked points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Wang. All the weld repair areas (7 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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