

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-018964**Date Inspected:** 16-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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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)

Repair welding of Weld joint # 024 as per CWR no. B-CWR -2411, located on Deck panel DP3135 in segment 13BW. Welder is identified as 045276. 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 –FCM-Repair.

Repair welding of Weld joint # 241 as per CWR no. B-CWR -2403, located on Deck panel DP3146 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 – FCM -Repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding of Weld joint # 251 as per CWR no. B-CWR -2417, located on Deck panel DP3148 -001 in segment 13BW. Welder is identified as 045240. 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 – FCM -Repair.

Repair welding of Weld joint # 248 as per CWR no. B-CWR -2416, located on Deck panel DP3148 -001 in segment 13CW. Welder is identified as 045209. 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 – FCM -Repair.

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 017 , located on Floor beam to stiffener, P.P 120, FB 3201, SEG 3013B in segment 13AW. Welder is identified as 045221. ZPMC Quality Control (QC) Inspector is identified as Li Shi You. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -3G (3F) – Repair .

Repair welding of Weld joint # 104 as per WRR no. B-WR-18681 located on Floor beam SEG 3013P in P.P 118 in Segment 13AW. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Wang Xiang Qin. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -3G (3F) -Repair.

Submerged Arc Welding (SAW)

Weld joint # 030 located on Deck panel DP3167 to DP 3161 in segment 14E. Welder is identified as 044771. ZPMC Quality Control (QC) Inspector is identified as Zhan hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B –T-2221 –B –U2C –S-2.

Weld joint # 392 located on Deck panel DP3161 to DP 3162 in segment 14E. Welder is identified as 044771. ZPMC Quality Control (QC) Inspector is identified as Zhan hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B –T-2221 –B –U2C –S-2.

Weld joint # 023 located on Deck panel DP3162 to DP 3163 in segment 14E. Welder is identified as 044771. ZPMC Quality Control (QC) Inspector is identified as Zhan hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B –T-2221 –B –U2C –S-2.

Blast shop #1

This QA inspector, Baskar Govindarajan, performed Post blast inspection of External surfaces of North tower, Lift 4 from 114 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. Pillai (B 286), Mr. Vikram (B 300), and Mr. Larry viars (B 252) . All the marked

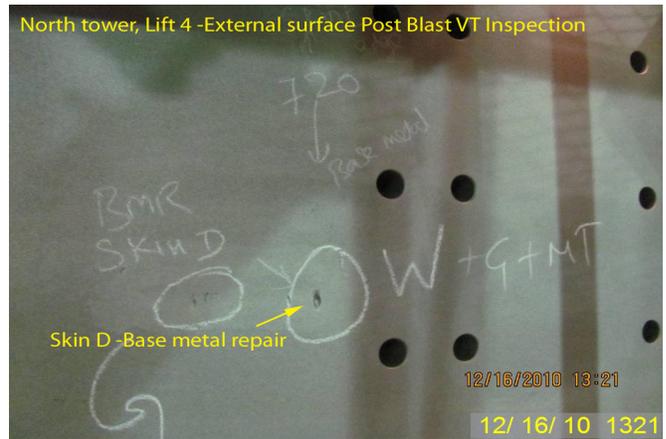
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Wang. All the weld repair areas (2 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.



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
