

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-018968**Date Inspected:** 18-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:	OBG/ Tower	

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 # 002, located on Anchor Bearing plate SEG 3013A -001, piece no. 4319C. Welder is identified as 048433. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B –T -2231 -Esab.

Weld joint # 002, located on Anchor Bearing plate SA3161B -001. Welder is identified as 048245. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B –T -2231 -Esab.

Weld joint # 001, located on Side plate to Bottom plate SEG3020AZ -001. Welder is identified as 045175, 202122. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC

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appeared to comply with the WPS – B –T -2231 -Esab.

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 241 as per CWR no. B-CWR -2451, located on Deck panel DP3122 in segment 13AW. Welder is identified as 045133. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) –ESAB – FCM -Repair.

Repair welding of Weld joint # 013 as per CWR no. B-CWR -2459, located on Deck panel DP3122 -001 in segment 13AW. Welder is identified as 066398. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) –ESAB – FCM -Repair.

Blast shop #2

This QA inspector, Baskar Govindarajan, performed Post blast Visual inspection of External surfaces of West 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. Pillai (B 286), Mr. Vikram (B 300), and Mr. Larry viars (B 252) . All the marked points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Yang Yi Heng. All the weld repair areas (6 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector.

Blast shop #1

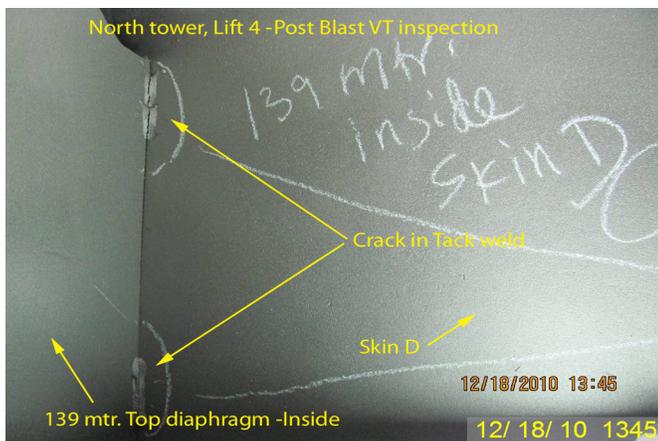
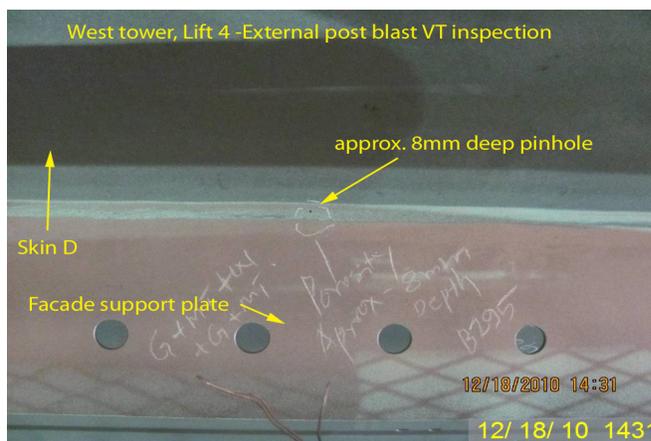
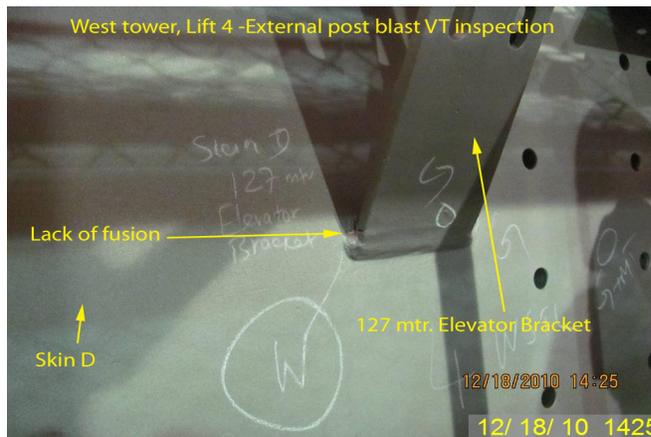
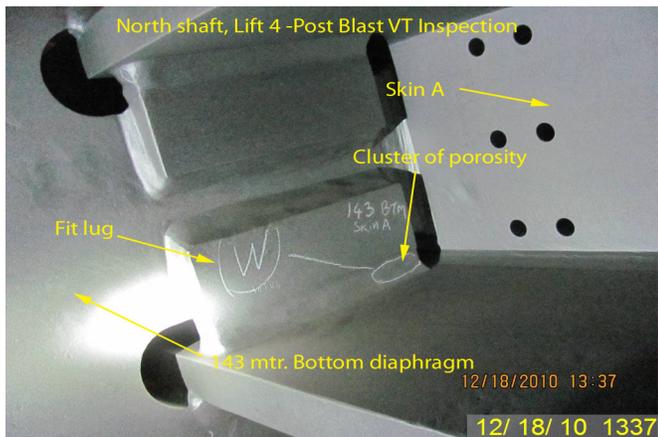
This QA inspector, Baskar Govindarajan, performed Post blast Visual inspection of Internal surfaces of North tower, Lift 4 from 131 mtr. Top Diaphragm to 146 mtr. elevation. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower. This inspection was carried out along with QA Inspector Mr. Pillai (B 286), Mr. Vikram (B 300), and Mr. Larry viars (B 252) . All the marked points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Yang Yi Heng. All the weld repair areas (8 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

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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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