

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-018974**Date Inspected:** 20-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:** Guo Yan Fei**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007855

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

BIKE PATH

BK004A6-031-128; 003; 005; 008; 010; 025~028; 004; 006; 009; 011

BK004A8-031-003; 005; 008; 010; 004; 006; 009; 011

This QA Inspector observed the following work in progress

Heat Straightening:

Heat Straightening being performed on Bike Path component identified as BK004-031 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as

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Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9343. (See attached photo)

Flux Cored Arc Welding (FCAW):

Weld joint # 06 located on Bike Path BK004A1 – 030. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB. (See attached photo)

Weld joint # 01 located on Bike Path BK004A1 – 030. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 05 located on Bike Path BK004A1 – 030. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 10 located on Bike Path BK004A1 – 030. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Sub-merged Arc Welding (SAW):

Weld joint # 001 located on Bike path stringer plate BK009A4 – 001. Welder is identified as 503060. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Weld joint # 007 located on Bike path stringer plate BK009A4 – 001. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Weld joint # 004 located on Bike path stringer plate BK009A4 – 001. Welder is identified as 207745. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Weld joint # 004 located on Bike path stringer plate BK009A3 – 001. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Heat Straightening:

Heat Straightening being performed on Lift-6 tower head components identified as SSD1-FCSA6-1 and NSD1-FCSA6-3 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11643.

Heat Straightening being performed on Lift-6 tower head component identified as NSD1-FCSA6-3 by

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oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11649.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
