

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-018975**Date Inspected:** 21-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 # 271 located on Side plate to Edge plate SEG 3015B in segment 13CW. Welder is identified as 201583. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2232-Esab.

Weld joint # 195 located on Floor beam to Edge plate SEG 3015K in segment 13C W, . Welder is identified as 067876. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2233-Esab.

Weld joint # 052 located on Hinge plate to Bottom plate, SEG 3020D in segment 14W. Welder is identified as 047866. 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 -2232-Esab.

Weld joint # 068, 069 located on Floor beam to Bottom plate, SEG 3020P in segment 13CW. Welder is identified as 067550. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2132-Esab.

Shielded Metal Arc Welding (SMAW)

Weld joint # 271 located on Side plate to Edge plate SEG 3015B, in segment 13CW. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –P -2212 –B –U2 –FCM -1.

Repair welding of Weld joint # 119 as per WRR no. B –WR -18791, B-WR -18792, located on Deck panel DP 3137 -001 in segment 13BW. Welder is identified as 067611 and 047864. 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) -FCM – Repair.

Repair welding of Weld joint # 251 as per CWR no. B –CWR -2417, located on Deck panel DP 3148 -001 in segment 13BW. Welder is identified as 037780. 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) -FCM – Repair.

Weld joint # 065, 066 located on Longitudinal diaphragm to Floor beam stiffener SEG 3013Q in segment 13AW. Welder is identified as 045221. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B –P -2212 –TC-U4B-FCM-1.

Blast shop #1

This QA inspector, Baskar Govindarajan, performed Post blast inspection of internal surfaces of West tower, Lift 4. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 131 mtr. Top diaphragm to 146 mtr. Elevation. This inspection was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227, Mr. Umesh (B 282), Mr. Shailesh (B 295), and Mr. Anand (B 297) . All the marked points shown to ZPMC inspector Mr. Zhu Feng and ABF Inspector Mr. Yang. 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:-

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevent 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
