

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-018979**Date Inspected:** 22-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: Yu Dong Ping
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:** 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

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 41 located on Bike Path BK004A1 – 030. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – ESAB.

Weld joint # 42 located on Bike Path BK004A1 – 030. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – ESAB.

Shielded Metal Arc Welding (SMAW):

Weld joint # 37 located on Bike Path BK004A1 – 030. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2312 – Tc – P4.

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Weld joint # 40 located on Bike Path BK004A1 – 030. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2312 – Tc – P4.

Weld joint # 35 located on Bike Path BK004A – 030. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 40 located on Bike Path BK004A1 – 030. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2312 – Tc – P4.

Weld joint # 31 located on Bike Path BK004A – 030. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 17 located on Bike Path BK004A – 030 – MEP. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 02 located on Bike Path BK005A8 – 003. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 130 located on Bike Path BK005A8 – 003. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – ESAB.

Weld joint # 22 located on Bike Path BK4ASD1 – 023. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Weld joint # 32 located on Bike Path BK004A1 – 019. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 44 located on Bike Path BK008A1 – 002 as per the weld repair report#B-WR19271.

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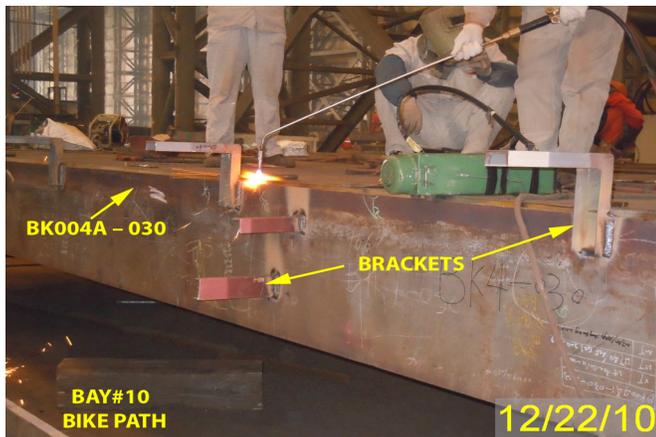
(Continued Page 3 of 3)

Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

Repair welding of weld joint # 44 located on Bike Path BK008A1 – 002 as per the weld repair report#B-WR19271.

Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

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
