DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018986
Date Inspected: 26-Dec-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1100
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Yu Dong Ping			**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

This QA Inspector observed the following work in progress
Flux Cored Arc Welding (FCAW):
Weld joint # 13 located on Bike Path BK004A2 – 031. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 08 located on Bike Path BK004A2 – 031. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 13 located on SA3138 – 001. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Weld joint # 02 located on SA7006 – 004. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector

is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Weld joint # 05 located on SA3138 – 001. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – ESAB.

Shielded Metal Arc Welding (SMAW):
Weld joint # 15 located on Bike Path BK004A – 031. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – plug.

Weld joint # 19 located on Bike Path BK004A – 031. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – plug.

Sub-merged Arc Welding (SAW):
Weld joint # 001 located on Bike path stringer plate BK009A1 – 001. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

Heat Straightening:
Heat Straightening being performed on tower head component identified as NSD1-FDSA6-3 by oxy-acetylene flame method to remove the distortion that occured 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 (B) – 11644.

BAY#11

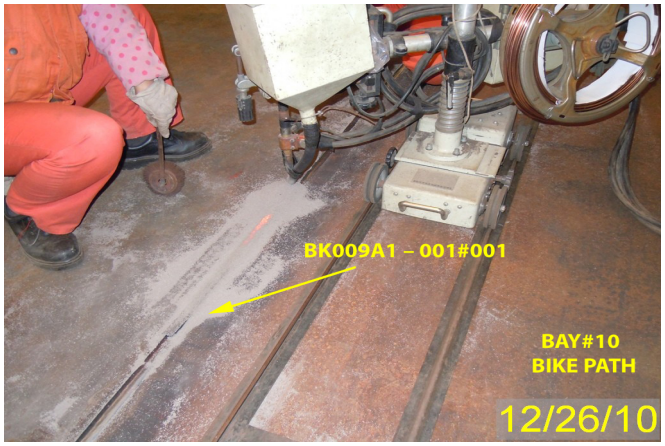
This QA Inspector observed the following work in progress
Shielded Metal Arc Welding (SMAW):
Weld joint # 11 located on Bike Path BK5ASD1 – 003. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 15 located on Bike Path BK5ASD1 – 003. 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 – B – P – 2113.

Weld joint # 26 located on Bike Path BK005ASD1 – 003. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2313 – Tc – U4c. (See attached photo)

WELDING INSPECTION REPORT

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