

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019087**Date Inspected:** 12-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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 Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007749

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB018-102-025,037,055,067,011,018,001,004
2. SB018-102-005,007,008,020,077,010,013,016,052
3. SB018-102- 058,029,023,002,021,027,034,040,045,046

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB022-104-006 located on Suspender Bracket SB104W. ZPMC Welder is identified as 058792. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

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FCAW welding of weld joint SB023-106-006 located on Suspender Bracket SB106E. ZPMC Welder is identified as 062732. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

FCAW welding of weld joint SB023-104-006 located on Suspender Bracket SB104E. ZPMC Welder is identified as 062783. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

FCAW welding of weld joint SB022-106-006 located on Suspender Bracket SB106W. ZPMC Welder is identified as 062732. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

ZPMC personnel performing heat straightening on bottom cover plate of OBG bike path member identified as BK004A-006-014~021. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9501.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Suspender Bracket SB98E and SB98W. See the attaché pictures.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3007AD-022, 024, 026 located on side plate to FL3 of OBG Segment 13AE. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3007AD-023, 025, 027 located on side plate to FL3 of OBG Segment 13AE. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2214-Tc-U4b-FCM-1.

SMAW repair welding of weld joint SEG3007E-035 located on OBG Segment 13AE. ZPMC welder is identified as 200113. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is used as per Welding Repair Report (WRR) B-WRR-18483.

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:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer