

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-019646**Date Inspected:** 28-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**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. Liu Fa 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**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 #8

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 043 as per CWR no. B-CWR 2481, located on Bike path, OBG Component BK 004A1 -062. Welder is identified as 069894. ZPMC Quality Control (QC) Inspector is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW -2G (2F) -Repair.

Bay #3

Shielded Metal Arc Welding (SMAW)

Weld joint # 265, located on OBG Component, Lift 13 Side plate to stiffener SP 3071-001. Welder is identified as 037996. ZPMC Quality Control (QC) Inspector is identified as Zhang Ya Xu. The welding variables recorded by

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

QC appeared to comply with the WPS – B –P -2213 –TC-U4B.

Flux cored Arc welding (FCAW)

Weld joint # 027, located on OBG Component, Lift 13 Edge plate EP 3017 -001. Welder is identified as 050977. ZPMC Quality Control (QC) Inspector is identified as Zhang Ya Xu. The welding variables recorded by QC appeared to comply with the WPS – B-T-2231-Esab.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07960

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG Bike path components. The weld designations reviewed are as follows:

BK004A8 -057 –Jt. nos- 072,005,123,124,027,065,063,078,080,098

BK004A3 -057 –Jt. nos.-009,010,045, 046

BK004A4-057-Jt. nos - 071, 072,032,047,059,073,074

For further information see below pictures:-

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 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