

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-019671**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing 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**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

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint 330, Located on Lift 13 West components SEG3014D, as per WRR no. B-WR-20191. Welder is identified as 037932. ZPMC Quality Control Inspector (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-REPAIR-FCM-1.

Repair welding of Weld joint 056, Located on Lift 14 West components SEG3014D, as per CWR no. B-CWR-2734. Welder is identified as 066038. ZPMC Quality Control Inspector (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR-FCM-1.

Ultrasonic Testing (UT)

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08288

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Lift 14 Components. The weld designation reviewed as follows:

SEG 3020R – Jt. nos. -032, 034

SEG 3020M – Jt. nos. -018, 019

Bay #19

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as OBG Component –Suspender Bracket. The component and weld designation identified as follows:

SB 025 -108E –Jt. nos – 062, 063, 073, 074, 085, 037, 066

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.

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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
