

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019693**Date Inspected:** 30-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:** Zhao Chen Sun**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

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007991

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

SOUTH TOWER LIFT-5, REPAIR AREAS AFTER BLASTING AND PAINTING (EXTERNAL)

Porosity – A/E corner weld – 200mm from top of the shaft

Porosity – A/E corner weld – 1600mm from top of the shaft

Arc gouge – Skin'E' – 1100mm from top of the shaft

Porosity – A/B corner weld – 280mm from top of the shaft

SOUTH TOWER LIFT-5, REPAIR AREAS AFTER BLASTING AND PAINTING (INTERNAL)

Underfill – between 2nd longitudinal and transverse stiffeners from skin'E'

Flux Cored Arc Welding (FCAW):

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Weld joint # 82 located on Bike Path BK004A6 – 032. 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 – 2233 – ESAB.

Weld joint # 78 located on Bike Path BK004A8 – 032. 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 – 2232 – ESAB.

Shielded Metal Arc Welding (SMAW):

Weld joint # 06 located on Bike Path BK004A8 – 032. Welder is identified as 052493. 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 – 2113.

Weld joint # 11 located on Bike Path BK004A8 – 032. Welder is identified as 052930. 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.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007987

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

OBG BIKE PATH

BK004C – 024

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 24 located on Bike Path BK5ASD1 – 003. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Wang Chung Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U4c. (See attached photo)

Weld joint # 02 located on Bike Path BK5ASD1 – 003. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Wang Chung Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – Tc – U4c.

Witness of Magnetic Particle Testing (MT)

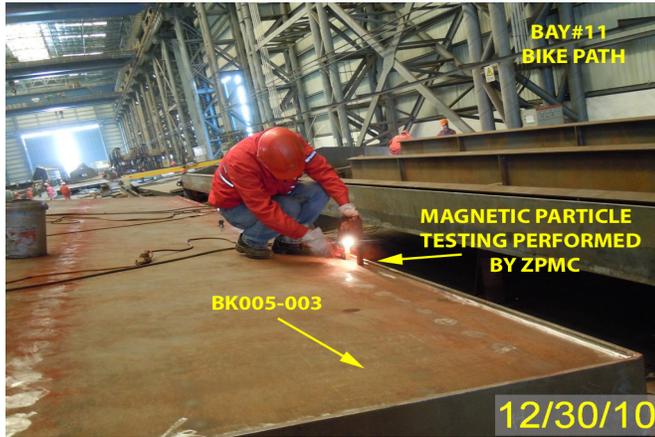
This QA inspector Witnessed MT performed by ZPMC Quality Control personnel. The member is identified as OBG Component. The component designation is identified as follows:

BIKE PATH : BK005 – 003 (See attached photo)

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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
