

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-019697**Date Inspected:** 04-Jan-2011**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:** Guo Yan Fei**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

Shielded Metal Arc Welding (SMAW):

Weld joint # 09 located on Tower Head component SSD1-FDSA6-1. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – U2.

Weld joint # 09 located on Tower Head component SSD1-FDSA6-1. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – U2.

Weld joint # 09 located on Tower Head component SSD1-FDSA6-1. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – U2.

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Flux Cored Arc Welding (FCAW):

Weld joint # 24 located on Tower Head component SSD1-FFSA6-1. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 24 located on Tower Head component NSD1-FFSA6-3. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 15 located on Tower Head component SSD1-FFSA6-1. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

Weld joint # 15 located on Tower Head component NSD1-FFSA6-3. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – ESAB.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08041

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:

EAST TOWER LIFT-6

ESD1-FFSA6-2-1~10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 15 located on Tower Head component ESD1-FDSA6-2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – B – U2b.

Weld joint # 27 located on Bike Path BK4CSD1 – 024. Welder is identified as 041271. 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 – 2211 – Tc – U4c.

Weld joint # 02 located on Bike Path BK4CSD1 – 024. Welder is identified as 040690. 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 – 2211 – Tc – U4c. (See attached photo)

Weld joint # 15 located on Tower Head component ESD1-FDSA6-2. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to

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comply with the WPS – B – P – 2211 – B – U2b.

Weld joint # 04 located on Bike Path BK4CSD1 – 024. Welder is identified as 040690. 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 – 2211 – Tc – U4c.

Weld joint # 22 located on Bike Path BK4CSD1 – 024. Welder is identified as 041271. 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 – 2211 – Tc – U4c.

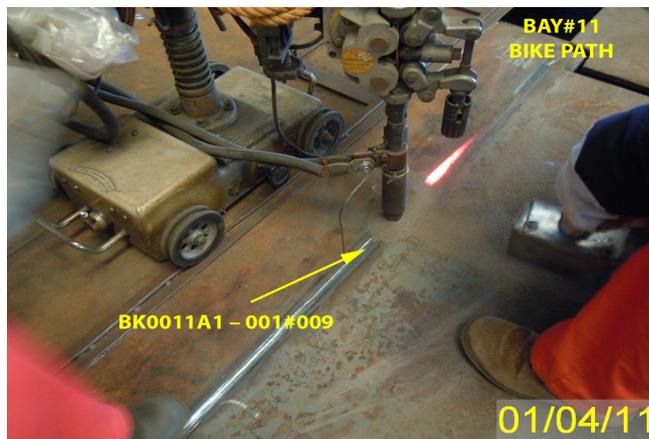
Weld joint # 15 located on Tower Head component ESD1-FDSA6-2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2211 – B – U2b.

Sub-merged Arc Welding (SAW):

Weld joint # 009 located on Bike path stringer plate BK0011A1 – 001. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

Weld joint # 009 located on Bike path stringer plate BK0012A1 – 001. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

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.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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