

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-019705**Date Inspected:** 07-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: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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. 08078

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

LIFT-6, TOWER

NSD1-FDSA6-3-1 – GREEN TAG#15734

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 02 located on Bike Path BK04A6 – 033. 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 165 located on Bike Path BK04A6 – 033. 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 # 07 located on Bike Path BK04A6 – 033. 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 – 2232 – ESAB.

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 09 located on Lift-6, Tower head component SSD1-FDSA6-1. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Li peng Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – ESAB – Repair.
(See attached photo)

Heat Straightening:

Heat Straightening being performed on tower head component identified as NSD1-FFSA6-3 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11665.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08083

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

LIFT-6, TOWER

ESD1-SPSA6-2-1A/B

WSD1-SPSA6-2-1A/B

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 94 located on Bike Path BK011A6 – 001. Welder is identified as 053316. 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 – 2231 – ESAB.

Weld joint # 40 located on Bike Path BK011A7 – 001. Welder is identified as 205649. 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 – 2233 – ESAB.

Weld joint # 95 located on Bike Path BK011A6 – 001. Welder is identified as 205649. ZPMC Quality Control

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

(QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – ESAB.

Weld joint # 46 located on Bike Path BK011A7 – 001. Welder is identified as 053316. 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 – 2233 – ESAB.

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
