

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-020494**Date Inspected:** 28-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:** Xu Le Feng /Qiu 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 Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 009 located on BK007A3-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 007 located on BK007A5-001. Welder is identified as 052075. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 073 located on BK007A4-001. Welder is identified as 040333. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07955.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality

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Control (QC) personnel.

The members are identified as:

BK004A1-023-030, 031, 032, 033, 034, 035, 036, 037, 038, 039, 040, 041, 042, 001, 010, 005, 006, 004, 013, 008

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07957.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004A-019 Step 12

BK004A-023 Step 12

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07958.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004C3-024-065, 067, 068, 100, 101, 102, 069, 070, 071, 103, 104, 105

BK004C4-024-080, 082, 083, 100, 101, 102, 085, 086, 087, 103, 104, 105

BK004A6-031-001, 002, 165, 007

BK004A8-031-001, 002, 130, 007

BK004ASD1-031-001, 002, 003, 004, 022, 023, 024, 027

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07962.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK009A4-001-001

BK009A3-001-004

BK009A4-001-007, 004

BK009A5-001-001

BK009A3-001-001

SSD1-FDSA6-1-1, 2, 3, 4, 5, 6, 7, 8

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07955.

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 MT report for this date.

The members are identified as:

BK004A1-023-030, 031, 032, 033, 034, 035, 036, 037, 038, 039, 040, 041, 042, 001, 010, 005, 006, 004, 013, 008

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07958.

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 MT report for this date.

The members are identified as:

BK004A6-031-001, 002, 165, 007

BK004A8-031-001, 002, 130, 007

BK004ASD1-031-001, 002, 003, 004, 022, 023, 024, 027

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07962.

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 MT report for this date.

The members are identified as:

BK009A4-001-001

BK009A3-001-004

BK009A4-001-007, 004

BK009A5-001-001

BK009A3-001-001

SSD1-FDSA6-1-1, 2, 3, 4, 5, 6, 7, 8

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 Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Leavitt, Scott	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
