

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-020501**Date Inspected:** 21-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/Tower**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 035 located on BK004A-030. Welder is identified as 040302. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 27 located on BK004A-030-MEP. Welder is identified as 040268. 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: SMAW welding of weld joint 16 located on BK004A-030-MEP. Welder is identified as 053829. 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: SMAW welding of weld joint 10 located on BK004A-030-MEP. Welder is identified as 056200. ZPMC Quality Control (QC) is identified as Qui Wen. The

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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 07863.

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:

BK004A1-003-002, 010

BK007A1-003-002, 008

BK005A5-003-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133

BK005A6-003-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

BK005A8-003-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07867.

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:

BK004C3-024-002, 010

BK004C5-024-002, 008

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07873.

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:

BK004A2-034-016, 018

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07876.

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:

WBSA4-4-1-1

WBSA4-4-2-1

WBSA4-5-1-1

WBSA4-5-2-1

WBSA4-6-1-1

WBSA4-6-2-1

Magnetic Particle Inspection (MT)

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07863.

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:

BK004A1-003-002, 010

BK007A1-003-002, 008

BK005A5-003-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133

BK005A6-003-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

BK005A8-003-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07873.

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:

BK004A2-034-016, 018

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07876.

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:

WBSA4-4-1-1

WBSA4-4-2-1

WBSA4-5-1-1

WBSA4-5-2-1

WBSA4-6-1-1

WBSA4-6-2-1

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07867.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BK004C3-024-002, 010

BK004C5-024-002, 008

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer