

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-020663**Date Inspected:** 26-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

Facility / Fabrication Surveillance Inspection: Bay 6, Bay 2, Bay 13 & Bay 14

This Caltrans QA inspector performed walk through inspection at the above mentioned locations. To assure that materials and workmanship conform to the requirements of the contact documents. This QA inspector observed no work being performed on the Caltrans Project.

Segment Name: Lift 4 North Tower / Bay 11

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #040261 welding corner closure plate, partial joint penetration (PJP) weld in the 2G position using WPS-B-T-4332-TC-P4-F. The weld is identified as NSTL4-3F/L-18 @ 123M bottom diaphragm. ZPMC QC inspectors are identified as Mr. Zhu Feng and Certified Welding Inspector (CWI), Mr. Gong Liang Zhu. Welding variables recorded by QC appeared to comply with the WPS.

Segment Name: Lift 4 North Tower / Bay 11

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #053869 welding corner closure plate, partial joint penetration (PJP) weld in the 2G position using WPS-B-T-4332-TC-P4-F. The weld is identified as NSTL4-3G/L-90 @ 127M top diaphragm. ZPMC QC inspectors are identified as Mr. Zhu Feng and CWI, Mr. Gong Liang Zhu. Welding variables recorded by QC appeared to comply with the WPS.

WELDING INSPECTION REPORT

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OBG Segment Name: OBG 5AW-5BW / Trial Assembly

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. The welds tested were scanned with Pattern "D" only in locations where flush grinding was present. All rejectable Indications were recorded on a data sheet that ABF and Caltrans QA generated after performing a joint inspection. The members are identified as the Bottom to side plate splice weld at W4 for segment 5AW-5BW. The weld designations are as follows:

SEG023A-021

This Caltrans QA inspector performed UT inspection using the conventional scan pattern A, B, C, and "D" per ABF Verification Witness Request #01262010-1 Item 1, weld repair, 5W BP to SP-W4 @ 5AW-5BW. QAMT/VT was not performed, due to the surface condition of the plate having coupling on it from ABF UT inspection. See Segment Splice NDT Tracking, dated 01-26-10 and Caltrans Ultrasonic Test Report (TL6027), dated 01-26-10 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

"As noted within the contents of this report."

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
