

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020893**Date Inspected:** 10-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Jun**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, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Feng Ya Jun

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Cross Beam 19

PCMK: CB3003A

Weld Number: 017

Welder: 054467

WPS-345-SMAW-2G-FCM-Repair

B-WR18720

Component: Cross Beam 19

PCMK: CB3003A

Weld Number: 017

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 049769

WPS-345-SMAW-2G-FCM-Repair

B-WR18720

Bay 8

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07721 from ZPMC for Bay 8. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as Bike Path. The weld designations reviewed are as follows.

BK004A5-061-112, 118, 121, 122

BK004A1-059-043

BK004A1-061-043

This QA Inspector observed the following work in progress for Bay 8.

ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.

ZPMC QC is identified as Feng Ya Jun

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Bike Path

PCMK: BK004A2-058

Weld Number: 015

Welder: 066155

WPS-B-P-2112-Plug

B-CWR2278

Bay 11

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07721 from ZPMC for Bay 11. This QA inspector performed visual testing (VT) verification of welds after ZPMC had performed their VT inspection. The segment is identified as Bike Path. The weld designations reviewed are as follows.

BK004A-017-Bike Path Anchor Plate

BK004A-018-Bike Path Anchor Plate

BK004A-021-Bike Path Anchor Plate

Bay 28

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07711 from ZPMC for Bay 28. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as U Rib Splice Plate. The weld designations reviewed are as follows.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

SA3085B-001~016-005

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
