

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-021054**Date Inspected:** 18-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 Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiang**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:** Splice Plate**Summary of Items Observed:**

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

OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as SA3117C-010-006, located on Splice Plate, SA3117C-010, welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of S welding of weld joint identified as A3103B-001-003, located on Splice Plate, SA3103B-001, welder is identified as 059318, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of welding of weld joint identified as SA3103B-011-003, located on Splice Plate, SA3103B-011-003, welder is identified as 059416, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of welding of weld joint identified as SA3103B-011-003, located on Splice Plate, SA3103B-011, welder is identified as 203805, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding

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variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay #1

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of welding of weld joint identified as E2-SB1-020-050, located on Splice Plate, E2-SB1-020, welder is identified as 215245, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 16

NDT

The following NDT performed ZPMC NDT notification 07832:

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 14:30 hours. The members are identified as follows: Tower Lift 4 FA QADE, ED1-SFSA4-51-5-2~9, ED1-SFSA4-60-51-1~4, WD1-SFA4-37-12-1~18, ED1-SFSA4-21A/B-2~10, ED1-SFSA4-60-1~32/45~50, ED1-SFSA4-60-2-33~44, ED1-SFSA4-60-3-33~44, ED1-SFSA4-60-3-33~44, WD1-SFSA4-333A/B-10-1~22.

OBG Bay # 16

NDT

The following NDT performed ZPMC NDT notification 07823:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 8:00 hours. The members are identified as follows: Steel Barriers, W5-SB1-104, W5-SB1-090, W5-SB1-078, W5-SB1-105, W5-SB1-103, W5-SB1-109, W5-SB1-105, W5-SB1-193, W5-SB28-006, W5-SB2-012, W5-SB1-007, W5-SB1-014.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

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

Inspected By: Humphrey, Delbert

Quality Assurance Inspector

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Reviewed By: Hall, Steven

QA Reviewer