

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-021552**Date Inspected:** 06-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 11 – Tower Shop

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 015 located on BK004A2-034(004). Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 024 located on BK004ASD1-022. Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Xu Le Feng.. 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 035 located on BK004C6-024. Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Xu Le Feng.. 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 098 located on BK004A6-023. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng.. 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 07648.

This QA inspector did not performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. It was noted that there was still unfinished MT inspections to be performed. VT inspection rescheduled to later in the day.

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07654

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:

BK005A3-003-017, 018, 041, 042

BK005A4-003-008, 009, 034, 035, 060, 061

BK005A6-003-023, 024, 035, 160

BK005A6-003-003, 152, 005, 153, 025, 159, 027, 125, 004, 150, 006, 151, 008, 156, 010, 157, 037, 161, 039, 128

BK005A6-003-009, 154, 011, 155

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07655

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:

BK004A2-019-001, 003, 004, 005, 006, 007, 009, 010

BK004A3-019-019, 020, 043, 044

BK004A4-019-006, 007, 032, 033, 058, 059

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07660

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:

BK004A6-030-001, 002, 165, 007

BK004A8-030-001, 002, 130, 007

BK004A6-029-001, 002, 165, 007

BK004A8-029-001, 002, 130, 007

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07654.

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.

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The members are identified as:

BK005A3-003-017, 018, 041, 042

BK005A4-003-008, 009, 034, 035, 060, 061

BK005A6-003-023, 024, 035, 160

BK005A6-003-003, 152, 005, 153, 025, 159, 027, 125, 004, 150, 006, 151, 008, 156, 010, 157, 037, 161, 039, 128

BK005A6-003-009, 154, 011, 155

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07655.

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:

BK004A2-019-001, 003, 004, 005, 006, 007, 009, 010

BK004A3-019-019, 020, 043, 044

BK004A4-019-006, 007, 032, 033, 058, 059

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07660.

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:

BK004A6-030-001, 002, 165, 007

BK004A8-030-001, 002, 130, 007

BK004A6-029-001, 002, 165, 007

BK004A8-029-001, 002, 130, 007

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

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your project.

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