

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-022296**Date Inspected:** 14-Mar-2011**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**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08539

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

BIKE PATH

BK3001-001-014; 021; 034; 042; 016; 023; 030; 033; 041; 045

BK17-001-040

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08540

Ultrasonic Testing (UT)

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This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

NORTH TOWER LIFT-6

NSD1-T16-3C/D-16A/B; 25A/B

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #013 located on Lift-6; south tower SSD1-TL6-1C/D. Welder is identified as 040270. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2314-Tc-P4.

Weld joint #003 located on Bike path BK16A-001. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4c. (See attached photo)

Weld joint #013 located on Lift-6; south tower SSD1-TL6-1C/D. Welder is identified as 056364. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2314-Tc-P4.

Repair welding of a weld joint #016 located on Bike path BK16B-001 as per the weld repair report # B-WR20396. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-REPAIR.

Weld joint #067 located on Lift-6; south tower SSD1-TL6-1B/D. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2314-Tc-P4.

Repair welding of a weld joint #017 located on Bike path BK16B-001 as per the weld repair report # B-WR20396. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-REPAIR.

Weld joint #012 located on Lift-6; south tower SSD1-TL6-1C/D. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b.

Flux Cored Arc Welding (FCAW):

Repair welding of a weld joint #16 located on Bike Path BK15B-001 as per the weld repair report # B-WR20395. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-REPAIR.

Repair welding of a weld joint #20 located on Bike Path BK15B-001 as per the weld repair report # B-WR20395. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-REPAIR.

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Repair welding of a weld joint #17 located on Bike Path BK15B-001 as per the weld repair report # B-WR20395. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-REPAIR. (See attached photo)

Repair welding of a weld joint #19 located on Bike Path BK15B-001 as per the weld repair report # B-WR20395. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-ESAB-REPAIR.

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 Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
