

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-023020**Date Inspected:** 24-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 /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 10 – Tower Shop

In Process Inspection SAW

This QA Inspector observed the following work in progress: SAW welding of weld joint 016 located on BK16B-001. Welder is identified as 207745. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 012 located on BK17B-001. Welder is identified as 500363. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 015 located on BK17B-001. Welder is identified as 057220. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 017 located on BK17B-001. Welder is identified as 040582. ZPMC Quality Control (QC) is identified as Qui Wen. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 052 located on BK011A3-001. 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 051 located on BK012A3-001. Welder is identified as 046769. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The 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 08607.

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:

BK16A-001-001, 002, 003, 004, 005, 006, 007, 009

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08610.

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:

BK009A5-001-028

BK009A3-001-011

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08617.

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:

31TR1-049, 050, 051, 052

31TR2-053, 054, 055, 056

31TR3-057, 058, 059, 060

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08607.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK16A-001-001, 002, 003, 004, 005, 006, 007, 009

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08610.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

31TR1-049, 050, 051, 052

31TR2-053, 054, 055, 056

31TR3-057, 058, 059, 060

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08617.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

31TR1-049, 050, 051, 052

31TR2-053, 054, 055, 056

31TR3-057, 058, 059, 060

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

your project.

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