

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-023055**Date Inspected:** 06-Apr-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

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint #066 located on Bike Path BK17C-001 as per the weld repair report # B-WR 20590. Welder is identified as 500363. 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-2G (2F)-REPAIR. (See attached photo)

Weld joint #004 located on Bike Path BK17C-001. Welder is identified as 057266. 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-2314-Tc-P4.

Repair welding of weld joint #068 located on Bike Path BK17C-001 as per the weld repair report # B-WR 20590. Welder is identified as 500363. 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-2G (2F)-REPAIR.

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Repair welding of weld joint #020 located on Bike Path BK17B-001 as per the weld repair report # B-WR 20590. Welder is identified as 500363. 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-2G (2F)-REPAIR.

Flux Cored Arc Welding (FCAW):

Weld joint #003 located on Bike path BK17C-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #023 located on Bike path BK010A6-001. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB. (See attached photo)

Weld joint #002 located on Bike path BK17C-001. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Heat Straightening:

Heat Straightening being performed on Traveler rail identified as 29TR1 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Jing Xiao Bo present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10186.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08745

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 TOWER Component. The weld designation reviewed as follows:

TOWER COMPONENTS

ED1-SA6-4-6

WD1-SA6-4-6

SD1-SA6-4-6

ESD1-ASA6-55B-3-1~4

WSD1-ASA6-55A-5-1~4

ESD1-ASA6-55B-3-1~4

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #008 located on Traveler Rail 28TR1-002. Welder is identified as 041713. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

WELDING INSPECTION REPORT

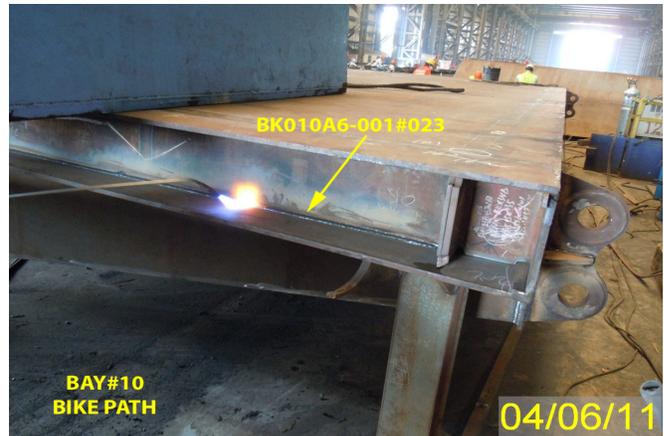
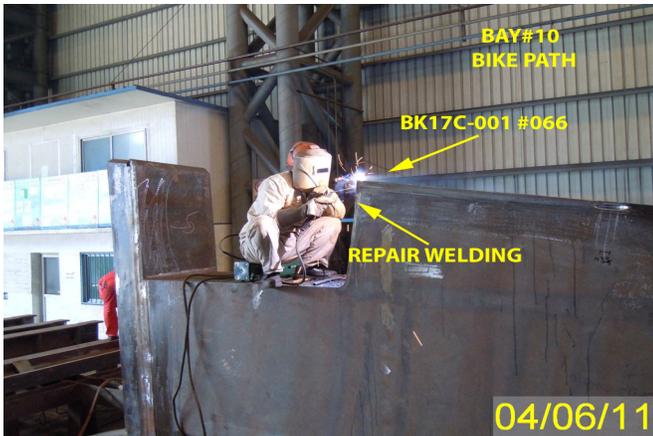
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Repair welding of weld joint #008 located on Traveler Rail 32TR1-001 as per the weld repair report # B-WR20595. Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-REPAIR.

Weld joint #011 located on Traveler Rail 28TR1-002. Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Repair welding of weld joint #014 located on Traveler Rail 32TR1-001 as per the weld repair report # B-WR20595. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-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
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Reviewed By:	Clifford,William	QA Reviewer
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