

**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-023090**Date Inspected:** 09-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**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**Summary of Items Observed:**

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

Bay #19

This QA Inspector observed the following work in progress,

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 008781

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Cable Bracket Components. The weld designation reviewed as follows:

SA6530- 001 – Jt. no. -016

SA6530- 002 – Jt. no. -075

SA6529- 001 – Jt. no. -016

SA6529- 002 – Jt. nos. -091, 096

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### Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08781

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 TL 6028 MT report for this date. The member is identified as OBG Cable Bracket Components. The weld designation reviewed as follows:

SA6529- 002 – Jt. nos. -096, 103,107, 110

### Heat Straightening:

Heat Straightening being performed on Cable Bracket Components identified as SA6530-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Zhang Zhi Wei present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10216.

### Flux Cored Arc Welding (FCAW)

Weld joint- 112, Located on Cable Bracket SA6531-001. Welder is identified as 062183. ZPMC Quality Control Inspector (QC) is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 030, Located on Cable Bracket SA6531-002. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

### Bay #16

This QA Inspector observed the following work in progress

### Shielded Metal Arc Welding (SMAW)

Weld joint- 002/003, Located on Bike path Hand rails, FS2. Welder is identified as 201861. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 001/003, Located on Bike path Hand rails, FS2. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with

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the WPS-B-P-2112.

For further information see below pictures:-

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.

## 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 Hu (15002048250), who represents the Office of Structural Materials for your project.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer