

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023191**Date Inspected:** 13-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**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 Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007758

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AE. The weld designations reviewed are as follows:

1. SEG3007C-501

Ultrasonic Testing (UT) – NWIT Document No: 007761

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Component. The weld designations reviewed are as follows:

1. E5-SB013-104-050

2. E5-SB013-105-019

3. E5-SB013-004-050

4. E5-SB013-067-019

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5. E5-SB013-100-081
6. E5-SB013-045-081
7. E5-SB013-015-081
8. E5-SB013-073-081
9. E5-SB013-095-050
10. E5-SB013-079-019
11. SA3016B-045-003
12. SA3016B-050-003
13. SA3016B-051-003
14. SA3016B-054-003
15. SA3016B-055-003
16. SA3016B-063-003
17. SA3016B-064-003
18. SA3016B-065-003
19. SA3016B-073-003
20. SA3016B-074-003

Bay 19

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB021-100-026 and 032 located on Suspender Bracket SB100E. ZPMC Welder is identified as 062762. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

FCAW welding of weld joint SB021-096-026 and 032 located on Suspender Bracket SB096E. ZPMC Welder is identified as 062732. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-ESAB.

ZPMC personnel performing heat straightening on bottom cover plate of OBG bike path member identified as BK004A-006-014~021. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9501. See the attached picture.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Suspender Bracket SB98E and SB98W.

Bay 16

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint W5-SB1-103-063 to 074 located on Steel Barrier of OBG Component. ZPMC Welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-P-2113.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

SMAW welding of weld joint W5-SB1-077-032 to 0043 located on Steel Barrier of OBG Component.. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2113.

This QA inspector observed that ZPMC personnel performed Ultrasonic Testing on Longitudinal Diaphragm to Longitudinal Diaphragm of OBG Segment 13CW. See the attached picture

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
