

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-023403**Date Inspected:** 24-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**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:** Feng Hai Jun**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

TOWER # BAY 11

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report of this date. The members are identified as following.

1. East Tower Lift 1 skin E reinforcing plates (Inside) from 13 to 28 meters
2. East Tower Lift 1 all the fit lugs to the skin A (Except the A/E corner) from 13 to 28 meters.
3. East Tower lift 1 diaphragm to skin a stiffener welds from 13 to 28 meters.
4. East Tower lift 1 diaphragm to skin a welds from 13 to 28 meters.
5. East tower lift 1 double diaphragm web to skin A and to skin E welds from 13 to 28 meters.
6. East tower lift 1 backfill plates to skin D and to skin E welds from 13 to 28 meters.
7. East tower lift 1 backfill plates (D/E corner) from 13 to 28 meters.
8. The fit lugs on the backfill plates (D/E corner) from 13 to 28 meters.
9. The perimeter channel plates to 9 meter diaphragm and to 13 meters diaphragm on skin A and Skin B.
10. The brace plates beside the 9 meters diaphragm on skin C.

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11.The angle plates to 9 meters diaphragm and to 13 metets diaphragm on skin A and skin B.

OBG ASSMEBLY # BAY 14

Segment No. 7AW

Flux Core Arc Welding (FCAW) of weld joint – SEG 033C-012 and SEG 033C-015, 016 and 017 in progress. Welder is identified as 067184. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2233-T-C-U4b and WPS-B-T-2132.

Segment No. 6BW

Flux Core Arc Welding (FCAW) of weld joint – SEG 029C-012, 022, 018 and 019 in progress. Welder is identified as 066401. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2233-T-C-U4b and WPS-B-T-2132.

Segment No. 6AW

Flux Core Arc Welding (FCAW) of weld joint – SEG SSD12B-PP-040- 220,221,230,231, 240,241,250 and 251 in progress. Welder is identified as 067103 and 067949. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2233-T-C-U4b.

Segment No. 6AW

Shielded Metal Arc Welding (SMAW) of weld joint – SEG SP 514-001-049 to 060 in progress. Welder is identified as 051348, 037840 and 067610. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS B-P-2214-B-U2-FCM.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

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 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer