

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-024203**Date Inspected:** 31-May-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 Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**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:** Traveler Rails & Deck Brackets**Summary of Items Observed:**

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

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding # 8 fillet weld, Lifting Point Assembly A3F, OBG Deck Bracket, Lift 13. Welder is identified as 206296. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T2132-ESAB (2F).

FCAW welding # 8 fillet weld, Lifting Point Assembly A3F, OBG Deck Bracket, Lift 13. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T2132-ESAB (2F).

FCAW welding # 8 fillet weld, Lifting Point Assembly A3F, OBG Deck Bracket, Lift 13. Welder is identified as 201889. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T2132-ESAB (2F).

OBG Bay # 14

WELDING

This QA Inspector observed the following work in progress:

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SMAW welding of weld identified as TR3015-TR1-001-001, located on Traveler Rail, TR3015-TR1-001. Welder is identified as 037799. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20757.

SMAW welding of weld identified as TR3003-TR1-001-015, located on Traveler Rail, TR3003-TR1-001. Welder is identified as 037799. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20561.

SMAW welding of weld identified as TR3003-TR1-001-015, located on Traveler Rail, TR3003-TR1-001. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20561.

SMAW welding of weld identified as X4025C-001-001, located on Saddle Support, X4025C-001. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-21117.

OBG Bay # 19

WELDING

FCAW welding of weld identified as BK025A1-026, located on Bike Path, BK025. Welder is identified as 062757. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-345-Fcm-2G(2F)-ESAB-repair & B-WR-21109.

FCAW welding of weld identified as BK023-012, located on Bike Path, BK023. Welder is identified as 062757. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-345-Fcm-2G(2F)-ESAB-repair & B-WR-21108.

FCAW welding of weld identified as BK025-088, located on Bike Path, BK025. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB(3G).

This QA inspector took measurements on Cable Bracket SA6529, base plate X6542A. Found distortion of between 9~ 11mm. This was performed for informational purposes only, work is still in progress.

OBG Bay # 13

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

WELDING INSPECTION REPORT

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Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09314.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG components. The weld designations reviewed are as follow: BK25A9-001-046, 045, 047, 051, 052, 061, 062, 059, 060, 065, 066, 069, 070, 067, 068, 073, 074, 083, 084, 081, 082, 087, 088, 001~004, 007, 008, 015~018, 021~026, 029, 030, 037~040, 043, 044.

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 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.

Inspected By: Humphrey, Delbert

Quality Assurance Inspector

Reviewed By: Hall, Steven

QA Reviewer
