

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024955**Date Inspected:** 17-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 Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lei/Wen/Shigang/Feng /Wen	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 (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector noted that there are 31 Bike Path Handrail components identified as BKR-NS-3 that are in various stages of final pick-up and will be ready for final VT soon.

This QA Inspector noted that there are 29 Bike Path Handrail components identified as intermediate BKR-NS-2 that are in various stages of final pick-up and will be ready for final VT soon.

This QA Inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

There are two identified traveler rails in this bay stamped BP106 and BP108

Bay 3

There are 8 miscellaneous components identified as Corner Assembly CA3014 at the front of this bay, these components are identified with a Green Tag no. 14801.

Bay 5

The following Traveler Rail components are in this bay waiting further processing: 3022TR1-001, 3020TR1-001,

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

3010TR1-002, 3025TR1-001, 3025TR1-002, 3025TR1-003, 3023TR1-002, 3023TR1-003, 3009TR1-001, 3023TR1-001, 3026TR1-001, and 3007TR2-001.

The following Bike Path components are in this bay waiting further processing: 26BK2-001, 26BK1-001, 29BK1-001, 29BK2-001, 29BK3-001, 30BK1-001, & 27BK1-001.

Bay 6

There are 28 miscellaneous components identified as GGL-MQ-1504-2-2 at the front of this bay, no work is being performed on these components at the time this QA Inspector identified these components.

Bay 7

The following Cantilever Box Bracket Assembly components are in this bay waiting further processing: BKSA21A-001, BKSA015-001, BKSA018-001 and 3011TR3-016.

Bay 8

This QA Inspector identified Sub Assembly components identified as Saddle Housing components SA7535 and SA7047 in this bay today.

Bay 9

The following Traveler Rail components are in this bay waiting further processing: 3003TR2-001, 3009TR2-001, 3016TR1-002, 3016TR1-001, 3016TR1-002, 3014TR2-002, 3013TR1-002, 3013TR2-001, 3016TR4-001, 3016TR3-001, 3016TR2-001, 3014TR2-001, 3014TR1-001, 3014TR1-002, 3016TR4-002, 3013TR1-001 and 3013TR2-002.

This QA Inspector observed 8 Bike Path Handrail components in various stages of fabrication waiting further processing.

This QA Inspector observed the following traveler rail components identified as X4025A, X4025B, & X4025C waiting for final NDT inspection and verification.

The following components are ready for the next stage of fabrication: GGL-MQ-1770-X5001A-001~039-001, GGL-MQ-1770-X5001B-001~039-001, GGL-MQ-1770-X8523D-001-001(2), GGL-MQ-1770-X8523F-001-001, GGL-MQ-1770-X8523G-001-001, 002, & 003, GGL-MQ-1770-X8523H-001-001, 002, & 003, GGL-MQ-1770-X8523L-001-001, GGL-MQ-1770-X8523M-001-001, GGL-MQ-1770-X8523E-001-001, GGL-MQ-1770-X8531F-001-001, GGL-MQ-1770-X8531D-001-001, GGL-MQ-1770-X8531G-001~003-001, GGL-MQ-1770-X8531H-001~003-001, GGL-MQ-1770-X8531L-001-001, GGL-MQ-1770-X8531M-001-001.

The following components have been fit-up with machined plates are waiting for further welding: SA7021-001-005, SA7022-001-005,011, SA7023-001-002,012, SA7024-001-004, SA7501-001-007, SA7502-001-001, SA7503-001-005,007, & SA7504-001-003.

Bay 10 – Tower Shop

In Process Inspection FCAW

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

This QA Inspector observed the following work in progress: FCAW welding of weld joint 049 located on BK009A8-001. Welder is identified as 054069. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 039 located on BK009A1-001. Welder is identified as 040365. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 016 located on BK011A2-001. Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 016 located on BK011A8-001. Welder is identified as 202354. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 015 located on BK012A6-001. Welder is identified as 041271. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 013 located on BK012A6-001. Welder is identified as 044541. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09155.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BKSA006-001-091, 092, 093, 094, 095, 055, 056, 057, 058, 059, 061, 062, 063, 064, 065

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09155.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BKSA006-001-091, 092, 093, 094, 095, 055, 056, 057, 058, 059, 061, 062, 063, 064, 065

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

Inspected By:	Leavitt,Scott	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
