

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-025031**Date Inspected:** 18-May-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,

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 007, Located on Cable Bracket SA 6530-001. Welder is identified as 059566. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) -Repair.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 001, Located on Bike path Hand rails, FS8. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

comply with the WPS-345-SMAW-2G (2F) -Repair.

Repair welding of Weld joint- 002, Located on Bike path Hand rails, FS21. Welder is identified as 053755. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -Repair.

Heat Straightening:

Heat straightening being performed on OBG Component Crash Barriers, E5-SB32-002, E5-SB29-001, W2-SB26-001, W2-SB14-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10176.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 008 as per WRR no. B-WR-21511, Located on Traveler rail TR 3004TR1-001. Welder is identified as 067752. ZPMC Quality Control Inspector (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

Repair welding of Weld joint- 011 as per WRR no. B-WR-20756, Located on Traveler rail TR 3021TR1-001. Welder is identified as 200569. ZPMC Quality Control Inspector (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

Heat Straightening:

Heat straightening being performed on OBG Component u Rib Splice plate X3305K-020-002 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10319.

Trial assembly yard

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09171

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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 a TL 6028 MT report for this date. The member is identified as OBG Lift 13AE components. The weld designations reviewed are as follows:

SEG3007X- Jt. nos -274,275,268,494,495,252,276,277,278,280,496,284,290,292,296,298,302,304,308,310,314,316,320,322,326,328

SEG3007X- Jt. nos -566,560,228,532,531,525,526,527,528,529,530,533,534,535,536,149,150,145,146,139,140,133,134,127,128,505

SEG3007X- Jt. nos -506,121,122,115,116,485,487,101to108,111,112,117to120,95,96,481to484,79,80,123to144,147,148,579,580,583,584,507,508

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

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Reviewed By: Clifford, William

QA Reviewer