

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-025302**Date Inspected:** 13-Jul-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:** Bike Path Components**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 # 14

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 # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as E5-B-SKYWAY-1-051, located on Steel Barrier E5-B-SKYWAY-1. Welder is identified as 062757. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-FCAW-1F-ESAB.

OBG Bay # 19

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as BK23A9-001-016, located on Bike Path, BK23A9-001. Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

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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.

Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09700.

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 15:20 hours. The members are identified as follows OBG Component. The weld designations reviewed are as follow: BK0121-001-028, 029, 034, 035, 030, BKSA008-001-009, 012, 010, 011, 013, 015, 014, 016, BK021-001, 020, 027, BK021A-001-002,~009, BK021-001-005, 006, 037, 039, BKSA9-001-001~004, added on in the field.

During the Quality Assurance (QA) NDT inspection of an OBG Bike Cantilever Truss BKA9-001-001~004 in Bay 16, this QA Inspector discovered the following issues:

- 1st Class "A" indication measuring 20mm in length.
- The Indication rating is 0db.
- The depth of the indication is approximately 20.33mm.
- SA 70.56
- PA 58.95
- The weld joint is identified as BKSA9-001-001.
- The weld joint is a Complete Joint Penetration (CJP) groove weld joining BKX80C-Top Plate to BKX80A-Side Plate.
- The thickness of the side plate is 22mm.
- The X location is +10.
- The Y location is approximately 269m.
- The indication is clearly marked on or near the weld.
- BK021 is currently located in Bay 16.

- 2nd Class "A" indication measuring 25mm in length.
- The Indication rating is -4db.
- The depth of the indication is approximately 20.99mm.
- SA 62.57
- PA 58.95
- The weld joint is identified as BKSA9-001-001.
- The weld joint is a Complete Joint Penetration (CJP) groove weld joining BKX80C-Top Plate to BKX80A-Side Plate.
- The thickness of the side plate is 22mm.
- The X location is +10.

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- The Y location is approximately 269m.
- The indication is clearly marked on or near the weld.
- BKSA9A is currently located in Bay 16.

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
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Reviewed By:	Hall, Steven	QA Reviewer
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