

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-017659**Date Inspected:** 29-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 11AW, Base metal repair around OBG segment transverse splice.

SMAW Critical Weld Repair around OBG segment transverse splices (CWR # B-CWR1842); located at Trial assembly yard. Welders are identified as 202316; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The attached photographs provide additional detail.

Trial assembly yard, 11CE-11DE, DP transverse splice.

SAW welding of weld joint OBE11A- 003, 002; located at Trial assembly yard. Welders are identified as 046709, 040656; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-223(2)1T-1.

Trial assembly yard, 11CW, BP-SP@ W4, CB side, Hold back area.

SMAW welding of weld joint OBW11B- 009; located at Trial assembly yard. Welders are identified as 044504, 044575; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

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This QA Inspector carried out NDE on following
Trial assembly yard, 11AE-11BE.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11E-036R1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Side panel & Bottom panel at the intersection of OBG Segment 11AE- 11BE, Cross beam Side. The weld designations were as;

- 1) SEG066A-011. (11AE-11BE, SP-BP-E4);
- 2) SEG068A-021. (11AE-11BE, SP-BP-E4).

Trial assembly yard, 10AE & 10AW, NDT after HSR.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 07154). This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) FB024-008-128. (HSR affected area.)
- 2) FB023-008-128. (HSR affected area.)

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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