

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018629**Date Inspected:** 16-Dec-2010**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) Chanxing Island **Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

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

Magnetic Particle Testing (MT) – NWIT Document No's: 007804

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13CE Deck Panel U-Ribs. The weld designations reviewed are as follows:

1. DP3102-001-031, 032, 033, 034, 035, 036, 039, 040, 050
2. DP3102-001-051, 052, 053, 054, 055, 056, 059, 060
3. DP3102-001-083, 084, 085, 086, 087, 090, 091, 092, 093
4. DP3102-001-094, 095, 096, 097, 100, 101, 102, 103, 104
5. DP3103-001-075, 076, 077, 078, 079, 082, 083, 084, 085
6. DP3103-001-086, 087, 090, 247, 248, 249, 250, 224, 223
7. DP3103-001-029, 028, 027, 031, 030, 034, 035, 036, 037
8. DP3103-001-038, 039, 040, 041, 043, 044, 042, 045, 235, 236

Bay 14

This QA Inspector observed the following work in progress:

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Shielded Metal Arc Welding (SMAW) repair welding of weld joint DP3019-001-024 located on deck panel to deck panel splice joint of OBG Segment 13BE. ZPMC Welder is identified as 068091. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2397.

SMAW repair welding of weld joint DP3104-001-248 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2400.

SMAW repair welding of weld joint DP3104-001-245 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC Welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2399.

SMAW repair welding of weld joint DP3104-001-010 located on deck panel to deck panel splice joint of OBG Segment 13CE. ZPMC welder is identified as 037723. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) - Repair, which is used as per Welding Repair Report (WRR) B-WRR-19101.

Submerged Arc Welding (SAW) welding of weld joint DP3167-001-030 located on deck panel to deck panel splice joint of OBG Segment 14E. ZPMC Welder is identified as 044771. ZPMC Quality Control (QC) is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U2c-S-2.

SAW welding of weld joint DP3162-001-623 located on deck panel to deck panel splice joint of OBG Segment 14E. ZPMC Welder is identified as 044771. ZPMC Quality Control (QC) is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U2c-S-2.

SAW welding of weld joint DP3161-001-392 located on deck panel to deck panel splice joint of OBG Segment 14E. ZPMC Welder is identified as 044771. ZPMC Quality Control (QC) is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U2c-S-2.

SMAW welding of weld joint SEG3013AA-031 located on Edge Plate at PP119 of OBG Segment 13AW. ZPMC Welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013AA-043 located on Edge Plate at PP119 of OBG Segment 13AW. ZPMC Welder is identified as 067764. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3013E-151 located on Floor Beam to Bottom Plate of the OBG Segment 13AW

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ZPMC Welder is identified as 047866. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3013Q-183 located on Floor Beam to Bottom Plate of the OBG Segment 13AW ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
