

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-019313**Date Inspected:** 10-Jan-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) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. Qui 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 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.

Ultrasonic Testing (UT) – NWIT Document No: 008119

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. SEG3020W-036

Ultrasonic Testing (UT) – NWIT Document No: 008121

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. SEG3007AT-069

Magnetic Particle Testing (MT) – NWIT Document No's: 008118

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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 Bike Path. The weld designations reviewed are as follows:

1. BK004A1-006-006, 005, 008, 032, 001, 010, 004, 013
2. BK004A1-006-032, 031, 033, 034, 035, 036
3. BK4A1-006-MEP-032, 004, 005, 006, 007, 008, 020, 021

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020E-056 located on Floor Beam to Bottom Plate of OBG Segment 14AW. ZPMC Welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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 Report (CWR) B-CWR-2734.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AG-005 located on Floor Beam to Edge of OBG Segment 14AW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

SMAW welding of weld joint SEG3020F-027 and 036 located on Floor Beam joint of OBG Segment 14W. ZPMC Welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-B-U2-FCM.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020BB-010 located on Vertical Shear Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3020BB-046 located on Vertical Shear Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3020BB-001 located on Vertical Shear Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Floor beam and Longitudinal Diaphragm Stiffeners of the OBG Segment 13BW at panel point 121.5 north side.

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Bay 19 and 08

This QA Inspector observed the following work in progress:

SMAW repair welding of weld joint SB024-108-022 and 026 located on OBG Suspender Bracket SB108W. ZPMC Welder is identified as 062761. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2732.

SMAW repair welding of weld joint SB025-108-001 located on OBG Suspender Bracket SB108E. ZPMC Welder is identified as 062761. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2731.

ZPMC personnel performing heat straightening on suspender plate side plate of OBG SB104E. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Xu Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9726.

FCAW welding of weld joint BK004A8-064-002 and 007 located on the OBG bike path BK004A-064. ZPMC Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2132-ESAB.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on sole plate at deck panel of OBG Bike Path BK004A-006.

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



Summary of Conversations:

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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
