

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-019661**Date Inspected:** 19-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. LIU HUA JIE**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 (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following;

1. INPROCESS:

OBG Trial Assembly

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for deck plate located on 12AE+12BE at bike path side. The weld is designated as DP3022-001-023. The welder is identified as 044575. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-T-3213-B-U3b.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for deck plate located on 12AE+12BE at cross beam side. The weld is designated as DP3012-001-025. The welder is identified as 050289. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-T-3213-B-U3b.

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ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Base Metal Repair weld (temporary attachment removal area) near the side plate to side plate transverse splice weld joint located on 12BW+12CW at counter weight side. The location near the weld is designated as OBW12E-001. The welder is identified as 202316. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2129.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Base Metal Repair weld (temporary attachment removal area) near the side plate to side plate transverse splice weld joint located on 12BW+12CW at cross beam side. The location near the weld is designated as OBW12E-002. The welder is identified as 202316. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2126.

2. NDT:

Ultrasonic Testing (UT):

UT carried out as per the ZPMC submitted Notification No 08225.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10 % of CJP welds that has been previously tested and accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA inspector generated a (UT) (TL-6027) report for this date. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were BK008A1-001-044.

UT carried out as per the ZPMC submitted Notification No 08224.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10 % of CJP welds that has been previously tested and accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA inspector generated a (UT) (TL-6027) report for this date. The QA Inspector generated a TL-6027 UT report on this date. Weld identification numbers were BK005ASD1-003-001~004, 022~024, 027.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Pillai,Santosh	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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