

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-020076**Date Inspected:** 25-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: 008288

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. SEG3020K-009, 021

Ultrasonic Testing (UT) – NWIT Document No: 008285

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 Suspender Bracket. The weld designations reviewed are as follows:

1. SB025-108-001,011,033,035,039,045,047,049,051,053,055

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AJ-303, 312 and 321 located on Floor Beam I-Stiffener to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 067949. 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.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020BB-001 located on Vertical Shear Plate to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 067942. 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 Welding Repair Report (WRR) B-WRR-20146.

SMAW repair welding of weld joint SEG3020D-052 and SEG3020E-056 located on Floor Beam to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 0066398. 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 (CWR) B-CWR-2734.

FCAW welding of weld joint SEG3020R-176 located on Floor Beam to Edge Beam of OBG Segment 14W. ZPMC Welder is identified as 066236. 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.

FCAW welding of weld joint SEG3020AY-065, 069 and 073 located on Side Plate to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 067609. 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 repair welding of weld joint SEG3014D-306, 310 and 330 located on Floor Beam to Side Plate I-rib stiffener of OBG Segment 13BW. ZPMC Welders are identified as 045196 and 037932. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20191.

SMAW repair welding of weld joint SEG3015K-224, 234 and 238 located on Floor Beam to Side Plate I-rib stiffener of OBG Segment 13CW. ZPMC Welders are identified as 045196 and 037932. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20190.

FCAW welding of weld joint SEG3014-009 located on Deck Panel to Corner Assembly of OBG Segment 14W. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1T-ESAB-1.

Sub Merged Arc Welding (SAW) welding of weld joint SEG3015-007 located on deck panel to corner assembly OBG Segment 13CW to OBG Segment 13CW. ZPMC Welder is identified as 250050. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the

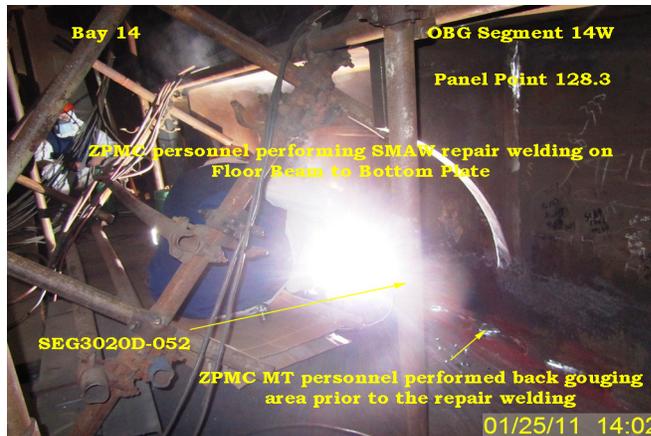
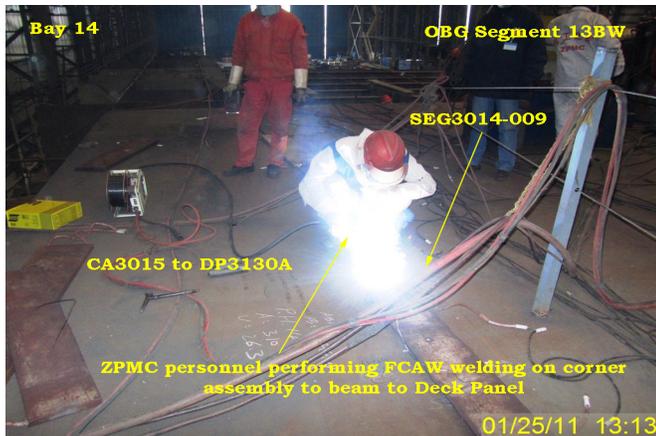
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Applicable WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint DP3133-001-028 and 029 located on Deck Panel to Deck Pane of the OBG Segment 13BW. ZPMC Welders are identified as 037840. 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-2213-Tc-U4b-FCM-1.

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