

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020584**Date Inspected:** 10-Feb-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: 008325

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 13AE. The weld designations reviewed are as follows:

1. SEG3020K-026

Magnetic Particle Testing (MT) – NWIT Document No's: 008323

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 13AE. The weld designations reviewed are as follows:

1. SEG3007AT-003, 004, 005, 202, 203.

2. SEG3007X-208, 544~548.

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3007AB-087 located on Floor Beam to Edge Beam at panel point 120 of OBG Segment 13AE. ZPMC Welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) – FCM – Repair, which is used as per Welding Repair Report (WRR) B-WRR-20166.

SMAW repair welding of weld joint SEG3007AD-025 located on Floor Beam (F13) to Side Plate at panel point 119-1500 of OBG Segment 13AE. ZPMC Welder is identified as 044772. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-19453.

SMAW repair welding of weld joint SEG3007AD-027 located on Floor Beam (F13) to Side Plate at panel point 119-1500 of OBG Segment 13AE. ZPMC Welder is identified as 037723. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-19451.

SMAW repair welding of weld joint SEG3007P-220 located on Bottom Plate I-rib stiffener to Floor Beam Plate at panel point 118 of OBG Segment 13AE. ZPMC Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20134.

SMAW repair welding of weld joint SEG3007AH-086 located on K- Plate to Side Plate at panel point 119+1500 of OBG Segment 13AE. ZPMC Welder is identified as 068924. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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-20220.

FCAW welding of weld joint SEG3007T-114 and 116 located on Longitudinal Diaphragm I-Stiffener of OBG Segment 13AE. ZPMC Welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

SMAW welding of weld joint DP3173-001-018 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 037779. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-018 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 037780. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-020 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 066155. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

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FCAW welding of weld joint DP3174-001-385 to 388 located on Deck Panel U-ribs to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 048696. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

FCAW welding of weld joint DP3173-001-415 located on Deck Panel U-rib to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 048433. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3095-001-013 and 014 located on Bottom Plate of OBG Segment 14E. ZPMC Welder is identified as 068858. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB. See the attached picture.

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