

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-020586**Date Inspected:** 07-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: 008316

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 13BE. The weld designations reviewed are as follows:

1. SEG3009L-052, 053, 060, 058, 059, 044, 047
2. SEG3009L-041, 042, 043, 050, 048, 049, 051

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020D-052 located on Floor Beam to Bottom Plate at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. 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-R1.

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SMAW repair welding of weld joint SEG3020X-011 located on Longitudinal Diaphragm to Bottom Plate at panel point 126 to 126.5 of OBG Segment 14W. ZPMC Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. 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-2659.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020E-128 located on Longitudinal Diaphragm to Floor Beam at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 201215. 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. See the attached picture.

FCAW welding of weld joint SEG3020R-182 located on Edge plate to Floor Beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 066421. 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 SEG3020AB-055 and 033 located on Longitudinal Diaphragm to Floor Beam at panel point 128 of OBG Segment 14W. ZPMC Welder is identified as 069688. 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.

SMAW welding of weld joint DP3176-001-204 and 208 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welders are identified as 037779 and 067707. 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.

FCAW welding of weld joint DP3174-001-293 and 294 located on Deck Panel U-rib 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-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-034 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 067904. 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.

FCAW welding of weld joint SEG3014E-010 located on Deck Panel Diaphragm to Floor Beam at panel point 121.5 of OBG Segment 13BW. ZPMC Welders are identified as 067888 and 066239. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3015J-010 located on Deck Panel Diaphragm to Floor Beam at panel point 123 of OBG Segment 13CW. ZPMC Welders are identified as 067876 and 201583. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

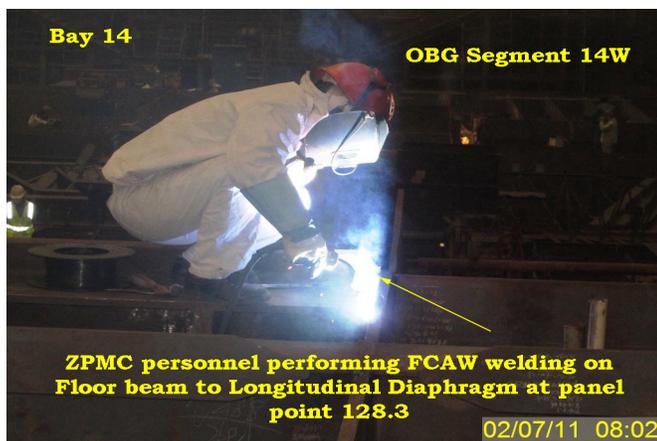
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SMAW welding of weld joint SEG3014G-002 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014J-002 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Qui Wen. 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
