

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-020723**Date Inspected:** 11-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: 008326

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. SEG3007R-151
2. SEG3007M-122, 132, 137, 125, 130, 135, 140, 233, 234, 126, 131, 136, 141
3. SEG3007AY-103, 106, 110, 107

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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. SEG3007P-086
2. SEG3007R-153

WELDING INSPECTION REPORT

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Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on OBG Segment 13AE, this Quality Assurance Inspector (QA) discovered one (1) Class “A” indications measuring approximately 20mm in length. The weld is Complete Joint Penetration ‘T’ joint joining the stiffener to floor beam at panel point 118.5 CB Side. The indication details that The Indication rating is +7dB and length approximately 20mm. The Thickness of the plate is 28mm and depth of the indication approximately 16mm. The indication is located on the weld joint identified as SEG3007M-141. The “Y” location for this indication is approximately 50mm from top edge of the stiffener. The weld is a Complete Joint Penetration (CJP) ‘T’ weld joint bottom plate I-stiffener to Floor Beam. The bottom plate is identified as BP3050A and Floor Beam is identified is FB3105A. The indication is clearly marked by the QA Inspectors near the weld. This weld joint is designated as Seismic Performance Critical Member (SPCM). The OBG Segment 13AE located in the inside of fabrication bay 14. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld. Regarding this UT indication, QA inform to ZPMC QC. The ZPMC QC identified as Mr. Wang Xu.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3095-001-010 and 009 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.

Bay 19

This QA Inspector observed the following work in progress:

FCAW welding of weld joint BK004A6-014-002 and 007 located on OBG Bike Path. ZPMC Welder is identified as 062735. 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-2232(3)-ESAB.

FCAW welding of weld joint BK004A6-014-001 and 165 located on OBG Bike Path. ZPMC Welder is identified as 062735. 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-2232(3)-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.

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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