

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-021034**Date Inspected:** 25-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.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW-13A-018 located on Corner Assembly to Corner Assembly of OBG Segment 13BW to OBG Segment 13CW. ZPMC Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3015C-013 located on Floor Beam Flange to Corner Assembly at panel point 124.5 of OBG Segment 13CW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. 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 SEG3015C-134 located on Deck Panel Diaphragm to Corner Assembly at panel point 124.5 of OBG Segment 13CW. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

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SMAW welding of weld joint SEG301B-262 located on Vertical plate to Floor Beam at panel point 120 OBG Segment 13AW. ZPMC Welder is identified as 066002. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3013F-025 located on deck panel diaphragm to Floor Beam of OBG Segment 13AW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3013K-024 located on deck panel diaphragm to Floor Beam of OBG Segment 13AW. ZPMC Welder is identified as 048433. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW repair welding of weld joint SEG3020BB-052 located on Bottom Plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 045246. 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 Rev2.

SMAW repair welding of weld joint SEG3020BB-064 located on Bottom Plate to Vertical Shear 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 Critical Welding Repair (CWR) B-CWR-2793.

SMAW repair welding of weld joint SEG3020X-013 located on Bottom Plate to Longitudinal Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 047864. 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-2662.

FCAW welding of weld joint SEG3020BB-114 located on Anchor plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 066695. 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 SEG3020R-020 located on Floor Beam to Floor Beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 066239. 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-2232-ESAB.

SMAW welding of weld joint SEG3020R-023, 024 and 025 located on Floor Beam to Anchor Plate at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 069896. 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-P-2114-FCM.

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This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Vertical Shear Plate to bottom plate 'T' joint weld at panel point 125 to 126 of OBG Segment 14W. The weld number is identified as SEG3020BB-037 and SEG3020BB-010. See the attached pictures.

SMAW welding of weld joint DP3173-001-019 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 DP3138-001-112 and 113 located on Deck Panel U-ribs to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 045227. 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 DP3138-001-122 and 123 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 DP3125-001-193 and 194 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 045227. 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-2132-ESAB.

SMAW repair welding of weld joint DP3173-001-023 and 021 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welders are identified as 067588 and 067520. ABF Quality Control (QC) is identified as Mr. Shen Jian. 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-20289.

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

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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
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Reviewed By:	Patel,Hiranch	QA Reviewer
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