

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-021438**Date Inspected:** 04-Mar-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: 008447

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 13AW. The weld designations reviewed are as follows:

1. FB3194-001-082
2. FB3180-001-098
3. SEG3013AH-109, 118, 111, 120
4. SEG3013AH-038, 024, 025

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint FB3329-001-019, 013 and 014 located on Floor Beam Stiffener of OBG Segment 14W. ZPMC Welder is identified as 051348. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable

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WPS-B-P-2114-FCM-1

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AZ-079, 080 and 081 located on Side Plate I-Stiffener to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 066673. 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 welding of weld joint SEG3020M-064 and 065 located on Anchor Plate to Floor Beam Stiffeners of OBG Segment 14W. ZPMC Welder is identified as 067707. 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-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020Q-178 and 183 located on Anchor Plate to Floor Beam Stiffeners of OBG Segment 14W. ZPMC Welder is identified as 067707. 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-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AB-134 located on Anchor Plate to Longitudinal Diaphragm of OBG Segment 14W. ZPMC Welders are identified as 051348 and 045246. 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-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015L-008 located on Deck Panel Diaphragm to Deck Panel Diaphragm at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 045213. 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.

SMAW repair welding of weld joint DP3172-001-018 located on Deck Panel Diaphragm to Deck panel of OBG Segment 14W. ZPMC Welder is identified as 066674. 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 Critical Welding Repair (CWR) B-CWR-2830.

SMAW repair welding of weld joint DP3174-001-017 located on Deck Panel Diaphragm to Deck panel of OBG Segment 14W. ZPMC Welder is identified as 067588. 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 Critical Welding Repair (CWR) B-CWR-2820.

SMAW repair welding of weld joint DP3173-001-024 located on Deck Panel Diaphragm to Deck panel of OBG Segment 14W. ZPMC Welder is identified as 067588. 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 Critical Welding Repair (CWR) B-CWR-2816.

FCAW welding of weld joint SEG3013P-031 and 036 located on Edge Plate to Floor Beam of OBG Segment 13AW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The

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welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

SMAW welding of weld joint SEG3013F-037 located on Floor Beam Stiffener at panel point 119+1500 bike path side of OBG Segment 13AW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SEG3013H-035 and 033 located on Floor Beam Stiffener to Grillage of OBG Segment 13AW. ZPMC Welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Floor Beam to Grillage 'T' joint weld at panel point 119, 119+1500 and PP119-1500 Bike Path Side of OBG Segment 13AW. The weld number is identified as SEG3013AH-178. See the attached pictures.

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
