

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021925**Date Inspected:** 10-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), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 047866 perform welding by Flux Cored Arc Welding (FCAW), on floor beam to side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020C-056. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 250~265 amperes and 26.2 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform welding by Shielded Metal Arc Welding (SMAW), on Sub assembly SA3231 of OBG Segment 13BW. Weld joint is identified as SA3231C-001-084. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 155~170 amperes and 25.4 volts, which appears to be in compliance with the approved WPS.

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This QA Inspector observed ZPMC qualified welding personnel identified as 037996 perform repair welding by Shielded Metal Arc Welding (SMAW), on Sub assembly SA3173 of OBG Segment 13AW. Weld joint is identified as SA3173-001-019. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair. This QA Inspector noted welding variables were 140~150 amperes and 24.8 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified NDT personnel perform Magnetic particle testing on Floor beam to floor beam flange weld of OBG Segment 14W. Weld joint is identified as FB3329-001-018/019. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 204730 perform welding by Flux Cored Arc Welding (FCAW), on Bottom plate I rib stiffener of OBG Segment 14W. Weld joint is identified as SEG3020AY-117. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 250~270 amperes and 26.2 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 067275 perform welding by Flux Cored Arc Welding (FCAW), on Bottom plate I rib stiffener of OBG Segment 14W. Weld joint is identified as SEG3020AY-140. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 245~260 amperes and 25 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066673 perform welding by Flux Cored Arc Welding (FCAW), on Bottom plate I rib stiffener of OBG Segment 14W. Weld joint is identified as SEG3020AJ-450, 455, 460. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 245~260 amperes and 27 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066765 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to corner assembly diaphragm weld of OBG Segment 13AW. Weld joint is identified as SEG3013C-152, 154, 156. ZPMC Quality Control (QC) Inspector identified as Shen Jian Bo was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1. This QA Inspector noted welding variables were 130~140 amperes and 24 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 045143 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to deck panel diaphragm weld of OBG Segment 13AW. Weld joint is identified as SEG3013G-019. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 255~270 amperes and

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26.5 volts, which appears to be in compliance with the approved WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

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 Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
