

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-024871**Date Inspected:** 03-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

OBG Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08443.

Ultrasonic Testing (UT)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested

and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

Seg3009S-052, 053, 076, 077

Seg3009E-084, 085, 099, 100, 114, 115, 129, 130, 144, 145, 267, 268, 282, 283, 292, 293, 302, 303

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This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3019AP-027 located on Anchor Plate of the OBG Segment 14E. The welder is identified as 051356. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3019AQ-037 located at Floor Beam of the OBG Segment 14E. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007L-032 located at PP119-1500 of the OBG Segment 13AE. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019N-018 located on Floor Beam at PP126.5 of the OBG Segment 14E. The welder is identified as 044790. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3076-001-017 located on Deck Panel to Longitudinal Diaphragm of the OBG Segment 13AE. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AG-050 located on Edge Plate to Floor Beam of the OBG Segment 14E. The welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AJ-054 located on Bottom Plate I-Rib to Floor Beam of the OBG Segment 14E. The welder is identified as 044779. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair & B-WR20245.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019BB-166 located on Bottom Plate I-Rib to Floor Beam of the OBG Segment 14E. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair & B-WR20246.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3160-001-038 located on Deck Panel of the OBG Segment 14E. The welder is identified as 050969. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair & B-WR20272.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3019D-2-160 located on Longitudinal Diaphragm to Floor Beam of the OBG Segment 14E. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair and B-WR19781.

Submerged Arc Welding (SAW)

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as SEG3007*-007 located on Deck Panel of the OBG Segment 13AE. The welder is identified as 058100. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant 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, 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Singh, Vikram	Quality Assurance Inspector
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Reviewed By:	Patterson, Rodney	QA Reviewer
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