

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026380**Date Inspected:** 14-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:** Lv Li Qing**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.

OBG Bay 14

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08544.

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:

SEG3011-005, 006

WELDING

This QA Inspector randomly observed the following work in progress:

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Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as OBE13-A-009 located on deck plate to deck plate of the OBG Segment 13BE and 13CE. The welder is identified as 051359. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AB-136 located on 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-4G (4F)-FCM-Repair and B-WR2234.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AA-028 located on the OBG Segment 14E. The welder is identified as 058087. 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 and B-CWR2755.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AZ-076 located on 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-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AH-084 located on K-plate to side plate of the OBG Segment 13AE. The welder is identified as 050242. 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 SEG3007AV-049 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-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007G-049 located on floor beam to side plate of the OBG Segment 13AE. The welder is identified as 069493. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019B-029 located on 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-2233-ESAB.

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007L-046 located on floor beam to side plate of the OBG Segment 13AE. 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-B-T-2233-ESAB.

Submerged Arc Welding (SAW)

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as SEG3007-010 located on deck plate (DP3081A) to deck plate (DP3082A) of the OBG Segment 13AE. The welder is identified as 062406. 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.

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