

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-026385**Date Inspected:** 08-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.

NDT

OBG Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08489.

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

DP3176-001-044~047, 076~085, 102~105, 136~139, 160~169, 178~181

WELDING

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This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007F-012/013 located at PP119+1500 of the OBG Segment 14E. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-4113-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007-007 located on deck plate to deck plate of the OBG Segment 13AE. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019U-003 located on the OBG Segment 14E. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-CWR2822.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AW-042 located on vertical plate of the OBG Segment 14E. The welder is identified as 050696. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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 Seg3019T-117 located on side plate of the OBG Segment 14E. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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 Seg3019K-016 located on the OBG Segment 14E. The welder is identified as 044779. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR20357.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019AE-248 located on Deck Panel Diaphragm of the OBG Segment 13AE. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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 SEG3007U-261 located at PP118.35 of the OBG Segment 13AE. The welder is identified as 055564. ZPMC

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Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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-014 located Floor Beam 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.

During random in process observations of OBG Segment 13BE, this QA inspector observed ZPMC personnel performing air-carbon-arc-cutting method to make a bevel on vertical plate for joint identified as SA3013-001-010 located on Vertical Plate (VP3004A) to Deck Plate (DP3096) of OBG Segment 13BE. This QA performed Visual Testing (VT) of the joint and found that appeared to be in general compliance with the applicable contract documents. 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
