

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-023189**Date Inspected:** 25-Apr-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. Sun Tian Liang**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: 008921

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 13AE. The weld designations reviewed are as follows:

1. SEG3007E-240, 175, 176, 131, 134, 135, 136, 139, 140, 253, 256, 257, 171
2. SEG3007G-117, 209, 212, 097, 098, 101, 102, 103, 106, 108, 111, 050

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014B-145 located on Floor Beam to Vertical Plate at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 045213. 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. See the attached file.

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SMAW welding of weld joint SEG3014F-216 located on Floor Beam to Vertical Plate at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 067588. 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.

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Deck Panel Diaphragm to Floor Beam Flange Weld at Panel point 123.5 CB Side of OBG Segment 13CW. The weld number is identified as SEG3015G.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) on Deck Panel to Deck Panel of OBG Segment 13BW and OBG Segment 13CW. The weld number is identified as OBW13A-016.

SMAW welding of weld joint SEG3007Y-372 located on Floor Beam Rib to SA at panel point 119+1500 of OBG Segment 13AE. ZPMC Welder is identified as 067183. ZPMC Quality Control (QC) is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20637

SMAW welding of weld joint SEG3007AH-024 located on Floor Beam to Key Plate at panel point 119 of OBG Segment 13AE. ZPMC Welder is identified as 066416. ZPMC Quality Control (QC) is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20640.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3007AE-087, 089 and 091 located on Side Plate Rib at panel point 117.5 to 118 of OBG Segment 13AE. ZPMC Welder is identified as 068924. ZPMC Quality Control (QC) is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-3G-(3F)-ESAB-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20640.

SMAW welding of weld joint SEG3007AA-090, 091, 097 and 098 located on Deck Panel RS Stiffener to Dec Panel at panel point 119 to 119+1500 of OBG Segment 13AE. ZPMC Welder is identified as 066416. ZPMC Quality Control (QC) is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SEG3007AA-069, 070, 076 and 077 located on Deck Panel RS Stiffener to Dec Panel at panel point 119 to 119-1500 of OBG Segment 13AE. ZPMC Welder is identified as 200113. ZPMC Quality Control (QC) is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

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

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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