

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-023791**Date Inspected:** 06-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), 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 067949 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld at panel point 125, of OBG Segment 14W. Weld joint is identified as SEG3020W-013. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB. This QA Inspector noted welding variables were 280~290 amperes and 25.3 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 067949 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam diaphragm weld at panel point 125, of OBG Segment 14W. Weld joint is identified as SEG3020W-015. ZPMC Quality Control (QC) Inspector identified as Zhu Lin 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 230~240 amperes and 24.2 volts, which appears to be in compliance with the approved WPS. See attached picture.

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This QA Inspector observed ZPMC qualified welding personnel identified as 069118 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam weld at panel point 126, of OBG Segment 14W. Weld joint is identified as SEG3020R-015. ZPMC Quality Control (QC) Inspector identified as Zhu Lin 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 250~260 amperes and 25.8 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066881 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam weld at panel point 126.5, of OBG Segment 14W. Weld joint is identified as SEG3020P-035. ZPMC Quality Control (QC) Inspector identified as Zhu Lin 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 250~260 amperes and 24.2 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ABF qualified NDT personnel perform Ultrasonic testing on Corner assembly to Deck panel and Deck panel to Deck panel weld of OBG Segments 13 BW and 13 CW. Weld joints are identified as SEG3014-006, SEG3014-009, SEG3015-004 and SEG3015-007. Total of 5 locations, 2 locations, 3 locations and 3 locations were marked for weld repair on SEG3014-006, SEG3014-009, SEG3015-004 and SEG3015-007 respectively. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 045246 perform welding by Shielded Metal Arc Welding (SMAW), on Vertical shear plate to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-065. 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-P-2214-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 145~160 amperes and 24.7 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 069841, 066261 perform welding by Shielded Metal Arc Welding (SMAW), on Vertical shear plate to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-056. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 140~150 amperes and 25.3 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 067588 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel I-Rib to I-Rib weld of OBG Segment 13BW. Weld joint is identified as DP3126-001-115, 120, 125, 130. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-3213-B-U3b. This QA Inspector noted welding variables were 150~160 amperes and 24.6 volts, which appears to be in compliance with the approved WPS.

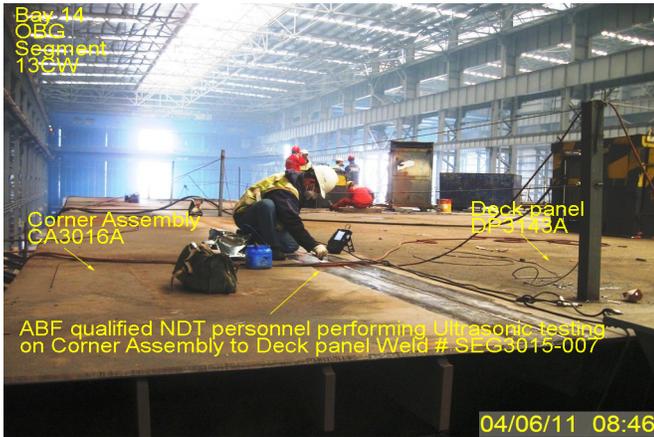
This QA Inspector observed ZPMC qualified welding personnel identified as 045196 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015L-009. ZPMC Quality Control (QC) Inspector identified as Zhang Lin

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was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Welding repair report B-WR20538. This QA Inspector noted welding variables were 135~150 amperes and 24.9 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
