

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023980**Date Inspected:** 30-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:** Tower and 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.

BLAST SHOP 2**West Shaft Lift 6 Tower Head**

This QA Inspector performed random External and Internal Post Blast Visual Inspection on West Shaft Lift 6 Tower Head. This QA Inspector discovered defects that required welding and NDT at different locations. These locations were marked up for future repair and NDT. These locations were also recorded on weld map for identification. Areas that required additional grinding were marked by QA and repaired by ZPMC personnel.

WELDING

This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 066361 perform repair welding by Shielded Metal Arc Welding (SMAW), on Anchor Plate to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AQ-025. 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-345-SMAW-1G (1F)-FCM-Repair-1, which is used as per Critical Welding Repair Report B-CWR2923

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

R1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067949 perform welding by Flux Cored Arc Welding (FCAW), on Side plate I Rib to Floor beam weld at Panel Point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020AZ-242, 247, 252, 257. 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 observed ZPMC qualified welding personnel identified as 066421 perform welding by Flux Cored Arc Welding (FCAW), on Edge plate to Side plate weld between Panel Point 127 and Panel Point 128 of OBG Segment 14W. Weld joint is identified as SEG3020AH-004. 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 observed ZPMC qualified welding personnel identified as 037938 perform welding by Shielded Metal Arc Welding (SMAW), on Edge plate to Side plate weld between Panel Point 125 and Panel Point 127 of OBG Segment 14W. Weld joint is identified as SEG3020AH-002. 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-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066881 perform welding by Flux Cored Arc Welding (FCAW), on longitudinal diaphragm to Deck panel weld of OBG Segment 14W. Weld joint is identified as SEG3020AB-016. 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 observed ZPMC qualified welding personnel identified as 037748 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Deck panel diaphragm weld at Panel Point 127.3 of OBG Segment 14W. Weld joint is identified as SEG3020AK-003. 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.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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