

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-023891**Date Inspected:** 24-May-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. Shi Lei**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.

Magnetic Particle Testing (MT) – NWIT Document No's: 009239

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13AW. The weld designations reviewed are as follows:

1. SEG3013M-153, 147, 141, 135
2. SEG3013M-044

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3127-001-011, 012 located on bottom plate connected SA3127 at panel point 124 to 124.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 045240 ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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FCAW welding of weld joint SA3126-001-007, 008 located on bottom plate connected SA3126 at panel point 123 to 123.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SA7508-001-005, 006, 007, 008 located on bottom plate connected SA7508 at panel point 122 to 122.5 FL2 side of OBG Segment 13CW. ZPMC Welder is identified as 066825. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014C-086 located on RS Stiffener to Floor Beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 066156. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21062.

SMAW welding of weld joint SEG3014C-130 located on RS Stiffener to Floor Beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 044541. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21062.

SMAW welding of weld joint DP3133-001-030 located on deck panel splice plate at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 057220. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21033.

SMAW welding of weld joint DP3146-001-241 located on deck panel splice plate at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 066687. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21033.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) on repair area on deck panel to deck panel splice weld of OBG Segment 13AW. The weld number is identified as SEG3013A-009 and 010. See the attached picture.

Visual Inspection after Blast – Trail Assembly Yard

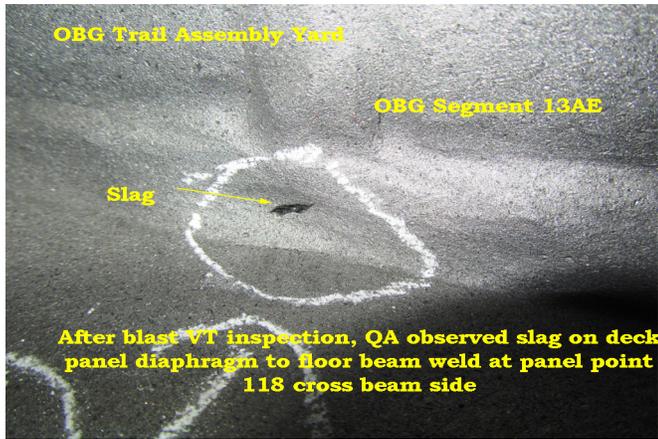
OBG Segment 13AE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13AE, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. The panel point is identified as PP117.5 to 118 at cross beam side. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

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



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