

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-024558**Date Inspected:** 07-May-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:** Li Yan Hua**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

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09057.

Ultrasonic Testing (UT)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% 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 13BW. The weld designations reviewed is as follows:

SEG3014M-001

WELDING

TA-Yard

This QA Inspector randomly observed the following work in progress:

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Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020C-057 located on bottom plate stiffener to floor beam of the OBG Segment 14W. The welder is identified as 037705. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020B-016 located on floor beam stiffener to floor beam of the OBG Segment 14W. The welder is identified as 037705. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020B-023 located on floor beam stiffener of the OBG Segment 14W. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SA3409-001-068 located on anchor plate stiffener of the OBG Segment 14W. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. 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 SEG3020AH-002 located on edge plate to vertical plate of the OBG Segment 14W. The welder is identified as 067520. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1. 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.

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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 James Devey-15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
