

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-024368**Date Inspected:** 07-Jun-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.

Ultrasonic Testing (UT) – NWIT Document No: 009379

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 Bike Path. The weld designations reviewed are as follows:

1. BK24A5-001-095, 096, 097, 098, 099, 100, 101, 103, 104, 029
2. BK25A1-001-006
3. BK24A6-001-111, 112
4. BK24A8-001-112, 113
5. BK25A6-001-065, 066

Magnetic Particle Testing (MT) – NWIT Document No's: 009382

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 Bike Path. The weld designations reviewed are as follows:

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1. BK23A11-001-003, 004, 005, 006, 007, 008
2. BK23A11-001-011, 012, 013, 014, 015, 016
3. BK23A11-001-028, 029, 030, 031, 032, 033
4. BK23A11-001-034, 035, 036, 037, 038, 039

Visual Testing (VT) – NWIT Document No's: 009383

This QA inspector performed VT randomly of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as before covering the closer box area of OBG Bike Path BK24-001. See the attached picture.

OBG Trial Assembly Yard

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020P-208 located on Edge Beam to Floor Beam at panel point 126.5 of OBG Segment 14W. ZPMC Welder is identified as 069118. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G-(1F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20970.

SMAW welding of weld joint SEG3020R-173 located on Edge Beam to Floor Beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G-(1F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20970.

SMAW welding of weld joint SEG3020*-021 located on Edge Plate to Deck panel at panel point 125.5 to 126.5 of OBG Segment 14W. ZPMC Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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-21150.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on side plate to Bottom plate hold back area of OBG Segment 13CW. The panel point is identified as PP124.5 at counter weight. The weld number is identified as SEG3015A-008. See the attached picture.

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