

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-024836**Date Inspected:** 22-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.

Magnetic Particle Testing (MT)

This QA inspector witnessed and performed Magnetic Particle Testing (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 14W.

The weld designations reviewed/witnessed are as follows:

1. SEG3020W-009, 015, 028, 030, 034
2. SEG3020W- 108, 109, 093, 094, 095, 097, 098, 110
3. SEG3020W- 111, 116, 090, 091, 092, 179, 181
4. SEG3020R- 015, 066, 007, 013, 066, 018, 074, 069, 061, 062, 063
5. SEG3020R- 023, 024, 025, 026, 027, 028, 029, 030
6. SEG3020R- 256, 257, 258, 259, 260, 261, 262, 263, 264, 265
7. SEG3020R- 157, 158, 244, 245, 161, 162, 246, 247, 165, 166, 248, 249
8. SEG3020R- 159, 163, 167, 171, 169, 170, 250, 251
9. SEG3020R- 192, 193, 191, 194, 195, 196, 197, 198, 199, 200
10. SEG3020R- 201, 202, 203, 204, 205, 206

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- 11. SEG3020R- 148, 149, 150, 151, 152, 153, 154, 155
- 12. SEG3020R- 156, 157, 158, 159, 160, 161, 162, 166, 164
- 13. SEG3020R- 170, 172, 169, 173, 174, 175

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020D-324 located on Deck panel Diaphragm to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020D-325 and 326 located on SA3416 to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SEG3020D-327 located on Deck panel Diaphragm to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066758. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020D-328 and 329 located on SA3416 to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066758. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SEG3020D-330 located on Deck panel Diaphragm to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 068097. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020D-331 and 332 located on SA3416 to RS Stiffener at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 068097. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on side plate to Bottom plate hold back area of OBG Segment 14W. The panel point is identified as PP125 to 125.5 at counter weight side. The weld number is identified as SEG3020A*-001. 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