

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024840**Date Inspected:** 18-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. SA3123-(001~002)-013, 014, 015
2. SA3123-(001~002)-016, 017, 018
3. SA3122-(015~024)-007, 008, 009
4. SA3122-(015~024)-010, 011, 012
5. SA7507-(001~002)-007, 008, 009
6. SA7507-(001~002)-010, 011, 012
7. SA3127-(001~019)-009, 010, 011, 012
8. SA7523-(001~002)-001, 002, 003, 004
9. SA3126-(001~004)-001, 002, 003, 004
10. SA7522-(001~002)-001, 002, 003, 004

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11. SA3136-(001~004)-001, 002, 003, 004
12. SA3136-(001~008)-005, 006, 007, 008
13. SA7514-(001~005)-007, 008, 009
14. SA7514-(001~005)-010, 011, 012
15. SA3126-(016~029)-005, 006, 007, 008
16. SA3127-(001~002)-003, 004, 007, 008
17. SA3127-(001~002)-001, 002, 005, 006
18. SA3127-(020~033)-009, 010, 011, 0012
19. SA3128-(001~002)-004, 005, 006
20. SA3128-(001~002)- 010, 011, 012
21. SA3128-(001~002)- 001, 002, 003
22. SA3128-(001~002)- 007, 008, 009

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020S-119 to 126 located on Bottom plate I-rib to bottom plate at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 066261. 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 OBW14A-015 located on drip plate at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 037997. 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-2114-FCM-1.

SMAW welding of weld joint SEG3020M-064 located on anchor plate I-rib to floor beam at panel point 127 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 SEG3020R-186 located on anchor plate I-rib to floor beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067904. 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 SEG3020M-196 located on floor beam I-rib to longitudinal diaphragm at panel point 127 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-2214-Tc-U4b-FCM-1.

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
