

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-024841**Date Inspected:** 17-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 are as follows:

1. SA3122-004-010, 011, 012
2. SA3122-004-007, 008, 009
3. SA3122-003-007, 008, 009
4. SA3122-006-007, 008, 009
5. SA3123-002-004, 005, 006
6. SA3122-001-007, 008, 009
7. SA3122-007-010, 011, 012
8. SA3122-011-010, 011, 012
9. SA3122-003-010, 011, 012
10. SA3122-011-007, 008, 009

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11. SA3122-012-007, 008, 009
12. SA3122-014-007, 008, 009
13. SA3123-002-007, 008, 009
14. SA3122-012-010, 011, 012

The weld designations witnessed are as follows:

1. SA3123-001-010, 011, 012
2. SA3122-001-010, 011, 012
3. SA3122-005-010, 011, 012
4. SA3122-005-007, 008, 009
5. SA3122-002-010, 011, 012
6. SA3122-008-007, 008, 009
7. SA3122-013-007, 008, 009
8. SA3123-001-007, 008, 009
9. SA3122-006-010, 011, 012
10. SA3123-001-001, 002, 003
11. SA3122-009-007, 008, 009
12. SA3122-002-007, 008, 009
13. SA3122-007-007, 008, 009
14. SA3122-010-007, 008, 009
15. SA3122-009-010, 011, 012
16. SA3122-010-010, 011, 012
17. SA3122-013-010, 011, 012
18. SA3123-002-001, 002, 003
19. SA3122-014-010, 011, 012
20. SA3122-008-010, 011, 012

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020AG-009 located on Edge Plate to Side Plate at panel point 127 to 128 of OBG Segment 14W. ZPMC Welder is identified as 067610. 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-2212-B-U2-FCM-1.

SMAW welding of weld joint SEG3020V-029 located on Deck panel Splice Plate to floor beam at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 066674. 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-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020R-148 and 150 located on floor beam I-rib to I-rib at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 070006. ZPMC Quality Control (QC) is identified as Mr. Zhu

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Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3020Z-084 located on floor beam I-rib to longitudinal diaphragm at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 040610. 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-2111-FCM-1.

SMAW welding of weld joint SEG3020E-029 located on floor beam to edge plate at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 046765. 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-197 located on floor beam I-rib to Longitudinal Diaphragm at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 070432. 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 SEG3020AB-116 located on Longitudinal Diaphragm I-rib to floor beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067829. 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. See the attached picture.

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.

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Inspected By:	Kumar, Vibin	Quality Assurance Inspector
Reviewed By:	Patel, Hiranch	QA Reviewer
