

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-016611**Date Inspected:** 29-Aug-2010**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. Geng Wei & Mr. Xu Tao**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 Segments**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) – Document No: 006516

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 Suspender Bracket. The weld designations reviewed are as follows:

- SB17-084-008, 011, 020, 025, 037, 061, 031, 067, 055, 043

Magnetic Particle Testing (MT) - Document No's: 006522

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 Segment 13 Side Plates. The weld designations reviewed are as follows:

- SP3065-001-043~070

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This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13AE, weld joint identified as SEG3011A-007. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform SAW Welding on OBG Segment 13AE, weld joint identified as SEG3007AD-005 and 006. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 217805 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13AE, weld joint identified as SEG3011A-007. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform SAW Welding on OBG Segment 13CW, weld joint identified as SEG3015A-010. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

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This QA inspector observed ZPMC qualified welding personnel identified as 062806 perform Flux Core Arc Welding (FCAW) welding on suspender bracket, weld joint identified as SB019-074-026 and 032. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062755 perform FCAW welding on suspender bracket, weld joint identified as SB017-084-026 and 032. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062808 perform FCAW welding on suspender bracket, weld joint identified as SB019-078-026 and 032. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Visual Inspection after Blast

Cross beam 12

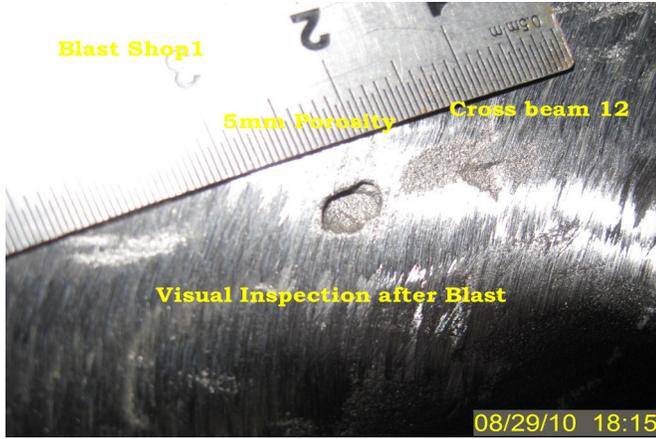
This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior and interior components of the deck panel, floor beams intermediate diaphragm, bottom plate and side plate of this cross beam. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied.

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ZPMC QC personnel are aware of these areas and were present during the inspection.

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.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
