

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-017191**Date Inspected:** 01-Oct-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:** Mrs. Lv Yun**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 Bike Path and 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: 006820

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. BK004A5-011-112,115,118,121,122,125,128,131,007
2. BKSD1-005,006
3. BK004A1-011-008

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerged Arc Welding (SAW) Welding on deck plate splice joint of OBG Segment 13BE, weld joint identified as SEG3009-005. ZPMC QC is identified as Mr. Lv Li Qing. 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 044824 perform SAW Welding on

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deck plate splice joint of OBG Segment 13AE, weld joint identified as SEG3007-005. ZPMC QC is identified as Mr. Zhang Lin. 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 045265 perform SAW Welding on bottom plate butt joint of OBG Segment 14W, weld joint identified as SEG3020A*-001. ABF QC is identified as Mrs. Lv Yun. 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 067520 perform Flux Core Arc Welding (FCAW) repair welding on vertical plate of OBG Segment 13AE, weld joint identified as VP3005-001-010. ZPMC QC is identified as Mr. Lu Li Qing. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair, which is used as per Welding Repair Report (WWR) B-WRR-15331.

This QA inspector observed ZPMC qualified welding personnel identified as 202121 perform FCAW welding on bottom plate splice joint of OBG Segment 14W, weld joint identified as SEG3020A*-002. ABF QC is identified as Mrs. Lv Yun. 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 202121 perform FCAW welding on bottom plate splice joint of OBG Segment 14W, weld joint identified as SEG3015-005. ABF QC is identified as Mrs. Lv Yun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Visual Inspection after Blast – Blast Shop 1

OBG Segment 11DW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11DW, after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Visual Inspection after Blast - Blast Shop 2

OBG Segment 11EE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11EE, after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

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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
