

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017704**Date Inspected:** 02-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 11BE-11CE, BK side, Side Panel I-rib splice.

FCAW welding of weld joint SP715-001-31, 32, 33; located at Trial assembly yard. Welder is identified as 047353; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2233-B-U2-F.

Trial assembly yard, 11BE-11CE, BK side, Edge Panel I-rib splice.

SMAW welding of weld joint EP171-001-13, 14; located at Trial assembly yard. Welder is identified as 044515; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Trial assembly yard, 11BE-11CE, CB side, Deck Panel I-rib splice.

SMAW welding of weld joint DP706-001-19, 20; located at Trial assembly yard. Welder is identified as 500363; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3213-B-U3b.

Trial assembly yard, 11CW-11DW, EP-F9.

SMAW welding of weld joint OBW11A-005; located at Trial assembly yard. Welders are identified as 040611; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

Trial assembly yard, CB17, BP-SP-West, Hold back weld.

FCAW welding of weld joint CB3001A-017-005; located at Trial assembly yard. Welder is identified as 066421; ZPMC Quality Control Inspector (QC) is identified as Feng Ya Tun . The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Trial assembly yard, 11CW-11DW, SP-BP E4, CB Side.

FCAW welding of weld joint SEG069A-012, SEG071A-021; located at Trial assembly yard. Welder is identified as 040609; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following

Trial assembly yard, 11BW-11CW.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11W-050) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Deck panel & Edge panel at the Splice of OBG Segment 11BW- 11CW, Cross beam Side. The weld designations were as;

- 1) SEG067*-049. (11BW-11CW, DP-EP-W5);
- 2) CA086-006. (11BW-11CW, DP-EP-W5).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
