

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-018627**Date Inspected:** 18-Dec-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**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) – NWIT Document No's: 007822

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 13AW. The weld designations reviewed are as follows:

1. SEG3013Y-115, 16, 134, 050, 052, 063, 065, 426, 033, 037, 039, 004, 089
2. RS3485A-001, 002
3. RS3485B-001, 002
4. SEG3013AU-074
5. SEG3013AX-101, 105, 078

Magnetic Particle Testing (MT) – NWIT Document No's: 007824

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 13AW. The weld designations reviewed are as follows:

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1. SEG3013Y-003, 469, 470, 377, 381
2. SEG3013H-143, 144
3. SEG3013AU-096

Magnetic Particle Testing (MT) – NWIT Document No's: 007824

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 14W. The weld designations reviewed are as follows:

1. SEG3020K-010
2. SA3410-001-038, 039, 039, 041
3. SA3409-001-038, 039, 039, 041
4. SA3409-001-001, 024, 002, 019, 015, 063
5. SA3409-001-017, 014, 060, 005, 007, 008, 009, 028, 031, 032, 053, 054
6. SA3409-001-065, 066, 020, 021, 055, 056, 006, 013, 037, 044, 048, 049

Magnetic Particle Testing (MT) – NWIT Document No's: 007830

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 14W. The weld designations reviewed are as follows:

1. SA3409-001 - 022, 023, 029, 030, 033, 034
2. SA3409-001- 075, 076, 077, 078

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AY-014 located on Side Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 202122. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB. See the attached picture.

FCAW welding of weld joint SEG3020AY-015 located on Side Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3015B-271 located on Side Plate to Floor Beam of the OBG Segment 13CW. 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-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015H-268 and 269 located on panel point 123

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floor beam of OBG Segment 13CW. ZPMC Welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-U2-FCM-1.

SMAW welding of weld joint SEG3015H-318, 320 located on panel point 123 floor beam of OBG Segment 13CW. ZPMC Welder is identified as 068924. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-FCM.

FCAW welding of weld joint SEG3015D-208 and 212 located on panel point 123 floor beam of the OBG Segment 13CW ZPMC Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

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: Patel,Hiranch

QA Reviewer