

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018965**Date Inspected:** 17-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), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qiu Wen	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	

Summary of Items Observed:

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

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Repair welding of Weld joint # 254 as per CWR no. B-CWR -2418, located on Deck panel DP3148 in segment 13BW. Welder is identified as 066398. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –FCAW -2G (2F) –ESAB –FCM-Repair.

Weld joint # 132 located on Longitudinal diaphragm to Floor beam stiffener SEG 3013AP in segment 13AW. Welder is identified as 067183. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B –P-2214 – TC –U4B –FCM -1.

Weld joint # 002 located on Side panel SP3109A to Side panel SP3103A, in segment 13AW. Welder is

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identified as 045240. ZPMC Quality Control (QC) Inspector is identified as Li Ke Wei. The welding variables recorded by QC appeared to comply with the WPS – B –T -2232 -Esab.

Weld joint # 002 located on Side plate to Edge plate, in segment 13BW to 13CW, OBW 13AD. Welder is identified as 201583. ZPMC Quality Control (QC) Inspector is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B –T -2133 -Esab.

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 016 as per CWR no. B –CWR -2394, located on Deck panel DP 3120 -001 in segment 13AW. Welder is identified as 037780. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -FCM – Repair.

Repair welding of Weld joint # 254 as per CWR no. B –CWR -2418 , located on Deck panel DP 3148 -001 in segment 13AW. Welder is identified as 066398. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -FCM – Repair .

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07817

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG Edge beam components. The weld designations reviewed are as follows:

SEG3014P – Jt. nos. -006, 027,028,032,115,116,007,033,034,039

SEG3015G – Jt. nos. -163,167,168,171,172,175

SEG3015J – Jt. nos. -148,153,154,157,158,160

For further information see below pictures:-

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

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Summary of Conversations:

No relevant Conversations.

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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer
