

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-018971**Date Inspected:** 20-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/ Tower	

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)

Weld joint # 033 located on Floor beam to Longitudinal Diaphragm SEG 3020R in segment 14 W, P.P 126. Welder is identified as 067520. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2233-Esab.

Weld joint # 271 located on Side plate to Edge plate SEG 3015B in segment 14W. Welder is identified as 045213. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2232-Esab.

Weld joint # 144 located on Floor beam to Side plate SEG 3014B in segment 13BW. Welder is identified as 045143. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC

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appeared to comply with the WPS – B –T -2233-Esab.

Weld joint # 186 located on Floor beam to Edge plate, SEG 3015K in segment 13CW. Welder is identified as 068924. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2233-Esab.

Weld joint # 187 located on Floor beam to Side plate, SEG 3015K in segment 13CW. Welder is identified as 066179. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2232-Esab.

Shielded Metal Arc Welding (SMAW)

Weld joint # 271 located on Side plate to Edge plate SEG 3015B, in segment 14W. Welder is identified as 067993. ZPMC Quality Control (QC) Inspector is identified as Zhang Lin. The welding variables recorded by QC appeared to comply with the WPS – B –P -2212 –B –U2 –FCM -1.

Repair welding of Weld joint # 021 as per CWR no. B –CWR -2421, located on Deck panel DP 3133 -001 in segment 13BW. Welder is identified as 067588. 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 # 248 as per CWR no. B –CWR -2416, located on Deck panel DP 3148 -001 in segment 13BW. Welder is identified as 045133. 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 # 251 as per CWR no. B –CWR -2417, located on Deck panel DP 3148 -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.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07849

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 Lift 13 components. The weld designations reviewed are as follows:

SEG3013X – Jt. nos. - 471, 472, 477, 608

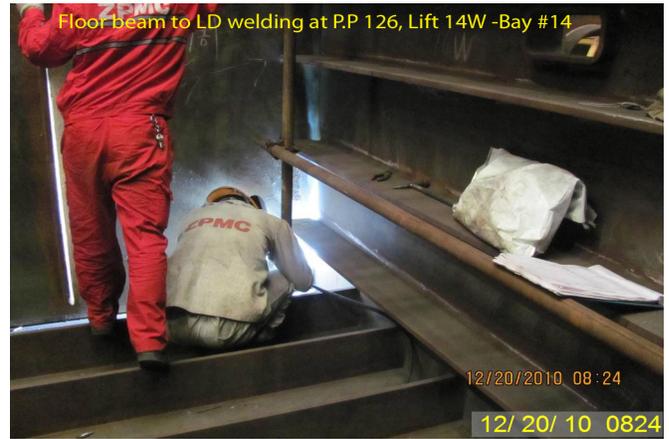
SEG3013Y – Jt. nos. - 051, 056, 062, 064, 066, 032, 038, 040, 042, 044,383,384

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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.



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