

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-019076**Date Inspected:** 30-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: 007982

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. The weld designations reviewed are as follows:

1. SA3056-004-025, 027, 029, 032
2. SA3056-005-025, 026, 027, 029
3. SA3056-003-017, 018, 019, 023
4. SA3056-001-025, 027, 029, 031
5. SA3056-002-025, 026, 027, 031
6. SA3056-003-025, 027, 031, 032
7. SA3056-001-002, 007, 010, 015, 018, 023, 024
8. SA3056-002-017, 018, 019, 031, 032

Magnetic Particle Testing (MT) – NWIT Document No's: 007990

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC

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Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. AP3031-001-192, 198, 200, 203, 208, 212, 215, 217
2. AP3031-001-296, 325, 344, 373, 421, 441
3. AP3031-001-469, 517, 537, 584, 613, 633
4. AP3031-001-661, 728, 757, 777, 822, 823
5. AP3031-001-849, 869, 914, 941, 987, 1007

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3013R-028 located on Longitudinal Diaphragm to K-Plate at panel point 117.5 of the OBG Segment 13AW. ZPMC Welders are identified as 067183. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013D-191 located on Floor Beam to Edge Beam at panel point 120 of the OBG Segment 13AW. ZPMC Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013AH-024 located on Floor Beam to Edge Beam at panel point 119 of the OBG Segment 13AW. ZPMC Welder is identified as 037778. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013AH-027 located on Floor Beam to K-Plate of the OBG Segment 13AW. ZPMC Welder is identified as 069841. ZPMC Quality Control (QC) is identified as Mr. Liu Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014E-091 096, 131 and 136 located on Side plate stiffener to Floor Beam of the OBG Segment 13BW. ZPMC Welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014G-086 090, 118 and 122 located on Side plate stiffener to Floor Beam of the OBG Segment 13BW. ZPMC Welder is identified as 067917. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2213-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020BB-064 located on SA3450 to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr.

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Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3020BB-046 located on SA3447 to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint SEG3013F-069 and 072 located on Side plate I-stiffener to I stiffener of the OBG Segment 13AW. ZPMC Welder is identified as 068494. 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.

FCAW welding of weld joint SEG3015K-264 located on Floor Beam to K-plate of the OBG Segment 13AW. ZPMC Welder is identified as 045143. 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.

Submerged Arc Welding (SAW) welding of weld joint SA3013-003 and 002 located on Anchor Plate to Anchor Plate of the OBG Segment 14E. ZPMC Welder is identified as 044771. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

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.

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Inspected By:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	Patel,Hiranch	QA Reviewer
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