

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-019081**Date Inspected:** 24-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.

Ultrasonic Testing (UT) – NWIT Document No: 007897 (Scanning Face C)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. AP3031-001-505, 511, 539, 557, 561, 585, 573, 577, 587, 591
2. AP3031-001-409, 413, 429, 451, 457, 461, 477, 481, 487, 493
3. AP3031-001-597, 603, 607, 623, 627, 633, 643, 649, 655, 671
4. AP3031-001-671, 677, 683, 687, 693, 699, 701, 717, 721, 725
5. AP3031-001-869, 873, 879, 885, 903, 917, 921, 925, 933, 949

Ultrasonic Testing (UT) – NWIT Document No: 007912

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AW. The weld designations reviewed are as follows:

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1. SEG3007AZ-068, 071

Magnetic Particle Testing (MT) – NWIT Document No's: 007908

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 13AE. The weld designations reviewed are as follows:

1. SA3011-001-005
2. SA3011-002-005
3. SA3011-003-005
4. SA3011-004-005

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3011K-127, 137, 147 located on Side Plate I-Stiffener of the OBG Segment 13CE. ZPMC Welder is identified as 068091. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. 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 SEG3009V-002 located on Vertical Plate to Side Plate of the OBG Segment 13BE. ZPMC Welders are as identified as 067765 and 067571. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3009V-002 located on Vertical Plate to Side Plate of the OBG Segment 13CE. ZPMC Welders are as identified as 066258 and 069683. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-P-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SA3011-001-001 located on the OBG Segment 13AE. ZPMC Welder is identified as 070140. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2233-ESAB.

FCAW welding of weld joint SA3038-024 located on the OBG Segment 13AE. ZPMC Welder is identified as 067079. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2231-ESAB.

FCAW welding of weld joint SEG3011-035, 041 located on Longitudinal Diaphragm Stiffener of the OBG Segment 13CE. ZPMC Welder is identified as 067103. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2132-ESAB.

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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
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Reviewed By:	Patel,Hiranch	QA Reviewer
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