

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-019084**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) 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 Bike Path**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: 007849

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-340, 342, 347, 372, 378, 512, 515, 519, 538, 539, 543, 550
2. SEG3013AX-144, 118, 199, 069, 070, 157, 161
3. SEG3013J-125, 126
4. SEG3013AW-073, 074

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015B-271 located on Side Plate to Edge Plate of the OBG Segment 13CW. ZPMC Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-

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B-T-2232-ESAB.

SMAW repair welding of weld joint DP3148-001-257 located on deck panel to deck panel longitudinal diaphragm joint of OBG Segment 13CW. ZPMC Welder is identified as 037780. ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2417.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3015K-186, 187 located on Floor Beam to Edge Plate of the 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-T-2232-ESAB.

FCAW welding of weld joint SEG3020E-056 and 057 located on Floor Beam to bottom plate of the OBG Segment 14W. ZPMC Welders are identified as 047866 and 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.

FCAW welding of weld joint SEG3020G-022 and 023 located on Longitudinal Diaphragm to Floor Beam of the OBG Segment 14W. ZPMC Welder is identified as 201215. 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 SEG3020H-075 and 076 located on Longitudinal Diaphragm to Floor Beam of the OBG Segment 14W. ZPMC Welder is identified as 066439. 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 SEG3020H-042 and 043 located on Bottom plate I-stiffener to Floor Beam 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-2133-ESAB.

Bay 19

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004A1-014-044 located on side plate to deck plate of the OBG Bike Path BK004A-14. ZPMC Welder is identified as 259566. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F)-Repair.

Flux Core Arc Welding (FCAW) welding of weld joint BK004A3-014-068, 069 and 070 located on the OBG Bike Path BK004A-14. ZPMC Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2132-ESAB.

FCAW welding of weld joint BK004A3-014-101, 102 and 102 located on the OBG Bike Path BK004A-14. ZPMC

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Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2134-ESAB.

This QA inspector observed that ABF personnel performed Magnetic Particle Testing on Closer Plate of OBG Bike Path BK005A-002 and on stringer plate to deck plate joint of OBG Bike Path BK004B-001.

This QA inspector observed that ABF personnel performed Ultrasonic Testing on deck plate to side plate of OBG Bike Path BK004B1-001 and the weld joint is identified as BK004B1-001-044. See the attached picture.

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