

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-019308**Date Inspected:** 15-Jan-2011**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

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|------------------------------------|-------------|----------------------------------|-------------|----|
| CWI Name: | Mr. Qui 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 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: 008175

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. RS3079-001-003, 004, 005
2. RS3079-001-001
3. SEG3007T-081, 082, 079, 080, 092
4. SEG3007AU-069, 071
5. SEG3007D-168
6. SEG3007AU-066, 068
7. SEG3007D-165
8. RS3096-001-004, 005, 006
9. SEG3007D-166, 167
10. SEG3007B-073
11. RS3007-001-002

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3013BB-001 and 019 located on Vertical Shear to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20146.

SMAW repair welding of weld joint SEG3020E-44 located on Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 051348. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) – FCM – Repair-1, which is used as per Critical Welding Repair (CWR) B-CWR-2735.

SMAW repair welding of weld joint SEG3013AA-063 and 064 located on Edge Plate to Side Plate of OBG Segment 13AW. ZPMC Welder is identified as 066481. 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-1, which is used as per Welding Repair Report (WRR) B-WRR-20131.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020L-023 located on Bottom Plate 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 SEG3020V-071, 072 located on Side Plate to Floor Beam of the OBG Segment 14W. ZPMC Welders are identified as 066695 and 067949. 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-2132-ESAB.

FCAW welding of weld joint SEG3015D-002 and 003 located on Deck Panel Diaphragm to Floor Beam of the OBG Segment 13CW. ZPMC Welders are identified as 066155 and 045227. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint SEG3015E-010 and 011 located on Deck Panel Diaphragm to Floor Beam of the OBG Segment 13CW. ZPMC Welders are identified as 067993 and 037932. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW repair welding of weld joint SEG3014S-052 located on Floor Beam of OBG Segment 13BW. ZPMC Welder is identified as 045204. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair-1, which is used as per Critical Welding Repair (CWR) B-CWR-2725.

SMAW welding of weld joint SEG3014K-093 and 095 located on Longitudinal Diaphragm to Floor Beam at panel

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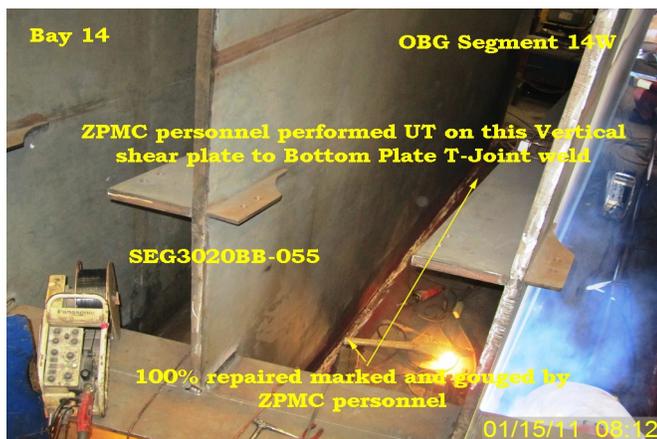
point 122 of the OBG Segment 13BW. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr.Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-FCM-1.

SMAW welding of weld joint SEG3014K-094 and 096 located on Longitudinal Diaphragm to Floor Beam at panel point 122 of the OBG Segment 13BW. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr.Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-FCM-1.

FCAW repair welding of weld joint SEG3014D-143 and 193 located on Bottom Plate I-Stiffener to Floor Beam at panel point 122 of the OBG Segment 13BW. ZPMC Welders are identified as 045143 and 201583. 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-Repair, which is used as per Welding Repair Report (WRR) B-WRR-18318.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on Floor beam and Longitudinal Diaphragm Stiffeners of the OBG Segment 13BW at panel point 124.5 and 124 north side.

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