

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-019311**Date Inspected:** 12-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**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. 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.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020D-035 located on Floor Beam to Longitudinal Diaphragm of the OBG Segment 14W. ZPMC Welder is identified as 067520. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) – FCM – Repair, which is used as per Welding Repair Report (WRR) B-WRR-20078.

SMAW welding of weld joint DP3173-001-036, 037, 038, 039 and 040 located on deck panel diaphragm to Dec Plate of the OBG Segment 14W. ZPMC Welder is identified as 045133. 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-Tc-U4b-FCM.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020K-032, 034, 036 and 038 located on Longitudinal Diaphragm to Floor Beam at panel point 127.3 of the OBG Segment 14W. ZPMC Welder is as identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC

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appeared to comply with the Applicable WPS- B-T-2231-ESAB.

FCAW welding of weld joint DP3175-001-359 and 360 located on deck panel diaphragm to Dec Plate of the OBG Segment 14W. ZPMC Welder is identified as 203871. 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-2133-ESAB.

FCAW welding of weld joint DP3177-001-163 and 164 located on deck panel diaphragm to Dec Plate of the OBG Segment 14W. ZPMC Welder is identified as 048433. 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-2133-ESAB.

FCAW welding of weld joint DP3177-001-171 and 172 located on deck panel diaphragm to Dec Plate of the OBG Segment 14W. ZPMC Welder is identified as 048696. 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-2133-ESAB.

FCAW welding of weld joint SEG3020BB-019 located on Vertical Shear Plate to Bottom Plate of the OBG Segment 14W. ZPMC Welders are as identified as 067947 and 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 SA3175-001-001, 002, 003 and 004 located on Edge Plate to Edge Plate of the OBG Segment 14W. ZPMC Welders are as identified as 054069. 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-2231-ESAB.

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 122.5 and 123 north side.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Vertical Share Plate to Bottom plate of the OBG Segment 14W. The weld numbers are identified as SEG3020BB-046, 055 and 037. See the attached picture.

Bay 08

This QA Inspector observed the following work in progress:

FCAW welding of weld joint BK004A8-063-078 located on the OBG bike path BK004A-063. ZPMC Welder is identified as 500405. ZPMC Quality Control (QC) is identified as Mr. Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

FCAW welding of weld joint BK004A6-063-088 located on the OBG bike path BK004A-063. ZPMC Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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