

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-019314**Date Inspected:** 07-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

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.

Ultrasonic Testing (UT) : AB/F Request No. 01062011-1

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between Deck Plate to Deck Plate and Side Plate to Side Plate for OBG Segment 12AE and 12BE. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The welds are designation as follows

1. OBE12-003
2. OBE12-002
3. OBE12D-003

Magnetic Particle Testing (MT) – NWIT Document No's: 008078

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 Bike Path. The weld designations reviewed are as follows:

1. BK4ASD1-057-001, 002, 003, 004, 022, 023, 024, 027

Visual Testing (VT) – NWIT Document No: 008076

This QA inspector randomly performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Bike Path BK004A-064. The weld designations reviewed on before fit-up the closure plate welds. See the attached picture.

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) repair welding of weld joint SEG3014F-084, 090 located on Floor Beam to Bottom Plate Stiffener of the OBG Segment 13BW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- 345-FCAW-3G (3F)-FCM-Repair-ESAB, which is used as per Welding Repair Report (WRR) B-WRR-19634.

FCAW repair welding of weld joint SEG3014F-149, 144 located on Floor Beam to Bottom Plate Stiffener of the OBG Segment 13BW. ZPMC Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS- 345-FCAW-3G (3F)-FCM-Repair-ESAB, which is used as per Welding Repair Report (WRR) B-WRR-19634.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3015D-224 located on Vertical Plate to Floor Beam corner joint of OBG Segment 13CW. ZPMC Welder is identified as 045204. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. 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-18952. See the attached picture.

SMAW repair welding of weld joint SEG3014B-233 located on Vertical Plate stiffener to Floor Beam corner joint of OBG Segment 13BW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Welding Repair Report (WRR) B-WRR-18963.

Bay 08

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A5-059-024 and 025 located on the OBG bike path BK004A-059. 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-2133-ESAB.

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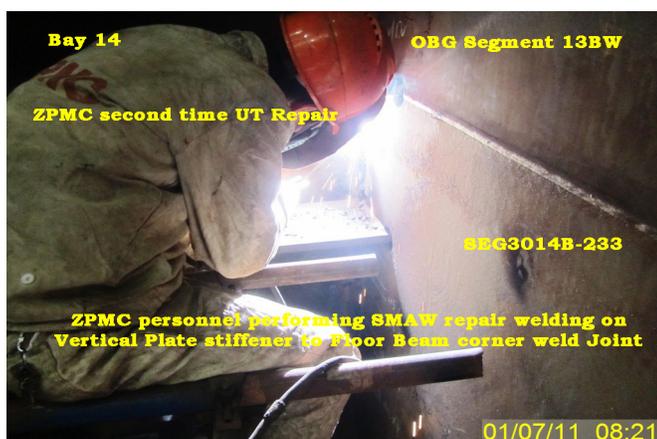
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FCAW welding of weld joint BK004A5-059-034 and 035 located on the OBG bike path BK004A-059. ZPMC Welder is identified as 500405. ZPMC Quality Control (QC) is identified as Mr. Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS- B-T-2133-ESAB.

FCAW welding of weld joint BK004A5-059-119 and 120 located on the OBG bike path BK004A-059. 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-2132-ESAB.

ZPMC personnel performing heat straightening on deck plate of OBG bike path member identified as BK004A-063. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Liu Chuan Gang was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 9609.

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