

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-019316**Date Inspected:** 04-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. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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: 008039

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. SEG3011F-066, 071, 076, 081, 086, 091, 096, 101, 106
2. SEG3011F-111, 116, 121, 126, 131, 136, 141, 157, 159, 146
3. SEG3011H-147, 149

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020AY-143 and 148 located on Side plate to Floor Beam corner joint of OBG Segment 14W. ZPMC Welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2213-Tc-U4b-FCM-1.

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SMAW welding of weld joint SEG3020AY-263 located on Side plate to Floor Beam corner joint of OBG Segment 14W. ZPMC Welder is identified as 037780. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2213-Tc-U4b-FCM-1.

SMAW repair welding of weld joint SA7512C-251 located on Deck Panel OBG Segment 13CW. ZPMC Welder is identified as 067904. 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-2629.

SMAW welding of weld joint SEG3020AL-011 located on Side plate to Floor Beam (FL3) of OBG Segment 14W. ZPMC Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AL-019 located on Side plate to Floor Beam (FL3) of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AL-013 located on Side plate to Floor Beam (FL3) of OBG Segment 14W. ZPMC Welder is identified as 0651348. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AL-029 located on Side plate to Floor Beam (FL3) of OBG Segment 14W. ZPMC Welder is identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P2214-Tc-U4b-FCM-1.

FCAW welding of weld joint SEG3020BB-037 located on Sub Assembly to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 068445. 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 SEG3020BB-055 located on Sub Assembly to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 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 SEG3020M-048 located on Floor Beam to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 068421. 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-2233-ESAB.

FCAW welding of weld joint SEG3020M-058 located on Floor Beam to Bottom Plate of the OBG Segment 14W. ZPMC Welder is identified as 201215. 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-2233-ESAB.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Floor Beam Hinge Plate to Bottom Plate T joint of the OBG Segment 14E and the weld is identified as SEG3020D-052. More than 30% of weld

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length repair marked by ZPMC UT personnel. 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