

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-019498**Date Inspected:** 22-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.

Magnetic Particle Testing (MT) – NWIT Document No's: 008261

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. DP3117-001-183, 192, 195, 202, 205, 214, 215, 224, 226, 233, 236, 245, 246, 255, 258, 263
2. DP3117-001-112, 113, 122, 123, 130, 131, 174, 175, 186, 187, 196, 197, 206, 218, 219
3. DP3117-001-227, 228, 237, 238, 249, 250, 218, 219, 227, 228, 237, 238, 249, 250, 259, 260
4. DP3117-001-114, 115, 119, 120, 127, 128, 135, 176, 177, 184, 185, 193, 194, 203, 204, 208
5. DP3117-001-209, 216, 217, 225, 226, 234, 235, 240, 247, 248, 256, 257, 266, 267

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) repair welding of weld joint SEG3020BB-037 and 019 located on Vertical Shear Plate to Bottom Plate of OBG Segment 14W. ZPMC Welders are identified as 067949 and 066236. ZPMC Quality

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Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) – FCM – ESAB- Repair-1, which is used as per Critical Welding Repair (CWR) B-CWR-2752.

FCAW repair welding of weld joint SEG3020BB-010 located on Vertical Shear Plate to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) – FCM – ESAB- Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20164.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020Q-058 located on Longitudinal Diaphragm to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM- Repair-1, which is used as per Critical Welding Repair (CWR) B-CWR-2620.

SMAW repair welding of weld joint SEG3013P-058 located on K-Plate to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM- Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2719.

SMAW repair welding of weld joint SEG3013AH-024 and 025 located on Floor Beam to Edge Plate of OBG Segment 14W. ZPMC Welder is identified as 045221. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. 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 Welding Repair Report (WRR) B-WRR-20171.

SMAW repair welding of weld joint SEG3013D-235 and 237 located on Floor Beam to K-Plate of OBG Segment 14W. ZPMC Welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. 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-20172.

SMAW repair welding of weld joint SEG3013AH-041 and 044 located on Side Plate to Edge Plate of OBG Segment 14W. ZPMC Welder is identified as 066002. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. 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-20173.

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.

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Inspected By:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	Patel,Hiranch	QA Reviewer
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