

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-019503**Date Inspected:** 16-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: 008194

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. SEG3007D-002,003,004,005,007,008
2. SEG3007D-009,010,012,013,014,015

Ultrasonic Testing (UT) – NWIT Document No: 008186

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 13AE. The weld designations reviewed are as follows:

1. SEG3007K-034, 036
2. SEG3007F-032, 034

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3015K-189 located on Floor Beam to Vertical Plate of OBG Segment 13CW. ZPMC Welder is identified as 045204. 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-20152.

SMAW welding of weld joint SEG3015J-011 located on Floor Beam Flange to Deck Panel Diaphragm at panel point 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 037932. 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-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015L-011 located on Floor Beam Flange to Deck Panel Diaphragm at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 067993. 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-P-2212-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3015-001 located on Deck Panel to Deck Panel of the OBG Segment 13BW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1T-ESAB-1.

SMAW repair welding of weld joint SEG3015-089 and 101 located on Floor Beam to Side Plate I-Rib Stiffener of OBG Segment 13CW. ZPMC Welder is identified as 067829. 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-3G (3F) – FCM – Repair-1, 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.

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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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