

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019637**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), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu 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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT

BAY 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08190.

Magnetic Particle Testing (MT).

This QA inspector performed MT of approximately 15 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

RS3481-001-001, 002, 006.

RS3480-002-001.

SEG3013AX-175, 176, 181, 182.

SEG3013N-263, 264, 265, 269, 270, 271.

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SEG3013Q-182, 189.

SA3168-079 ~ 086.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 037932 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015J-011. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045204 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015K-189. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20152.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13CW. Weld joint is identified as SEG3015-001. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2231T-ESAB-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067993 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015L-011. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045227 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13CW. Weld joint is identified as SEG3015H-003. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067829 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015C-089, 101. ZPMC Quality Control (QC) Inspector identified as Li Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR18318.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

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 Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
