

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019652**Date Inspected:** 03-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: Mr. Liu Yang
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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 033 as per CWR no. B-CWR 2621, located on OBG Component, Longitudinal Diaphragm to Floor Beam SEG 3020R, Segment 14W, P.P 126. Welder is identified as 051348. ZPMC Quality Control (QC) Inspector is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW -3G (3F) - FCM-Repair.

Repair welding of Weld joint # 058 as per CWR no. B-CWR 2620, located on OBG Component, Longitudinal Diaphragm to Floor Beam SEG 3020R, Segment 14W, P.P 126. Welder is identified as 047864. ZPMC Quality Control (QC) Inspector is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW -3G (3F) - FCM-Repair.

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Repair welding of Weld joint # 007 as per CWR no. B-CWR 2562, located on OBG Component, Deck plate of Segment 13CW, DP 3149-001. Welder is identified as 067904. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Repair welding of Weld joint # 114 as per CWR no. B-CWR 2570, located on OBG Component, Deck plate of Segment 13CW, DP 3150-001. Welder is identified as 066459. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Weld joint # 020, located on OBG Component, Architectoral House AH3001 of of Segment 13AW, AH3001. Welder is identified as 037932. ZPMC Quality Control (QC) Inspector is identified as Shao Jia Yuan. The welding variables recorded by QC appeared to comply with the WPS – B-P-2214 –B –U3B.

Flux cored Arc welding (FCAW)

Weld joint # 073, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 055, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 066695. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification Nos. 08032, 08027, 08030

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG component, Lift 13 Deck panels. The weld designations reviewed are as follows:

SA3168-Jt. nos. -365, 366, 223, 224, 225, 226, 227, 228, 169 to 178, 197 to 206.

SEG3013Q - Jt. nos. -147, 152, 157

SEG3013B- Jt. nos. -024,030,036,042,193

SEG3013D- Jt. nos. -019,024,029,034,152,155, 020,025,030,035

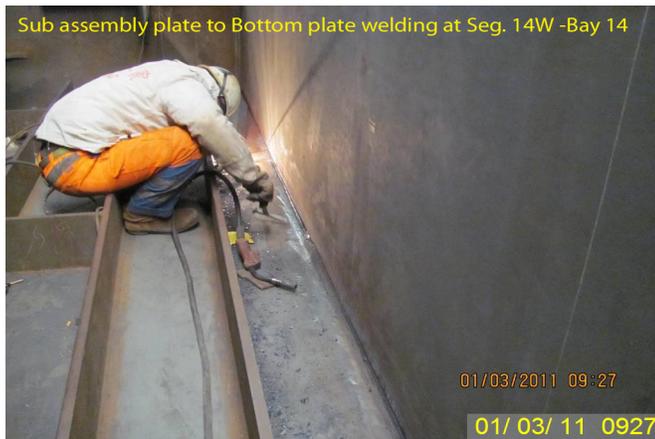
SEG3013E- Jt. nos - 171, 172.

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For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevent Conversations.

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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer