

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019653**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), 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)

Weld joint # 143, located on OBG Component, Side plate to Floor beam of Segment 14W, SEG 3020AY, P.P 128.

3. Welder is identified as 067611. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B-P-2213 –TC –U4B –FCM-1.

Weld joint # 263, located on OBG Component, Side plate to Floor beam of Segment 14W, SEG 3020AY, P.P 128.

3. Welder is identified as 037780. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B-P-2213 –TC –U4B –FCM-1.

Weld joint # 011, located on OBG Component, Side plate to FL3 of Segment 14W, SEG 3020AC. Welder is

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identified as 067942. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B-P-2214 –TC –U4B –FCM-1.

Weld joint # 019, located on OBG Component, Side plate to FL3 of Segment 14W, SEG 3020AC. Welder is identified as 045246. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B-P-2214 –TC –U4B –FCM-1.

Weld joint # 013/ 029, located on OBG Component, Side plate to FL3 of Segment 14W, SEG 3020AC. Welder is identified as 051348 / 066038. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B-P-2214 –TC –U4B –FCM-1.

Repair welding of Weld joint # 251 as per CWR no. B-CWR 2629, located on OBG Component, Deck plate of Segment 13AW, SA 7512C. 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.

Flux cored Arc welding (FCAW)

Weld joint # 048/ 058, located on OBG Component, FL2 to Bottom plate of of Segment 14W, SEG 3020M. Welder is identified as 066421 / 201215. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Lian. The welding variables recorded by QC appeared to comply with the WPS – B-T-2233 -Esab.

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.

Weld joint # 078, located on OBG Component, Floor Beam to Bottom plate of of Segment 14W, SEG 3020L, P.P 127. Welder is identified as 045276. ZPMC Quality Control (QC) Inspector is identified as Zhu lin. The welding variables recorded by QC appeared to comply with the WPS – B-T-2132 -Esab.

For further information see below pictures:-

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

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contract documents.



Summary of Conversations:

No relevant 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