

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019659**Date Inspected:** 11-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, LTD(ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Jiao**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**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

BAY # 14

Shielded Metal Arc Welding (SMAW) on weld joint SEG3007AT-095 located on bottom plate to stiffener in 13East in bay 14. The Welder is identified as 216086. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-R & repair report WR-19146.

Shielded Metal Arc Welding (SMAW) on weld joint SEG3000Y-422 located on S.A. to F.B. stiffener in 13East in bay 14. The Welder is identified as 066416. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on weld joint SEG3019AL-008 located on floor beam to side plate in 14East in bay 14. The Welder is identified as 037723. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on weld joint SEG3019AL-009 located on floor beam to side plate in 14East in bay 14. The Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on weld joint SEG3000AL-295 located on E.P. to S.P. in 14East in bay 14. The Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) on weld joint SEG3019L-1-077 located on floor beam to longitudinal diaphragm in 14East in bay 14. The Welder is identified as 066763. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-R-ESAB & repair report CWR-2643.

Flux Cored Arc Welding (FCAW) on weld joint SEG3019K-1-002 located on floor beam to longitudinal diaphragm in 14East in bay 14. The Welder is identified as 066763. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-R-ESAB & repair report CWR-2642. For details see image below

Shielded Metal Arc Welding (SMAW) on weld joint SEG3011E-429 located on V.P. I rib to V.P. I rib 13East in bay 14. The Welder is identified as 067571 ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. For details see image below

BAY # 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08139

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (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 MT report for this date. The member is identified as OBG 13AW. The welds designations reviewed are as follows

SA3168-031, 032, 033, 034

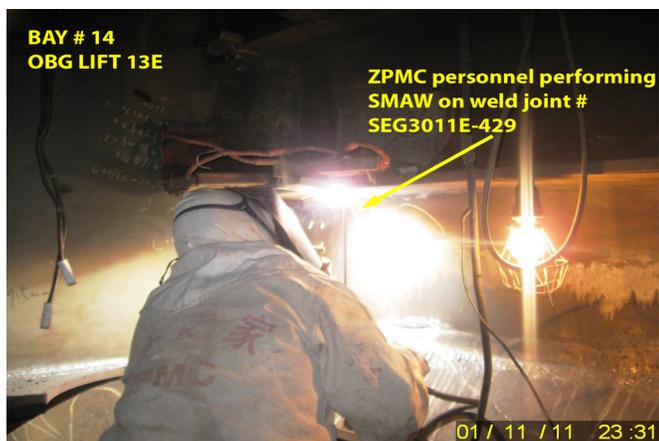
RS3481-003, 004, 005

SEG3013E-151, 152, 156, 157

SEG3013C-094, 087

RS3480-001, 002, 006

SA3168-001, 002, 003, 004, 005, 006, 008



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Ho (150002048250) , who represents the Office of Structural Materials for your project.

Inspected By:	Sharma,Robin	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
