

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-019921**Date Inspected:** 05-Feb-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. LI YAN HUA**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 (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Bay-14 Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the vertical shear plate to bottom plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-037. The welder is identified as 215553. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2737. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the vertical shear plate to bottom plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-059. The welder is identified as 044772. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

(2F)-FCM-Repair-1. The weld repair report number is named as CWR-2737.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the corner assembly to floor beam weld joint located on 13BE at Panel Point (PP-120.5). The weld is designated as SEG3009H-170. The welder is identified as 067138. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 256.8 Amps, Voltage 26.0 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the side plate to corner assembly weld joint located on 13BE in between Panel Point (PP-121 & PP-121.5). The weld is designated as SEG3009M-001. The welder is identified as 066041. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 292.5 Amps, Voltage 25.8 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2231-ESAB.

2. NDT:

Magnetic Particle Testing (MT):

MT carried out as per the ZPMC submitted Notification No 08314.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area that has been previously tested and accepted by ZPMC MT technicians. This QA Inspector generated a TL-6028 MT report on this date. The members are identified as joint between deck plate to deck panel diaphragm weld joint located on 13CE at bike path side. The weld designation numbers is as follows: DP3109-001-027~030, 032, 033, 026, 031, DP3108-001-043~046, 063~066, 083~086, 103~106, 125, 127, 129, 131 & 133.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
