

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020075**Date Inspected:** 27-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) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. Qui 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 Segment	

Summary of Items Observed:

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

Ultrasonic Testing (UT) – NWIT Document No: 008299

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. SEG3020AW-085
2. SEG3013*-003

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020BB-001 located on Vertical Shear Plate to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Welding Repair Report (WRR) B-WRR-20146.

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Flux Core Arc Welding (FCAW) repair welding of weld joint SEG3020BB-019 located on Vertical Shear Plate to Bottom Plate of OBG Segment 14W. ZPMC Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G (2F) – FCM – Repair-ESAB, which is used as per Critical Welding Repair Report (CWR) B-CWR-2750.

SMAW repair welding of weld joint SEG3020D-052 located on Floor Beam to Bottom Plate of OBG Segment 14W. ZPMC Welders are identified as 066398 and 066038. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2734.

SMAW welding of weld joint SEG3020K-023 located on Longitudinal Diaphragm to Sub Assembly of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2690.

SMAW welding of weld joint SEG3020M-186 located on Floor Beam to Edge Beam at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM.

SMAW welding of weld joint DP3148-001-247 located on Deck Panel of OBG Segment 13CW. ZPMC Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

FCAW welding of weld joint DP3171-001-022 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 069493. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint DP3171-001-189 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 066236. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM.

SMAW welding of weld joint DP3171-001-035 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 037779. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM.

FCAW welding of weld joint DP3171-001-428 located on Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 067520. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

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

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer