

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020127**Date Inspected:** 28-Dec-2010**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. AN QIANG XING
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 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 Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Fillet welds joining the I-Rib to deck plate hold back weld joint located on 12AW+12BW at counter weight side. The weld is designated as DP3049-001-031(12AW) & DP3060-001-007(12BW). The welder is identified as 044551. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-T-4114-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the deck plate to deck plate transverse splice weld joint located on 12AW+12BW at counter weight side. The weld is designated as CA3012-009. The welder is identified as 040656. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-1G

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(1F)-FCM-Repair-1. The weld repair report number is named as WR-17901.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Built-up weld for the side plate to side plate transverse splice weld joint located on 12AE+12BE at cross beam side. The weld is designated as OBE12D-002. The welder is identified as 044515. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-17903.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Built-up weld for the edge plate to deck plate hold back weld joint located on 12AE+12BE at cross beam side. The weld is designated as SEG3001AA-021(12AE). The welder is identified as 050289. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as WR-19618.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the deck plate to deck plate transverse splice weld joint located on 12AE+12BE. The weld is designated as OBE12-002. The welder is identified as 044515. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. The weld repair report number is named as WR-19643. Further weld detail mention in attached picture.

2. NDT:

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted Notification No 12282010-1.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between bottom plate to side plate hold back weld joint located on west side of 12AE at bike path side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: SEG3001A-016.

UT not done for the ABF submitted UT Report No UT-14W-001R1 due to A-face of the weld is not flush ground for D-Scan. The Notification is cancelled by ABF Quality Assurance & agree to perform D-scan from face-A for the weld. The weld is designated as DP3169-001-014, DP3170-001-017, DP3171-001-023, DP3172-001-392, DP3173-001-030, DP3174-001-392, DP3175-001-021, DP3176-001-017 & DP3177-001-013.

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

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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
