

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020142**Date Inspected:** 20-Dec-2010**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:** Mr. Li Ping (ZPMC)**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:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 07862. The member(s) is/are identified as Longitudinal Diaphragm Plate to Deck Plate. The weld designations reviewed are as follows:

DP3089-001-018, 021, 024, 027, and 030

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OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Deck Plate to Floor Beam Diaphragm identified as DP3105-001 weld number(s) 128 and 120. Welder is identified as welder no. 054013. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on Deck Plate to Floor Beam Diaphragm identified as DP3106-001 weld number(s) 115, 120, and 128. Welder is identified as welder no. 070007. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on 14W Segment 3020AZ Side Panel to Floor Beam weld number(s) 001. Welder is identified as welder no. 045175. The welding variables recorded by ZPMC QC identified as Liu Feng appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on 14W Segment 3020AY Side Panel to BottomPanel weld number(s) 014, 015, and 016. Welder is identified as welder no. 202122. The welding variables recorded by ZPMC QC identified as Liu Feng appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on 14W Segment 3020D Side Panel to Floor Beam weld number(s) 035 and 032. Welder is identified as welder no. 202122. The welding variables recorded by ZPMC QC identified as Liu Feng appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on 14W Segment 3020E Side Panel to Floor Beam weld number(s) 053 and 040. Welder is identified as welder no. 202122. The welding variables recorded by ZPMC QC identified as Liu Feng appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

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

Summary of Conversations:

As mentioned above between QA and QC concerning this project

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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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer