

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020292**Date Inspected:** 13-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Geng Wei**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

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on 13AW Segment 3013E Rib Stiffener to Bottom Panel weld number(s) 151 and 156. Welder is identified as welder no. 045280. The welding variables recorded by ZPMC QC identified as SunTian Liang appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on 13AW Segment 3013N Rib Stiffener to Floor Beam weld number(s) 196, 201, 206, and 211. Welder is identified as welder no. 066439. The welding variables recorded by ZPMC QC identified as SunTian Liang appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

SMAW welding of complete joint penetration weld joint(s) located on 13AW Segment 3013G FL2 / FL3 weld number(s) 018. Welder is identified as welder no. 07780. The welding variables recorded by ZPMC QC identified as SunTian Liang appeared to comply with applicable WPS(s) WPS-B-P-2211-B-Ua-FCM.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3105-001 weld number(s) 050. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 066746. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18697

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3105-001 weld number(s) 042. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 066746. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18696

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3105-001 weld number(s) 035. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 066746. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18695

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3106-001 weld number(s) 058. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 066746. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18705

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3105-001 weld number(s) 050. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 066746. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18706

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3106-001 weld number(s) 068. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate to Deck Plate identified as noted above. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-FCAW-2G-(2F)-Repair-FCM and WR-18718

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

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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
