

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-020585**Date Inspected:** 08-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. 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: 008318

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 13AW. The weld designations reviewed are as follows:

1. SEG3013S-212
2. SEG3013Q-114
3. SEG3013Q-115
4. SEG3013N-237, 243, 244.

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3014C-009 located on Deck Panel Diaphragm to Floor Beam at panel point 122 of OBG Segment 13BW. ZPMC Welders are identified as 045227 and 067888. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to

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comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3015L-010 located on Deck Panel Diaphragm to Floor Beam at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014J-002 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014C-002 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

ZPMC personnel performed ultrasonic inspection on vertical shear plate to bottom plate T joint weld of OBG Segment 14W. The weld numbers are identified as SEG3020BB-001 and 010.

SMAW welding of weld joint DP3173-001-019 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 067904. 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-1.

SMAW welding of weld joint DP3174-001-250 located on Deck Panel to Deck Panel Diaphragm 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-1.

SMAW welding of weld joint DP3174-001-021 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 067707. 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-1.

SMAW welding of weld joint DP3172-001-250 and 211 located on Deck Panel to Deck Panel Diaphragm 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-1. See the attached pictures.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3095-001-021 and 022 located on Bottom Plate of OBG Segment 14E. ZPMC Welder is identified as 068858. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

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See the attached picture.

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



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
