

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-020612**Date Inspected:** 05-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
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:** 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. 07636. The member(s) is/are identified as Floor Plate Stiffeners to Floor Beams. The weld designations reviewed are as follows:

SEG3015D-200, 182, 176, 170, 110, 104, 092, 086, and 080

SEG3015K -116, 110, 104, and 064

SEG3015L-047

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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. 07637. The member(s) is/are identified as Vertical Plate Stiffeners and plate to plate splices. The weld designations reviewed are as follows:

SEG3014S-090

3020AY-017-019, 004, 006, 009, 012

VP3008-001-013, 010, 045, 048, 023, 020, 017, 024, 047, 044

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Segment 3019A-019 Bottom Panel to Side Panel weld number(s) 025. Welder is identified as welder no. 044824. The welding variables recorded by ZPMC QC identified as Lu Li Qing appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on Segment 3019* Deck Plate to Deck Plate identified as DP167A to DP3160A weld number(s) 005. Welder is identified as welder no. 062782. The welding variables recorded by ZPMC QC identified as Shao Jian Yuan appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3102-001 weld number(s) 254 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected 19 areas within weld no. 254.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate and Deck Plate identified as noted above. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3102-001 weld number(s) 248 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected 16 areas within weld no. 248.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate and Deck Plate identified as noted above. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

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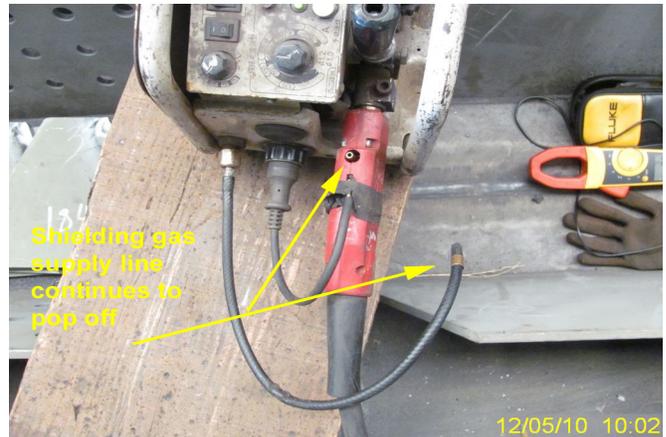
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During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3102-001 weld number(s) 251 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected 6 areas within weld no. 251.

FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate and Deck Plate identified as noted above. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3102-001 weld number(s) 251 this QA Inspector observed damaged shielding gas supply line During observation the supply line continued to disengage from the inlet port. This QA informed ZPMC Quality Control (QC) identified as Mr. Zong Guo Hui of this issue. Mr. Hui informed this QA that the in-process variables would be corrected in a manner compliant with the contract documents.

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



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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