

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-020614**Date Inspected:** 07-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

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07671. The member(s) is/are identified as Floor Beam. The weld designations reviewed are as follows:

FB3286-001-411,412,414,115,116,119,120,129,130,133,134

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Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07676. The member(s) is/are identified as Floor Beam to Bottom Panel. The weld designations reviewed are as follows:

BP3067-001-05, 06, 07, 08

BP3060-001-30, 31, 32, 33

BP3058-001-25, 26, 27, 28

BP3059-001-33, 34, 35, 36

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Lift 14E Segment 3019, DP3162A, DP3163A, and DP3164A weld joint(s) 008 and 009. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Geng Wei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-9831 dated 11-11-2010.

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.

During random in process inspection of Orthotropic Box Girder (OBG) member identified as DP3078-001 weld number(s) 028 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected (1) area within weld no. 028.

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. 052696. 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 DP3078-001 weld number(s) 241 this QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected (1) area within weld no. 241.

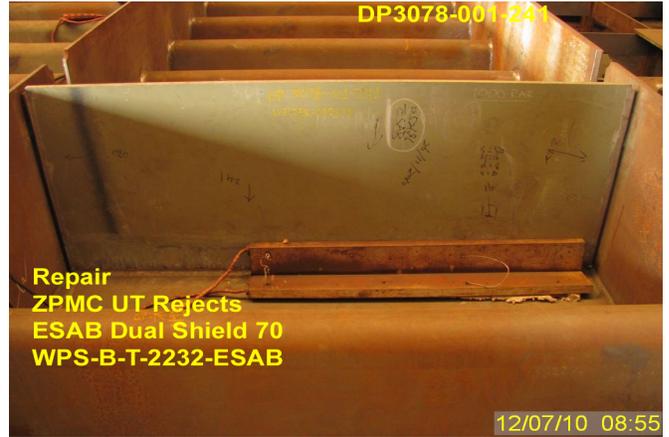
FCAW welding of complete joint penetration weld joint(s) located on Diaphragm Plate and Deck Plate identified

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as noted above. Welder is identified as welder no. 052696. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-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

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
