

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021003**Date Inspected:** 17-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.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020U-588 located on Bottom Plate to Anchor at panel point 126 of OBG Segment 14W. ZPMC Welders are identified as 067707, 067904 and 067588. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM.

SMAW repair welding of weld joint SEG3019Z-011 located on Bottom Plate to Longitudinal Diaphragm at panel point 126.5 of OBG Segment 14E. ZPMC Welder is identified as 066418. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2755.

SMAW repair welding of weld joint SEG3019AA-025 located on Bottom Plate to Longitudinal Diaphragm at panel point 127 of OBG Segment 14E. ZPMC Welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2755.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW repair welding of weld joint SEG3019Z-097 located on Bottom Plate to Longitudinal Diaphragm at panel point 126.5 of OBG Segment 14E. ZPMC Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2614.

SMAW welding of weld joint SEG3019Z-007 and 008 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 to 127 of OBG Segment 14E. ZPMC Welders are identified as 037932 and 068097. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joint SEG3019X-004, 005, 006 and 007 located on Anchor Plate to Longitudinal Diaphragm at panel point 125 to 126 of OBG Segment 14E. ZPMC Welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM.

SMAW welding of weld joint SEG3019L-337 and 338 located on Anchor Plate to Floor Beam at panel point 127 of OBG Segment 14E. ZPMC Welder is identified as 068917. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3019S-344 and 345 located on Floor Beam to Edge Beam at panel point 125.5 of OBG Segment 14E. ZPMC Welder is identified as 066763. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3019L-300 and 302 located on Floor Beam to Side Plate Stiffener at panel point 127 of OBG Segment 14E. ZPMC Welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3019M-171, 172, 165 and 166 located on Floor Beam to Bottom Plate i-Stiffener at panel point 126.5 of OBG Segment 14E. ZPMC Welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr. Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

This QA inspector observed ZPMC personnel performed Magnetic Particle Testing on OBG segment 13AE Deck Panel DP3075A to Deck Panel DP3076A splice weld after root pass. The weld number is identified as SEG3007-004.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on OBG Segment 13AW Side Plate to Key Plate 'T' joint. The weld number is identified as SEG3013AH-041. See the attached picture.

SMAW welding of weld joint SEG3007-004 located on deck panel DP3075A to deck panel DP3076A splice of

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

OBG Segment 13AE. ZPMC Welders are identified as 037723, 067183, 068924 and 037988. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-Tc-U4b-FCM.

Sub Merged Arc (SAW) welding of weld joint SEG3007-004 located on deck panel DP3075A to deck panel DP3076A splice of OBG Segment 13AE. ZPMC Welder is identified as 047771. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

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