

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-021385**Date Inspected:** 25-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), Changxing Island **Location:** Shanghai China**CWI Name:** 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:** OBG Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -13AE

In process Inspection

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process in the (2G) position on a weld joint identified as SEG3011G-008 .OBG 13CE Segment . The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process in (2G) Position on a weld joint identified as SEG3007B-133 .OBG 13AE Segment . The welder is identified as 066912. ZPMC Quality Control (QC) is identified as Mr. Lu Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB

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SHIELDED METAL ARC WELDING (SMAW).

This QA Inspector observed the welding operation per the (SMAW) process in the (3G)Vertical position on a weld joint identified as SEG3009S-077. The welder is identified as 067904. The ZPMC Quality Control (QC) is identified as Mr. Lu Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-Repair-1

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE. The welds designations reviewed are as follows: SEG3007P-049,050,053,054,083

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE. The welds designations reviewed are as follows: SEG3007Q-102,103,108,109,085

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 13AE. The welds designations reviewed are as follows: SEG3007P-218~220,225~227,231~236,238,241~243,246~248,251~253,256~258 ,261~263

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment 12AE. The welds designations reviewed are as follows: SEG3007Q-151~156,159~161,168~170,176~177,129~131,134~136,139~141,144~146,149~151.

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant conversations were reported on this date.

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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