

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-021616**Date Inspected:** 07-Mar-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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08476

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

SADDLE SUPPORT BEAM

SEG3066-001-001~018

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint #193 located on 14E, SEG3019P as per the weld repair report# B-WR20247. Welder is identified as 050232. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding

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variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-REPAIR-1.

Weld joint #100 located on 14E, SEG3019AW. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1.

Weld joint #046 located on 14E, SEG3019L. Welder is identified as 070008. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

Weld joint #100 located on 14E, SEG3019AW. Welder is identified as 066418. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW):

Weld joint #039 located on 13AE, SEG3007N. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #207 located on 13AE, SEG3007E. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #008 located on 13AE, SEG3007J. Welder is identified as 20009. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #040 located on 13AE, SEG3007N. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #051 located on 13AE, SEG3007G. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #208 located on 13AE, SEG3007E. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Visual Inspection Testing (VT) on Saddle Support Beam

This QA inspector performed random VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

SADDLE SUPPORT BEAM

WELDING INSPECTION REPORT

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SEG3067-001-019~022; 024~027

(See attached photo)

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



Summary of Conversations:

No Relevant Conversations.

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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
