

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-021746**Date Inspected:** 13-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sha Zhi**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.

Ultrasonic Testing (UT) – NWIT Document No: 008533

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. SEG3020BB-111, 115

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020U-587 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2854.

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SMAW welding of weld joint SEG3020V-048 located on Floor Beam to Longitudinal Diaphragm at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020L-178 located on Floor Beam I-stiffener at panel point 127 bike path side of OBG Segment 14W. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020K-303, 304, 307 and 308 located on Bottom Plate Stiffener to Floor Beam at panel point 127 to 127.3 of OBG Segment 14W. ZPMC Welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020L-083, 084 087, 088, 091 and 092 located on Bottom Plate Stiffener to Floor Beam at panel point 127.3 to 127.5 of OBG Segment 14W. ZPMC Welder is identified as 204730. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. 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 (MT) on Floor Beam to Floor Beam Flange at panel point 125 of OBG Segment 14W. The weld number is identified as SEG3020W-022 and 023. See the attached pictures.

SMAW welding of weld joint DP3120-001-012 located on Deck Panel to Longitudinal Diaphragm of OBG Segment 13AW. ZPMC Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3120-001-030 and 242 located on Deck Panel to Longitudinal Diaphragm of OBG Segment 13AW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013AH-110 located on Deck Panel to Edge Plate of OBG Segment 13AW. ZPMC Welder is identified as 066443. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3019AW- 105 located on Side Plate to Side Plate at panel point 126 to 127 of OBG Segment 14E. ZPMC Welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

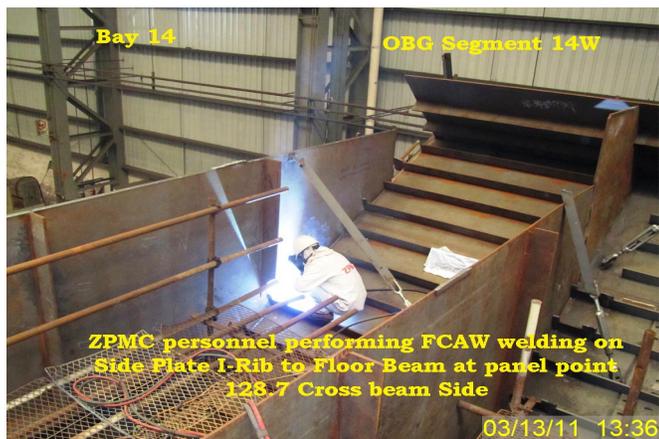
SMAW welding of weld joint SEG3019AW-100 located on Side Plate to Side Plate at panel point 125 to 126 of

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OBG Segment 14E. ZPMC Welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

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
Reviewed By: Patel,Hiranch

Quality Assurance Inspector
QA Reviewer
