

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021908**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), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 perform repair welding by Shielded Metal Arc Welding (SMAW), on Bottom plate to longitudinal diaphragm weld of OBG Segment 14E. Weld joint is identified as SEG3019Z-097. ZPMC Quality Control (QC) Inspector identified as Xie Ming Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 037932 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to longitudinal diaphragm weld of OBG Segment 14E. Weld joint is identified as SEG3019Z-007. ZPMC Quality Control (QC) Inspector identified as Zhong Guo Hui was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 066179 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to longitudinal diaphragm weld of OBG Segment 14E. Weld joint

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is identified as SEG3019X-004, 005. ZPMC Quality Control (QC) Inspector identified as Zhong Guo Hui was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 068917 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to floor beam weld of OBG Segment 14E. Weld joint is identified as SEG3019L-337. ZPMC Quality Control (QC) Inspector identified as Zhong Guo Hui was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 215553 perform repair welding by Shielded Metal Arc Welding (SMAW), on Bottom plate to longitudinal diaphragm weld of OBG Segment 14E. Weld joint is identified as SEG3019AA-025. ZPMC Quality Control (QC) Inspector identified as Xie Ming Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2755.

This QA Inspector observed ZPMC qualified welding personnel identified as 066418 perform repair welding by Shielded Metal Arc Welding (SMAW), on Bottom plate to longitudinal diaphragm weld of OBG Segment 14E. Weld joint is identified as SEG3019Z-011. ZPMC Quality Control (QC) Inspector identified as Xie Ming Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2755.

This QA Inspector observed ZPMC qualified welding personnel identified as 066236 perform welding by Flux Cored Arc Welding (FCAW), on Bottom plate stiffener to floor beam weld of OBG Segment 14E. Weld joint is identified as SEG3019M-171, 172. ZPMC Quality Control (QC) Inspector identified as Zhong Guo Hui was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC qualified NDT personnel perform Magnetic Particle Testing on OBG Segment 13AE, deck panel DP3075A to deck panel DP3076A splice weld after root pass. Weld joint is identified as SEG3007-004. See attached picture.

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

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Summary of Conversations:

No significant 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
