

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-022594**Date Inspected:** 16-Apr-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. Liu Hua Jie**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.

Magnetic Particle Testing (MT) – NWIT Document No's: 008838

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13B/CW. The weld designations reviewed are as follows:

1. DP3102-001- 031, 032, 073, 074, 115, 116, 157, 158, 199, 200
2. DP3089-001- 031, 032, 073, 074, 115, 116, 157, 158, 199, 200
3. DP3088-001- 011, 012, 013, 014, 015, 051, 052, 053, 054, 055
4. DP3088-001- 091, 092, 093, 094, 095, 131, 132, 133, 134, 135
5. DP3101-001- 011, 012, 013, 014, 015, 051, 052, 053, 054, 055, 091, 092, 093
6. DP3101-001-094, 095, 131, 132, 133, 134, 135, 171, 172, 173, 174, 175

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW13A-016 located on Deck panel to Deck Panel

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of OBG Segment 13BW to OBG Segment 13CW. ZPMC Welders are identified as 067588 and 067609. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20634.

SMAW welding of weld joint SP3115-001-010 and 016 located on OBG Segment 13CW. ZPMC Welder is identified as 066019. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20718.

SMAW welding of weld joint AH3003-038 and 011 located on Architecture House of OBG Segment 13BW. ZPMC Welders are identified as 045213 and 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20718.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) 'D' Scanning on Side Plate to Corner Assembly of OBG Segment 13CW. The weld number is identified as CA3015A-005. See the attached picture.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on Deck Panel Diaphragm to Longitudinal Diaphragm of OBG Segment 13CW. The weld number is identified as DP3146-001-246. See the attached picture.

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Bottom Plate and Side Plate RS stiffener to Floor Beam at panel point 122 cross beam side of OBG Segment 13BW.

Bay 14

This QA Inspector observed the following work in progress:

SMAW welding of weld joint SEG3020AQ-025 located on Side Plate to Anchor Plate at panel point 125 to 127 of OBG Segment 14W. ZPMC Welders are identified as 066361 and 045246. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G-(1F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2923.

SMAW welding of weld joint SEG3020M-009 located on Deck Panel Diaphragm to Floor Beam Flange at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 067580. 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-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020F-014 located on Deck panel diaphragm to Deck Panel Diaphragm at panel point 128 of OBG Segment 14W. ZPMC Welder is identified as 067275. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the

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Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3020H-010 located on Deck panel diaphragm to Deck panel diaphragm at panel point 127.5 of OBG Segment 14W. ZPMC Welder is identified as 066881. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

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
