

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-022605**Date Inspected:** 03-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. An Qing Xing**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: 008719

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 13CW. The weld designations reviewed are as follows:

1. SEG3015G-061, 066, 071, 076, 081, 086, 091, 096
2. SEG3015G-101, 106, 111, 116, 121, 126, 131, 136, 141
3. SEG3015G-063, 068, 073, 078, 083, 088, 093, 098
4. SEG3015J-061, 065, 069, 073, 077, 081, 085, 089
5. SEG3015J-093, 097, 101, 105, 109, 113, 117, 121, 125

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020AQ-025 located on Anchor Plate to Side Plate at panel point 125 to 127 of OBG Segment 14W. ZPMC Welders are identified as 066443, 070432 and

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066002. 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-2211-Tc-U5b-FCM.

SMAW welding of weld joint SEG3020BB-056 and 038 located on Vertical Shear Plate to Anchor Plate of OBG Segment 14W. ZPMC Welders are identified as 037932 and 067765. 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.

SMAW welding of weld joint SEG3020BB-074 located on Vertical Shear Plate to Anchor Plate of OBG Segment 14W. ZPMC Welders are identified as 069841 and 066261. 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.

SMAW welding of weld joint SEG3020BB-020 located on Vertical Shear Plate to Anchor Plate of OBG Segment 14W. ZPMC Welder is identified as 045246. 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.

SMAW welding of weld joint SEG3020D-018 located on SA to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 069896. 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-2114-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AV-011 located on SA3416 to Floor Beam at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066695. 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-2231-ESAB.

SMAW welding of weld joint SA3231D-038 located on Deck Panel Diaphragm to Deck Panel Diaphragm of OBG Segment 13BW. ZPMC Welder is identified as 067588. 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-2213-B-U2-FCM-1.

Sub Merge Arc Welding (SAW) welding of weld joint SEG3014-001 located on Deck Panel to Deck Panel of OBG Segment 13BW. ZPMC Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1T-ESAB.

SMAW repair welding of weld joint SEG3014M-001 located on Corner Assembly to Side Plate of OBG Segment 13BW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2914.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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