

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-022617**Date Inspected:** 20-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.

Magnetic Particle Testing (MT) – NWIT Document No's: 008584

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. The weld designations reviewed are as follows:

1. SA3174-001-001, 003

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SA3449-001-021 located on Vertical Shear Plate to Anchor Plate at panel point 125 to 126 of OBG Segment 14W. ZPMC Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SA3448-001-012 located on Vertical Shear Plate to Anchor Plate at panel point 125

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to 126 of OBG Segment 14W. ZPMC Welder is identified as 051348. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3020AJ-284 and 286 located on Bottom Plate I-Stiffener at panel point 127 to 127.5 of OBG Segment 14W. ZPMC Welders are identified as 037779, 067707 and 066398. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AQ-002 and 006 located on RS-Stiffener to Anchor Plate at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3020AP-004 and 008 located on RS-Stiffener to Floor Beam at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020B-054 located on Side plate to Floor Beam at panel point 128.7 of OBG Segment 14W. ZPMC Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020AI-116 and 117 located on Side plate I-rib to Floor Beam at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SA3232B-004 located on Deck Panel Diaphragm to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welders are identified as 203871 and 048696. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3232A-003 located on Deck Panel Diaphragm to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 048433. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint SEG3015E-130 located on Side Plate I-rib to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 066061. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. 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 SEG3014E-008 and 012 located on Deck Panel Diaphragm to Deck Panel

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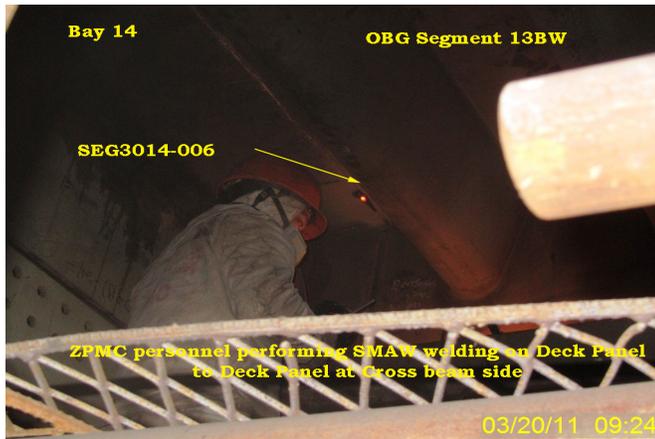
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Diaphragm at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (MT) on Sub Assembly Stiffener of OBG Segment 13BW. The Sub Assembly is identified as SA3231.

SMAW welding of weld joint SEG3014-006 located on Deck Panel to Deck Panel of OBG Segment 13BW. ZPMC Welder is identified as 067764. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1. See the attached pictures.

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
