

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-022797**Date Inspected:** 18-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. She Lei**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) - Document No's: 008855

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 Steel barriers. The weld designations reviewed are as follows:

1. E2-SB26A-002-063, 065, 067, 069, 071, 073, 077, 075, 082
2. E2-SB26A-002-086, 079, 084, 126, 127, 128, 129, 130, 131
3. E2-SB25D-002-063, 065, 067, 069, 071, 073, 077, 075, 082
4. E2-SB25D-002-086, 079, 084, 126, 127, 128, 129, 130, 131
5. E2-SB25B-001-063, 065, 067, 069, 071, 073, 077, 075, 082
6. E2-SB25B-001-086, 079, 084, 126, 127, 128, 129, 130, 131
7. E2-SB25B-002-063, 065, 067, 069, 071, 073, 077, 075, 082
8. E2-SB25B-002-086, 079, 084, 126, 127, 128, 129, 130, 131
9. E2-SB24-002-063, 065, 067, 069, 071, 073, 077, 075, 082
10. E2-SB24-002-086, 079, 084, 126, 127, 128, 129, 130, 131
11. E2-SB23-003-063, 065, 067, 069, 071, 073, 077, 075, 082
12. E2-SB23-003-086, 079, 084, 126, 127, 128, 129, 130, 131

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13. W5-SB31-006-063, 065, 067, 069, 071, 073, 077, 075, 082

14. W5-SB31-006-086, 079, 084, 126, 127, 128, 129, 130, 131

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This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The issued green tagging number is identified as 15534 and steel barriers are identified as following as.

1. E2-SB26A-002
2. E2-SB25D-002
3. E2-SB25B-001
4. E2-SB25B-002
5. E2-SB24-002
6. E2-SB23-003
7. W5-SB31-006
8. E2-SB25-001
9. W5-SB31-004

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint AH3002-026 located on Architecture House of OBG Segment 13BW. ZPMC Welders are identified as 067609. ZPMC Quality Control (QC) is identified as Mr. She Lei. 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 SP3115-001-010, 014 and 016 located on Side Plate I-Rib stiffener of OBG Segment 13BW. ZPMC Welder is identified as 20718. ZPMC Quality Control (QC) is identified as Mr. She Lei. 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-20719.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) 'D' Scanning repair area on Side Plate to Corner Assembly of OBG Segment 13CW. The weld number is identified as CA3016A-005. See the attached picture.

This QA inspector observed ABF personnel performed Magnetic particle Testing (MT) on Side Plate to Side Plate joint after back gouging of OBG Segment 13BW. The weld number is identified as AH3002-026.

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 123 cross beam side of OBG Segment 13CW.

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SB027-110-001 located on OBG Suspender Bracket SB110E. ZPMC Welder is identified as 062814. ZPMC Quality Control (QC) is identified as Mr. Li Ping. 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-2929.

SMAW repair welding of weld joint SB027-110-026, 055 and 035 located on OBG Suspender Bracket SB110E. ZPMC Welder is identified as 062814. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWRR) B-CWR-2929.

SMAW repair welding of weld buttering/build up on SB23-106-X64B of OBG Suspender Bracket SB106E. ZPMC Welder is identified as 202338. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2877. 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

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Reviewed By: Patel,Hiranch

QA Reviewer