

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-022798**Date Inspected:** 17-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.

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015K-224 located on Side Plate RS Stiffener to Floor Beam at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. 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-20641.

SMAW welding of weld joint SEG3015H-217 located on Side Plate RS Stiffener to Floor Beam at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. 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-20641.

SMAW welding of weld joint SP3113-001-078 located on Side Plate of OBG Segment 13CW. ZPMC Welder is identified as 066019. 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-1G-(1F)-FCM-Repair, which is used as per

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Welding Repair Report (WRR) B-WRR-20719.

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-2212-B-U2-FCM-1.

SMAW welding of weld joint SEG3007AH-030 located on Deck Panel I-Rib stiffener of OBG Segment 13AE. ZPMC Welder is identified as 066416. 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-20583.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3007P-103 and 168 located on Floor Beam I-Rib to Edge Plate at panel point 118 of OBG Segment 13AE. ZPMC Welder is identified as 050242. 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.

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 122.5 cross beam side of OBG Segment 13CW.

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 SEG3020BB-011 located on Anchor Plate to Vertical Shear Plate at panel point 125 to 127 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-345-SMAW-1G-(1F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20713.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020S-054 located on Deck panel diaphragm to Deck Panel Diaphragm at panel point 125.5 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.

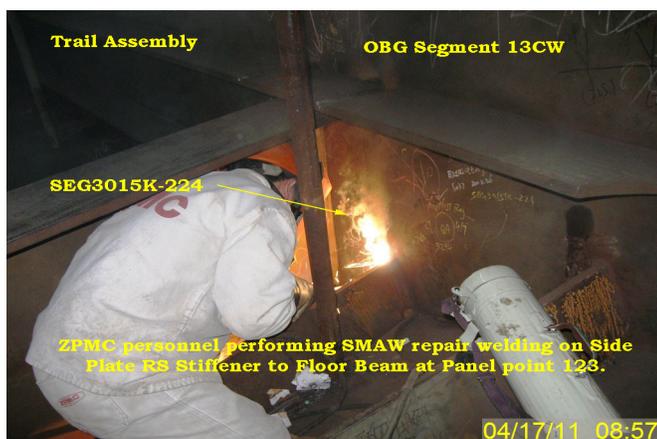
FCAW welding of weld joint SEG3020T-318 located on Deck panel diaphragm to Deck panel diaphragm at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 067275. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

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FCAW welding of weld joint SEG3020N-013 located on Deck panel diaphragm to Deck panel diaphragm at panel point 126.5 of OBG Segment 14W. ZPMC Welder is identified as 066239. 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
