

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022992**Date Inspected:** 24-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yang ZPMC**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:** TA Yard OBG 12/13E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

TRIAL ASSEMBLY

13CE

Ultrasonic Testing (UT)

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. All components were as listed on NWIT notification no. 08901. The member(s) is/are identified as Bottom Plate I-Ribs to Floor Beam. The weld designations reviewed are as follows

SEG3011D-079, 083, 087, 095, 099, 111, 115, 131, 135

13AE

Ultrasonic Testing (UT)

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. All components were as listed on NWIT notification no. 08917. The member(s) is/are identified as Deck Plate I-Rib to Edge Plate. The weld designations reviewed are as follows

SEG3007AA-082

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed the following work in progress:

SMAW welding of fillet weld joint(s) located on lift 13AE, SEG3007K I-Ribs to Floor Beam Holdback's weld number(s) 053, 064 and 058. Welder is identified as welder no. 044760. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-P-2112-FCM-1.

SMAW welding of complete joint penetration weld joint(s) located on lift 13AW, SEG3013E I-Ribs to Floor Beam weld number(s) 080. Welder is identified as welder no. 066019. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20604

SMAW welding of complete joint penetration weld joint(s) located on lift 13AW, SEG3013E I-Ribs to Floor Beam weld number(s) 080. Welder is identified as welder no. 048433. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20604

SMAW welding of complete joint penetration weld joint(s) located on lift 13BE, SEG3009C Side Plate I-Rib to Floor Beam weld number(s) 297 and 292. Welder is identified as welder no. 051359. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20749

FCAW welding of complete joint penetration weld joint(s) located on lift 13AE, SP3077-001 Flange Plate to Stiffener Plate weld number(s) 097, 098, 099, 100. Welder is identified as welder no. 044795. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-FCAW-2G (2F)-ESAB-Repair and WR-20797.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mentioned above 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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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