

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-023186**Date Inspected:** 29-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. Sun Tian Liang**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: 008982

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 13BW. The weld designations reviewed are as follows:

1. SEG3014E-010
2. SEG3014G-010

OBG Trail Assembly

This QA Inspector observed the following work in progress:

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Deck Panel Diaphragm to Floor Beam Flange Weld at Panel point 121 and 120.5 CB Side of OBG Segment 13BW. The weld number is identified as SEG3014J-010 and SEG3014G-010.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) on Architecture House of OBG

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Segment 13BW and OBG Segment 13CW. The weld number is identified as AH3003-001.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on Architecture House RS Stiffener of OBG Segment 13BW. See the attached pictures.

SMAW welding of temporary attachment areas located on bottom plate of OBG Segment 14W. ZPMC Welder is identified as 066361. 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-4G-(4F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20850.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020AE-096, 089 and 078 located on Edge plate RS stiffener of OBG Segment 14W. ZPMC Welder is identified as 067949. 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 SEG3020AF-017, 024 and 037 located on Edge plate RS stiffener 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-2233-ESAB.

FCAW welding of weld joint SEG3020AH-004 located on edge plate to side plate at panel point 127 to 128 of OBG Segment 14W. ZPMC Welders are identified as 066421 and 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-2232-ESAB.

SMAW welding of weld joint SEG3020AH-002 located on edge plate to side plate at panel point 125 to 127 of OBG Segment 14W. ZPMC Welder is identified as 037938. 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-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AV-007 located on SA to SA at panel point 128.3 to 128.7 of OBG Segment 14W. ZPMC Welder is identified as 037748. 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.

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