

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-023190**Date Inspected:** 24-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.

Ultrasonic Testing (UT) – NWIT Document No: 008911

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. But NWIT was cancelled due to visual testing (VT) problems on offered weld joints such as arc strike, Slag, undercut, under-fill etc. Regarding VT issues, this QA informed to ZPMC QC Mr. Sun Tian Liang. See the attached picture for more information.

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014B-145 located on Floor Beam to Vertical Plate at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 045213. 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-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3014H-159 located on Floor Beam to Vertical Plate at panel point 120.5 of OBG Segment 13BW. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr.

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Sun Tian Liang. 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 OBW13K-001, 004 and 007 located on Corner Assembly RS stiffener to Corner Assembly RS Stiffener of OBG Segment 13B+CW. ZPMC Welder is identified as 066422. 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-2213-B-U2-FCM-1.

SMAW welding of weld joint AH3001-001-027 located on Architecture Housing of OBG Segment 13AW. ZPMC Welder is identified as 047864. 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-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3133-001-020 located on Deck panel diaphragm to Longitudinal Diaphragm Plate at panel point 120.5 of OBG Segment 13BW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2932.

This QA inspector observed ZPMC personnel performed Magnetic particle Testing (MT) on Deck Panel Diaphragm to Floor Beam Flange Weld at Panel point 124.5 and Panel point 124 CB Side of OBG Segment 13CW. The weld numbers are identified as SEG3015C-010 and SEG3015E-010.

Bay 14

This QA Inspector observed the following work in progress:

Sub Merge Arc Welding (SAW) welding of weld joint SEG3020*-002 located on Deck Panel to Deck Panel of OBG Segment 14W. ZPMC Welder is identified as 045270. 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-223(2)1T-ESAB-1.

SMAW welding of weld joint SEG3020C-029 located on Floor Beam to Sub Assembly (SA) at Plate at panel point 128.7 of OBG Segment 14W. ZPMC Welders are identified as 066361 and 067764. 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.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020E-002 located on Deck panel diaphragm to Deck panel diaphragm at panel point 128.3 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 SEG3020M-009 located on Deck panel diaphragm to Floor Beam Flange at panel point 127 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

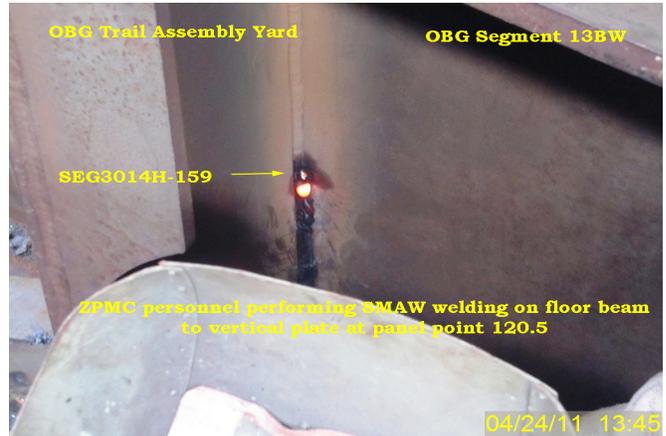
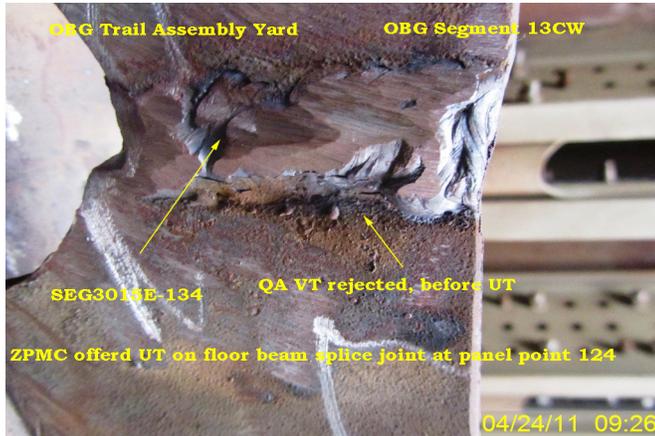
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WPS-B-T-2232-ESAB.

FCAW) welding of weld joint SEG3020K-004 located on Deck panel diaphragm to Floor Beam Flange at panel point 127.3 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-2232-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
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Reviewed By:	Patel,Hiranch	QA Reviewer
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