

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-023198**Date Inspected:** 23-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), Changxing Island **Location:** Shanghai,China**CWI Name:** Liu Hua Jie**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

OBG Trial Assembly

This QA inspector performed Magnetic Particle Testing (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 member is identified as OBG Segment 13BE&CE Floor Beam and Longitudinal Diaphragm Stiffeners. The weld designation reviewed is as follows:

LD3030-001-83,84,87,116,117,120,121,149,150,153,154,182,183,186,187,215,216

SEG3011N-149,150,,153,154,157,158,161,162,165,166,169,170,173,174,177,178,181

FB3158-001-04, 05,10,11,16,17

FB3158A-001-17,18,23,24,29,30,35,36,41,42,47,48

In process Inspection:-

OBG Trial Assembly

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## WELDING INSPECTION REPORT

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This QA inspector observed the following work in progress:

SMAW welding of weld joint No: VP3007-001-018 located on OBG Segment 13CE Vertical plate stiffener.

Welder is identified as #066656. ZPMC QC is identified as Mr. Wang Xu. Welding was performed with the weld repair report BWR-20767. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: VP3007-001-079 located on OBG Segment 13CE Vertical plate stiffener.

Welder is identified as #066258. ZPMC QC is identified as Mr. Wang Xu. Welding was performed with the weld repair report BWR-20768. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 13CE Floor beam Stiffener. The weld joint was designated as: FB3146-001-090. The welder is identified as #037743. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 13CE Longitudinal Diaphragm Stiffener. The weld joint was designated as: LD3028-001-081. The welder is identified as #037743. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3009D-103 located on OBG Segment 13BE Side plate stiffener to Floor beam. Welder is identified as #051359. ZPMC QC is identified as Mr. Wang Xu. Welding was performed with the weld repair report BWR-20630. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3007AH-117 located on OBG Segment 13AE Floor beam stiffener to Grillage. Welder is identified as #067183. ZPMC CWI is identified as Mr. Liu Hua Jie. Welding was performed with the weld repair report BWR-20596. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1.

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

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No Relevant Conversation.

## 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Pandaram

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer