

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-023269**Date Inspected:** 30-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:** Li Yang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # SEGMENT12CW

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 08991 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Hold back welds. The weld tested is identified as follows:

(DP3023-001-018,019)
(EP3003-001-013,014)
(SP3009-001-040,041)
(SP3010-001-035,036,023,024)
(DP3033-001-018,019)
(EP3006-001-013,014)
(SP3024-001-032,033)
(SP3023-001-025,026,017,018)
(SP3022-001-032,033)
(BP3010-001-009,010)
(BP3011-001-009,010)

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This QA Inspector randomly observed the following work in progress:

OBG # CROSSBEAM CB18

This QA observed ZPMC qualified welding personnel identified as 220066 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3112-018-013,014,015,016. ZPMC Quality Control Personnel (QC) identified as Mr. Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134-ESAB.

OBG # SEGMENT 13AW

This QA observed ZPMC qualified welding personnel identified as 220066 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3013AA*-133,134. ZPMC Quality Control Personnel (QC) identified as Mr. Li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134-ESAB.

OBG # CROSSBEAM CB19

This QA observed that ZPMC personnel perform Crossbeam CB19 fit-up to lift 14 East line and west line. No significant work was being performed on this crossbeam during the time QA was present.

OBG # SEGMENT 12CE

This QA observed ZPMC qualified welding personnel identified as 052493 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint CA3005-005. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and Critical Weld Repair Report CWR 2946, REV 0.

OBG # SEGMENT 12AE

This QA observed ZPMC qualified welding personnel identified as 052493 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint CA3001-001. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and Weld Repair Report B-WR 20873.

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

Summary of Conversations:

As mention above

Comments

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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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
