

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-023406**Date Inspected:** 07-May-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: 009057

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. The members are identified as OBG Segment 13B/CW. The weld designations reviewed are as follows:

1. DP3135-001-030
2. DP3148-001-241

OBG Trail Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint CA3016A-105, 109, 113, 117 and 121 located on Corner Assembly RS Stiffener at panel point 123 to 123.5 of Segment 13CW. ZPMC Welder is identified as 045240. 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-2112-FCM-1.

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SMAW welding of weld joint CA3015A-009, 013, 017, 021 and 025 located on Corner Assembly RS Stiffener at panel point 121.5 to 121 of Segment 13BW. ZPMC Welders are identified as 067588 and 066179. 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-2114-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3014S-002, 005, 008, 011, 014, 017 and 020 located on Vertical Plate Stiffener to Floor Beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 058245. 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-T-2231-ESAB.

FCAW welding of weld joint SEG3014B-145 located on Vertical Plate to Floor Beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 045143. 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-FCAW-3G-(3F)-FCM-ESAB-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20902.

FCAW welding of weld joint OBG13B-003 located on bottom plate to side plate of OBG Segment 13AW to OBG Segment 13BW. ZPMC Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231T-ESAB.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on Architecture House RS stiffeners at panel point 121 and 120.5 counter weight side of OBG Segment 13BW. The weld number is identified as RS3444E-083 and RS3444E-087.

SMAW welding of weld joint SEG3020X-004 located on longitudinal diaphragm to anchor plate at panel point 125 to 127 of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20845.

FCAW 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 067949. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint SEG3020T-117 located on anchor plate RS stiffener to floor beam at panel point 125.5 of OBG Segment 14W. ZPMC Welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1. See the attached picture.

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