

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-023673**Date Inspected:** 13-Mar-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:** Lv Li Qing**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 Structure**Summary of Items Observed:**

: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG FB3329-001. The welds designations reviewed are as follows: FB3329-001-018

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG FB3329-001. The welds designations reviewed are as follows: FB3329-001-015

MAGNETIC PARTICLE TESTING (MT)

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This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG FB3329-001. The welds designations reviewed are as follows: FB3329-001-013

MAGNETIC PARTICLE TESTING (MT)

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MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG SEG3007K . The welds designations reviewed are as follows: SEG3007K-026

MAGNETIC PARTICLE TESTING (MT)

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MAGNETIC PARTICLE TESTING (MT)

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MAGNETIC PARTICLE TESTING (MT)

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MAGNETIC PARTICLE TESTING (MT)

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WELDING INSPECTION REPORT

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report for this date. The member is identified as OBG SEG3007K . The welds designations reviewed are as follows: SEG3007K-030

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG SEG3007K . The welds designations reviewed are as follows: SEG3007K-031

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG SEG3007K . The welds designations reviewed are as follows: SEG3007K-032

MAGNETIC PARTICLE TESTING (MT)

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In process Inspection:-

BAY#14

:

SMAW welding of weld joint no: SEG3019U-003 located on OBG Segment 14E Bottom Panel to Anchor Plate. Welder is identified as #066418. ZPMC QC is identified as Mr. Zhu Yuan Yuan. Welding was performed according to the Critical weld repair report B-CWR2822. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair-1.

SMAW welding of weld joint no: SEG3019D-1-323 located on OBG Segment 14E Bottom Panel to Floor Beam. Welder is identified as #201087. ZPMC QC is identified as Mr. Zhu Yuan Yuan. Welding was performed according to the Critical weld repair report B-CWR2677. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair-1.

FCAW in the (3G) position for the OBG Segment 14E Side panel stiffener to Floor Beam. The weld joint was designated as: SEG3019C-042. The welder is identified as #066236. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB.

SMAW in the (2G) position for the OBG Segment 14E Side panel to Side panel. The weld joint was designated as: SEG3019AW-100. The welder is identified as #070007. ZPMC QC is identified as Mr. Zhan Hai Feng. The

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welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1. Please see the attached picture.

SMAW In the (3G) position for the OBG Segment 14E Side panel to Side panel. The weld joint was designated as: SEG3019AW-105. The welder is identified as #066163. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW In the (4G) position for the OBG Segment 13AE Deck panel to Edge panel. The weld joint was designated as: SEG3007AB-096. The welder is identified as #068097. ZPMC CWI is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the (4G) position for the OBG Segment 13AE Deck panel to Floor Beam. The weld joint was designated as: SEG3007S-048. The welder is identified as #068764. ZPMC CWI is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1. Please see the attached picture.

VISUAL INSPECTION

This QA Inspector Manuel Teall performed a random visual inspection on OBG APBB1-Bearing Blocks .the blocks are located in Bay 14 And in the paint bay .All visual defects were marked and ZPMC QC was notified .

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant conversations were reported on this date.

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.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
