DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023786
Date Inspected: 01-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	An Qing Xiang	**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 Components

Summary of Items Observed:
On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT
BAY 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08696.
Ultrasonic Testing (UT).

This QA inspector performed UT of approximately 10 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG3014E-061, 066, 071, 076, 081, 086, 091, 096, 101, 106, 111, 116, 121, 126, 131, 136, 141.

SEG3014E-103, 108, 113, 118, 123, 128, 133, 138, 143.

SEG3014G-062, 066, 070, 074, 078, 082, 086, 090, 094, 098, 102, 106, 110, 114, 118, 122, 126.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 045196 perform repair welding by Shielded Metal Arc Welding (SMAW), on Corner assembly to Floor beam weld of OBG Segment 13BW. Weld joint is identified as SEG3014C-146. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Welding repair report B-WR20539. This QA Inspector noted welding variables were 145~160 amperes and 24.9 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066179 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13BW. Weld joint is identified as SEG3014C-008. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Welding repair report B-WR20537. This QA Inspector noted welding variables were 145~165 amperes and 25.2 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066421 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel 3137A to Deck panel 3138A, of OBG Segment 13BW. Weld joint is identified as SEG3014-001. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-223(2)1T-ESAB-1. This QA Inspector noted welding variables were 270~285 amperes and 25.4 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 067904 perform welding by Shielded Metal Arc Welding (SMAW), on Vertical shear plate to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-011. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 140~155 amperes and 25.3 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 069841, 066261 perform welding by Shielded Metal Arc Welding (SMAW), on Vertical shear plate to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-065. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 145~160 amperes and 24.7 volts, which appears to be in compliance with the approved WPS.

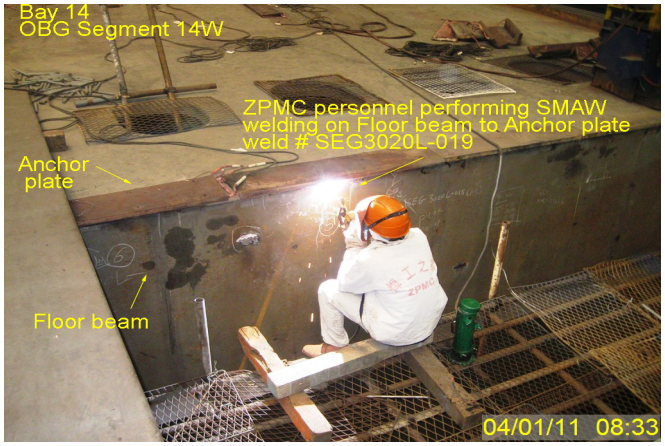
This QA Inspector observed ZPMC qualified welding personnel identified as 066443 perform welding by Shielded Metal Arc Welding (SMAW), on Sub assembly SA3416A to Floor beam weld at panel point 128.3, of OBG Segment 14W. Weld joint is identified as SEG3020AV-006. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC

appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 150~160 amperes and 24.8 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066002 perform welding by Shielded Metal Arc Welding (SMAW), on Sub assembly SA3416C to Floor beam weld at panel point 128.3, of OBG Segment 14W. Weld joint is identified as SEG3020AV-011. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 145~160 amperes and 24.8 volts, which appears to be in compliance with the approved WPS. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 069896 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to Floor beam weld at panel point 127, of OBG Segment 14W. Weld joint is identified as SEG3020L-019. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1. This QA Inspector noted welding variables were 145~160 amperes and 25.2 volts, which appears to be in compliance with the approved WPS. See attached picture.

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



Summary of Conversations:

No significant 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector

WELDING INSPECTION REPORT

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Reviewed By: Clifford,William QA Reviewer