

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023819**Date Inspected:** 15-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:** 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 11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08832.

Magnetic Particle Testing (MT).

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows:

SSD1-FASA6-1-11, 12.

NSD1-FASA6-3-15, 16.

SSD1-FESA6-1-19.

SSD1-FESA6-1-6.

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NSD1-FESA6-3-5.

NSD1-FBSA6-3-8.

SSD1-FASA6-1-29.

SSD1-FCSA6-1-9.

NSD1-FCSA6-3-9, 18.

SSD1-FDSA6-1-12.

NSD1-FDSA6-3-12.

SSD1-FESA6-1-29.

NSD1-FESA6-3-34.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 066695 perform welding by Flux Cored Arc Welding (FCAW), on Traveler Rail TR3004. Weld joint is identified as TR3004-TR1-001-008. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 240~250 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 045175 perform welding by Flux Cored Arc Welding (FCAW), on Traveler Rail TR3001. Weld joint is identified as TR3001-TR1-001-013. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 245~260 amperes and 25.1 volts, which appears to be in compliance with the approved WPS. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel DP3174 to Deck panel DP3175 weld of OBG Segment 14W. Weld joint is identified as SEG3020-008. 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-T-223(2)1T-ESAB-1. This QA Inspector noted welding variables were 275~285 amperes and 25.5 volts, which appears to be in compliance with the approved WPS. See attached picture.

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This QA Inspector observed ZPMC qualified welding personnel identified as 045246, 066361 perform repair welding by Shielded Metal Arc Welding (SMAW), on Anchor plate to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AQ-025. 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-345-SMAW-1G (1F)-FCM-Repair-1 and Critical welding repair report B-CWR2923 Rev 0. This QA Inspector noted welding variables were 150~160 amperes and 25 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066261 perform welding by Shielded Metal Arc Welding (SMAW), on longitudinal diaphragm to Anchor plate weld between panel points 126.5 through 127, of OBG Segment 14W. Weld joint is identified as SEG3020X-007. 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-2214-Tc-U4b-FCM-1. This QA Inspector noted welding variables were 145~160 amperes and 24.6 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 067275, 045143 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Anchor plate weld at panel point 127, of OBG Segment 14W. Weld joint is identified as SEG3020L-015. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB. This QA Inspector noted welding variables were 270~280 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 067888 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Deck panel diaphragm weld at panel point 128.3, of OBG Segment 14W. Weld joint is identified as SEG3020D-024. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. This QA Inspector noted welding variables were 240~250 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 067942 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Anchor plate weld at panel point 128.7, of OBG Segment 14W. Weld joint is identified as SEG3020C-042. ZPMC Quality Control (QC) Inspector identified as Liu Fang 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 135~150 amperes and 24.5 volts, which appears to be in compliance with the approved WPS.

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

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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
Reviewed By:	Clifford, William	QA Reviewer
