

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023892**Date Inspected:** 23-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. Shi Lei**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.

Magnetic Particle Testing (MT) – NWIT Document No's: 009225

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13AW. The weld designations reviewed are as follows:

1. SEG3013P-085

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3134-003-001, 003 located on bottom plate connected SA3134 at panel point 121 to 121.5 FL2 side of OBG Segment 13BW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015D-090, 091, 084 and 085 located on RS

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Stiffener to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 066687. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3015D-150, 151, 144 and 145 located on RS Stiffener to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 069075. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3015D-192, 193, 186 and 187 located on RS Stiffener to Floor Beam at panel point 124 of OBG Segment 13CW. ZPMC Welder is identified as 040614. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3015H-176, 177, 170 and 171 located on RS Stiffener to Floor Beam at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 057220. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3015K-266 and 267 located on Floor beam RS Stiffener to RS Stiffener at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 066157. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3014D-229 and 230 located on Floor beam RS Stiffener to RS Stiffener at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 040270. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint SA3128-001-001 and 007 located on bottom plate connected SA3128 of OBG Segment 13BW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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