

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-023895**Date Inspected:** 19-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.

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3015F-233 located on floor beam to vertical plate at panel point 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 045196. 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)-ESAB-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20961.

FCAW welding of weld joint SEG3015K-192 located on side plate RS stiffener to floor beam at panel point 122.5 of OBG Segment 13CW. 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)-ESAB-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20961.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014B-240 located on vertical plate to floor beam at panel point 122 of OBG Segment 13BW. ZPMC Welder is identified as 066156. 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-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report

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(WRR) B-WRR-21025.

SMAW welding of weld joint AH3002-025 located on Architecture House side plate to edge plate of OBG Segment 13BW. ZPMC Welder is identified as 040270. 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-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20877.

SMAW welding of weld joint AH3002-027 located on Architecture House side plate to edge plate of OBG Segment 13BW. ZPMC Welder is identified as 044541. 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-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-20878.

SMAW welding of weld joint SP3105-001-053 located on side plate I-rib to I-rib at panel point 121 to 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 040614. 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-2213-B-U2-FCM-1.

FCAW welding of weld joint SA7508-001-005, 006, 007 and 008 located on bottom plate connected SA7508 at panel point 122 to 122.5 FL2 side of OBG Segment 13B/CW. ZPMC Welder is identified as 066695. 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.

Visual Inspection before Blast – Trail Assembly Yard

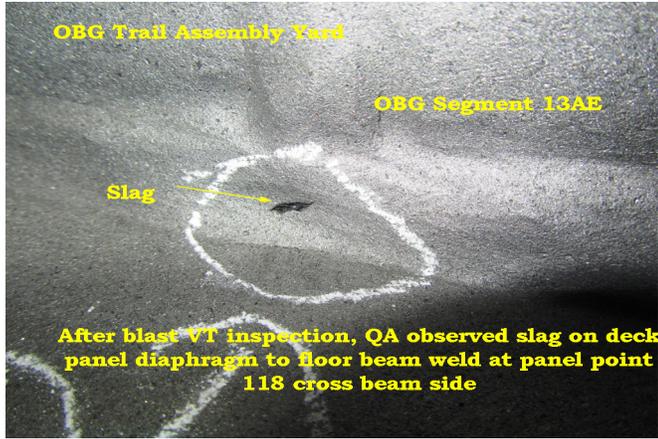
OBG Segment 13AE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13AE, before the grit blast of the interior components of the deck panel U-ribs, floor beams, side plate, longitudinal diaphragm, edge beams and corner assemblies of this segment. The panel points are identified as PP117.5 to 119-1500 at cross beam side. Areas of visual weld defects that will require welding were marked and will be repaired before the blasting/coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in 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