

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-024612**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Ji Cai Fang**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**Summary of Items Observed:**

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

NDT

OBG Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08162.

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. The weld designations reviewed is as follows:

SA3110-001-001, 002, 004, 005

WELDING

OBG Bay 14

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This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3175-001-007 located on Deck Plate to Deck Panel Diaphragm of the OBG Segment 14W. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020G-021/026 located on the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020H-041/044 located on the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3013AA-085 located on Edge Plate to Floor Beam of the OBG Segment 13AW. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20128.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3013AU-084 located on the OBG Segment 13AW. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3013AU-065 located on the OBG Segment 13AW. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3013AA-105 located on of the OBG Segment 13AW. The welder is identified as 068445. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-Repair and B-WR20130.

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:

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, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
