

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-024837**Date Inspected:** 21-Jun-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.

Ultrasonic Testing (UT) – NWIT Document No: 009536

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. FB3328-001-059, 060
2. SEG3020M-193, 200, 203
3. SEG3020AQ-005, 009
4. SEG3020AQ-006, 010, 014, 008
5. SEG3020M-009
6. SEG3020Q-181, 175, 179
7. SEG3020F-095, 096
8. SEG3020L-171
9. SEG3020N-165, 167, 170, 161, 162, 163, 164
10. SEG3020L-031

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3020D-066 located on Floor Beam I-rib to Longitudinal Diaphragm at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2211-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020D-022 and 023 located on Floor Beam I-rib to SA3415A at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3020B-119 and 120 located on Floor Beam I-rib to SA3415A at panel point 128.7 of OBG Segment 14W. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

SMAW welding of weld joint SEG3020N-053 located on Side Plate I-rib to SP3144B at panel point 126 of OBG Segment 14W. ZPMC 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 the Applicable WPS-B-P-2211-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AA-012 and 013 located on Longitudinal I-Rib at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SEG3020AA-011 located on Longitudinal I-Rib to Deck Panel at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020Y-012 and 013 located on Longitudinal I-Rib at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SEG3020Y-011 located on Longitudinal I-Rib to Deck Panel at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020X-042 located on Longitudinal I-rib to I Rib at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

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Visual Inspection after Blast

OBG Cross Beam 19

This QA Inspector performed a preliminary random visual inspection on OBG Cross Beam 19, after the grit blast of the interior components of the deck panel, Deck Panel Diaphragm, floor beams and Anchor Plate, side plate of this Cross Beam. Areas of visual weld defects that will require welding were taped and will be repaired after the 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.



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
