

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025045**Date Inspected:** 07-Jun-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:** Mr. Li Yan Hua**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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

OBG-Trial assembly Yard

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 133, 154 as per WRR no. B-WR-21277, Located on Vertical plate I Rib in Segment 14E, SEG 3019AJ. Welder is identified as 216086. ZPMC Quality Control Inspector (QC) is identified as Zhu Yuan Yaan. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) - Repair.

Repair welding of Base metal repair as per CWR no. B-CWR-2944, Located on Side plate in Segment 14E. Welder is identified as 067601. ZPMC Quality Control Inspector (QC) is identified as Zhu Yuan Yaan. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) - Repair.

Weld joint- 145, Located on Side plate I Rib to Floor beam at PP126, SEG 3020R. Welder is identified as 066751. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214- TC-U4B-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint- 092, Located on Drop plate to Side plate in Segment 14W, SEG 3020AW. Welder is identified as 066881. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214- TC-U4B-FCM-1.

Weld joint- 092, Located on Drop plate to Side plate in Segment 14W, SEG 3020AW. Welder is identified as 066673. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214- TC-U4B-FCM-1.

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09390.

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Anchor plate to Deck Joints. The weld designation reviewed as follows:

SEG3020BB –Jt. nos -029,038,047,002,011,056,065,020,074

For further information's, see the pictures below:

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:

No relevent Conversations.

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:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
