

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-025268**Date Inspected:** 07-Jul-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.

Visual Inspection after Painting at Segment 13BE and 13CE internal

This Quality Assurance (QA) Inspector performed random visual inspection of OBG Segment 13BE and 13CE internal Deck panel, side panel, bottom panel and Floor beam surfaces after primer painting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and informed to ABF and ZPMC personnel.

OBG Segment Trial Assembly

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3F position for the OBG Segment 13CE Corner Assembly. The weld joint was designated as: CA3014-017. The welder is identified as #069469. ZPMC QC is identified as Mr. Zhong Yong hong. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

SMAW in the 1G position for the OBG Segment 13CE Side panel "I" ribs. The weld joint was designated as: SEG3011E-290. The welder is identified as #216086. ZPMC QC is identified as Mr. Zhong Yong hong. The welding variables recorded by QC appear to comply with WPS-B-P-2211-TC-U4b-FCM-1.

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FCAW in the 2G position for the OBG Segment 13BE Vertical panel “I”rib connection plates. The weld joint was designated as: SA3101-001-004. The welder is identified as #051359. ZPMC QC is identified as Mr. Zhong Yong hong. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB.

SMAW in the 4G position for the OBG Segment 13AE VP3007A to RS3213C, The weld joint was designated as: VP3007-001-062. The welder is identified as #043661. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G (4F) FCM-Repair-1.

SMAW in the 4G position for the OBG Segment 13BE VP3007A to X3659A CJP Weld; , The weld joint was designated as: SEG3011E-216. The welder is identified as #067764. ZPMC QC is identified as Mr. An Qin Xiang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1.

Visual Inspection after Blast

OBG Segment 14W

This QA Inspector performed a random visual inspection on OBG Segment 14W, after the grit blast and preliminary of the interior components of the edge Plate, Anchor Plate, longitudinal diaphragm, floor beams and side plate cross beam side and cable side of OBG Segment 14W. Areas of visual weld defects that will require welding were inform to ZPMC QC personnel. ZPMC QC personnel are aware of these areas and were present during the inspection.

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
