

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-027187**Date Inspected:** 14-Oct-2010**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), Changxing Island **Location:** Shanghai**CWI Name:** Chen Xi**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 06945. The member(s) is/are identified as OBG Barrier Rails assembly. The weld designations reviewed are as follows:

1. E2-SB1C-001-001~179.
2. E2-SB1D-011-001~179.
3. E2-SB1D-009-001~179.
4. E2-SB1C-001-001~179.
5. E2-SB5-001-001~179.
6. E2-SB5-002-001~179.
7. E2-SB1-007-001~179.
8. E2-SB10-001-001~179.
9. E2-SB10-002-001~179.

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- 10. E2-SB11-001-001~179.
- 11. E2-SB4-002-001~179.
- 12. E2-SB1-012-001~179.

This QA inspector performed final VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as counter weight CW88. A pre-production VT examination and 30 degree bend test was observed and found to be acceptable on 2 studs in each position in accordance with AWS D1.5 section 7.7.1.1. The welding variables recorded by ZPMC QC identified as Chen Xi appeared to comply with applicable WPS(s), WPS-B-T-2141-stud. This inspector signed green tag no. 10529

This QA inspector performed final VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as counter weight CW86. A pre-production VT examination and 30 degree bend test was observed and found to be acceptable on 2 studs in each position in accordance with AWS D1.5 section 7.7.1.1. The welding variables recorded by ZPMC QC identified as Chen Xi appeared to comply with applicable WPS(s), WPS-B-T-2141-stud. This inspector signed green tag no. 11373

Bay Number 2

FCAW welding of complete joint penetration root pass weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 016. Welder(s) are identified as welder no.(s) 045227, 045175, 070217, & 045266. The welding variables recorded by ZPMC QC identified as Chen Xi appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U5-F-2.

FCAW welding of complete joint penetration root pass weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 015. Welder(s) are identified as welder no.(s) 068554, 067877, & 066236. The welding variables recorded by ZPMC QC identified as Chen Xi appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U5-F-2.

Bay Number 3

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 06953. The member(s) is/are identified as OBG Floor Beam assembly. The weld designations reviewed are as follows:

- 13. FB3285-001-003~022, 025~030, 035, 036,041~043, 048.
- 14. FB3293-001-003~032, 035~046, 051~053, 058~062.

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. All components were as listed on NWIT notification no.(s) 06952. The member(s) is/are identified as OBG Floor Beam assemblies. The weld designations reviewed are as follows:

- 1. FB3265-001-011, 012.

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Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3290-001 for the following designated weld number(s): 003~024. This QA inspector signed green tag #14811.

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3291-001 for the following designated weld number(s): 001~022. This QA inspector signed green tag #14813.

Bay Number 4

SAW welding of complete joint penetration welds located on sub-assembly plate identified as SA3362-001 weld number(s) 001. Welder is identified as welder no. 207288. The welding variables recorded by ZPMC QC identified as Chen Xi appeared to comply with applicable WPS(s) WPS-B-T-2221-B-L2C-S-2.

Bay 8

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. All components were as listed on NWIT notification no.(s) 06952. The member(s) is/are identified as OBG Floor Beam assemblies. The weld designations reviewed are as follows:

1. BK004A1-54-043 & 047.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the report.

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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
