

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-019871**Date Inspected:** 21-Dec-2009**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, China**CWI Name:** See Below**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 9AW / North of Bay 14

This Caltrans QA Inspector observed base metal repairs being performed in way of temporary attachment removal areas on the side plate identified as SP490A/PI648A, without the prior approval of the engineer. Caltrans Special Provision Section 8-3.01: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair. This QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 12-21-09 for additional information. ZPMC QC inspector/ Certified Welding Inspector (CWI), is identified as Mr. Wang Wei Ming.

OBG Segment Name: 9BW / North of Bay 17

This Caltrans QA inspector observed shielded metal arc welding (SMAW) in progress. Welder is identified as #068097 welding complete joint penetration (CJP) weld in the 3G position using welding procedure specification WPS-B-T-2213-TC-U4b-FCM-1. The weld is identified as SSD11A-PP75-185. ZPMC QC inspectors are identified as Mr. Wang Wei Ming and certified welding inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11CE / Bay 13

WELDING INSPECTION REPORT

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This Caltrans QA inspector observed SMAW in progress. Welder is identified as #044772 welding complete joint penetration (CJP) weld in the 4G position using welding procedure specification WPS-B-P-2214-B-U4b-FCM-1. The weld is identified as SEG070-001. ZPMC QC inspectors are identified as Mr. Tang Yan Jun and CWI, Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 12CE / Bay 14

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #044771 welding CJP weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG3003A-004 & 008. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI inspector, Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
