

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-020166**Date Inspected:** 15-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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 & Tower**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: 6CW+7AW / Trial Assembly

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #062092 welding temporary fit-up aids to side plate transverse weld joint, in the 4F position using welding procedure specification (WPS), WPS-B-P-2214-FCM-1. ZPMC Quality Control (QC) inspectors are identified as Mr. Wang Zu and certified welding inspector (CWI); Mr. Li Yang. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: Lift 1 Tower / Heavy Duty Dock

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #062126, welding partial joint penetration (PJP) weld in the 3G position using WPS-B-T-2333-TC-P4-F. ZPMC QC inspectors are identified as Mr. Sun Zi Wang and CWI inspector, Mr. Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 8BE / Blast Shop 1

ZPMC QC informed Caltrans QA inspector that the inspection notification after grit blast for 00:30 hours has been canceled. The inspection has been rescheduled for 06:30 hours. The ZPMC Notice of Inspection Document is identified as #2516.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG Segment Name: CB4 / Trial Assembly

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #219589, performing fit-up and tack welding brackets to the cross beam bottom plate exterior surface. The welder is observed welding in the 4F position, using WPS-B-P-2214-FCM-1. ZPMC QC inspectors are identified as Mr. Wang Zu and CWI; Mr. Li Yang. The welding variables recorded by QC appeared to comply with the WPS. The following digital picture illustrates fit-up and tack welding of bracket in place. Photo please see; Z:\Inspector Reports\B293 Hasler.

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
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Reviewed By:	Riley, Ken	QA Reviewer
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