

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-017140**Date Inspected:** 30-Aug-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, China**CWI Name:** Geng Wei**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 Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 13CW bottom panel weld, SEG3011A-004. ZPMC welder was identified as 044771. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CW bottom panel weld, SEG3009A-002. ZPMC welder was identified as 217605. ZPMC QC was identified as Wang Xu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-B-U2-F.

Submerged Arc Welding (SAW) of OBG Segment 13CW weld, SEG3015A-002. ZPMC welder was identified as 045270. ZPMC CWI was identified as Wang Xu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Bay 13-

Caltrans QA observed ZPMC milling OBG Segment 13AW shear key rod and bearing rod mill to bear surfaces.

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West of Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Cross Beam 11 exterior base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Items which require repair were recorded for future repair. Caltrans QA observed ZPMC Magnetic Particle Testing (MT) technicians performing MT of arc strike areas marked by ABF QC and Caltrans QA personnel.

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

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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