

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-019550**Date Inspected:** 23-Nov-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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Yu Zhi Lai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower, skin plate face A

PCMK: SSD1-FASA6-1-5-1

Weld No.

Welder: 052075

WPS-B-T-2132

Component; Tower, skin plate face A

PCMK: SSD1-FASA6-1-6-2

Weld No.

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Welder: 057258

WPS-B-T-2132

Bay 12

This QA Inspector observed the following work in progress for Bay 12.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

Mock up welding does not require ZPMC QC.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector. Photo below.

Component; Hand Rail Mockup

PCMK: BKR-NS-10 & 36

Welder: 053869

WPS-B-T-2234

Trial Assembly

This QA Inspector performed MT on approximately 15% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 MT requirements. The member was identified as OBE11BE / 11CE, interior side, weld numbers OBE11-006,007,008, 009,010.

This QA Inspector performed MT on approximately 15% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 MT requirements. The member was identified as OBE11BW / 11CW, interior side, weld numbers OBE11-006,007,008, 009,010, and interior side, OBE11B-006,007,008,009,010.

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



Summary of Conversations:

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No significant conversations

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
