

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-019564**Date Inspected:** 07-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.

Bay 10

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

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Sun tian liang, CWI Xu Le Feng.

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. See picture below.

Component; Bike Path, temporary attachment

PCMK: BK004A1-027

Welders: 052493, 052930, and 040268

WPS-B-T-2214-Tc-USb

Component; Bike Path

PCMK: BK004A3-026

Weld No: 068, 102

Tack Welders: 057186

WPS-B-T-2112

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Component; Bike Path
PCMK: BK004A1-030
Weld No. 044
Welder: 500363
WPS-345-SMAW-4G(4F)-Repair
B-WR-14889

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 Sun tian liang, CWI Xu Le Feng.
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. See picture below.

Component; Tower Lift 6, skin B
PCMK: NSD1-FBSA6-3
Weld No. 1, 2
Welder: 053869
WPS-B-T-2132

Component; Bike Path
PCMK: BK004A1-030
Weld No. 043
Welder: 040434
WPS-345-FCAW-2G(2F)-Repair
B-WR-15760

Bay 2
This QA Inspector observed the following work in progress for Bay 2.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Chen Xi.
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. See picture below.

Component; Diaphragm Sub-Assembly
PCMK: FB3343-001
Weld No. 096, 267
Welder: 067520
WPS-B-T-2232-TC-U4c-F

Bay 3
This QA Inspector observed the following work in progress for Bay 3.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Chen Xi.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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

Component; Diaphragm Sub-Assembly

PCMK: FB3286-001

Weld No. 101, 109

Welder: 066359

WPS-B-T-2233-TC-U4c-F

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



Summary of Conversations:

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