

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020601**Date Inspected:** 22-Nov-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:** Mr. 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:** BAY 6, 8, 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 8

This QA Inspector observed the following work in progress:

FCAW welding of fillet weld joint(s) located on OBG Bike Paths components identified as BK004A1-063 weld number(s) 080 and 081. Welder is identified as welder no. 046766. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

SMAW welding of complete joint penetration weld joint(s) located on Bike Path component(s), identified as BK004A1-057 weld number(s) 044. Welder is identified as welder no. 066439. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) 4G (4F) SMAW WPS-345-SMAW and CWR B-CWR2262.

FCAW welding of complete joint penetration weld joint(s) located on Bike Path component(s), identified as BK004A1-057 weld number(s) 044. Welder is identified as welder no. 066439. The welding variables recorded by

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) 1G (1F) FCAW WPS-345-FCAW and CWR B-CWR2262.

OBG BAY 6

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Lift 14 Sub-Assembly DP3168B-001, weld joint(s) 098, 099, 103, 104, 106, 107, 109, 110, 112, 113, 115, 116, 123, 139, 137, 138, 139, and 140. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li Jia was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-433 dated 11-10-2010.

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of fillet weld joint(s) located on U-Rib to Deck Plate Diaphragm components identified as DP3090-001 weld number(s) 012, 013, 022, and 023. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Mr. Zhong Gou Hui appeared to comply with applicable WPS(s) WPS-B-T-2133.

FCAW welding of fillet weld joint(s) located on U-Rib to Deck Plate Diaphragm components identified as DP3093-001 weld number(s) 044, 045, 054, and 055. Welder is identified as welder no. 044790. The welding variables recorded by ZPMC QC identified as Mr. Zhong Gou Hui appeared to comply with applicable WPS(s) WPS-B-T-2133.

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

Summary of Conversations:

As mentioned above between QA and QC concerning this project

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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer