

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025151**Date Inspected:** 24-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

CWI Name:	Tian Lei, Huang Wehguang	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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This inspector witnessed ZPMC personnel aligning the following barrier rails for fit-up and welding of mounting plates: E2-SB2-007, E2-SB1D-029, E2-SB5-026, E2-SB4-005, E2-SB1C-010, E2-SB1D-044, E2-SB5-031, E2-SB5-034, E2-SB5-036, E2-SB1D-024, E2-SB5-029, E2-SB2-006, E2-SB1D-023, E2-SB5-030, E2-SB1-040, & E2-SB1C-008.

Bay Number 2

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA3415-001 weld number(s) 002. Welder is identified as welder no. 020009. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U-4b-F

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA3415-002 weld number(s) 002. Welder is identified as welder no. 067184. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U-4b-F

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FCAW welding of fillet welds located on Sub Assembly components identified as SA3448-001 weld number(s) 026 & 027. Welder is identified as welder no. 045203. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132.

FCAW welding of fillet welds located on Sub Assembly components identified as SA3448-001 weld number(s) 019 & 020. Welder is identified as welder no. 067876. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132.

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA3449-002 weld number(s) 378. Welder is identified as welder no. 067184. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U-4b-F

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA3449-002 weld number(s) 071. Welder is identified as welder no. 045203. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U-4b-F

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA3449-002 weld number(s) 276. Welder is identified as welder no. 048696. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U-4b-F

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA7512-002 weld number(s) 036 & 037. Welder is identified as welder no. 066734. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5F.

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA7512-002 weld number(s) 051. Welder is identified as welder no. 066421. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5F.

FCAW welding of complete joint penetration welds located on Sub Assembly components identified as SA7512-002 weld number(s) 050. Welder is identified as welder no. 066443. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5F.

Bay Number 3

This inspector did not observe any welding or contract work in this bay today.

Bay Number 4

This inspector did not observe any welding or contract work in this bay today.

Bay Number 7

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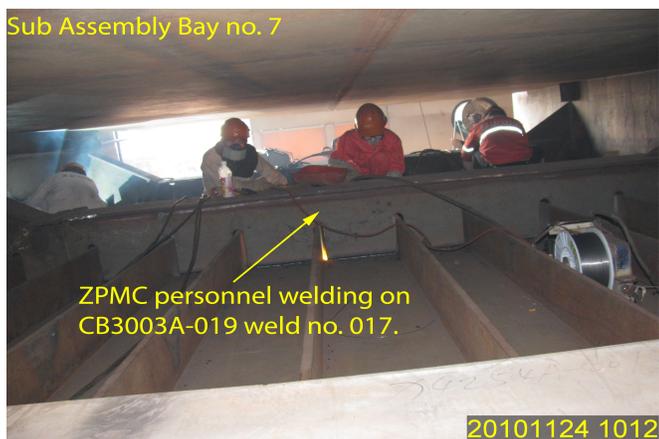
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FCAW welding of complete joint penetration welds located on Cross Beam components identified as CB3003A-019 weld number(s) 005. Welder is identified as welder no. 020009. The welding variables recorded by ZPMC QC identified as Huang Wehguang appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of complete joint penetration welds located on Cross Beam components identified as CB3003A-019 weld number(s) 017. Welder is identified as welder no. 048659. The welding variables recorded by ZPMC QC identified as Huang Wehguang appeared to comply with applicable WPS(s) WPS-B-T-2214-TC-U4b-FCM.

FCAW welding of complete joint penetration welds located on Deck Plate components identified as DP3179-001 weld number(s) 039. Welder is identified as welder no. 067801. The welding variables recorded by ZPMC QC identified as Huang Wehguang appeared to comply with applicable WPS(s) WPS-B-T-2233-B-U2-F.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the 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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Rene

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer
