

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-018896**Date Inspected:** 27-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Tian Lei**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin 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 for Bay 14.

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

ZPMC QC is identified as Zhong Yang Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Segment 13AE

PCMK: SEG-3007AV-087

Welder: 055491

WPS-B-T-2233-ESAB

PCMK: SEG-3007B-097,099

Welder: 050242

WPS-B-T-2233-ESAB

PCMK: SEG-3007M-147,152

Welder: 055564

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WPS-B-T-2233-ESAB

Components: Segment 13BE

PCMK: SEG-3009J-220

Welder: 66041

WPS-B-T-2233-ESAB

Components: Segment 14E

PCMK: SEG-3019Q-1-058

Welder: 66471

WPS-B-T-2233-ESAB

PCMK: SEG-3019N-074

Welder: 066733

WPS-B-T-2132-ESAB

PCMK: SEG-3019N-075

Welder: 66283

WPS-B-T-2133-ESAB

PCMK: SEG-3019Q-1-061,062

Welder: 217805

WPS-B-T-2132-ESAB

PCMK: SEG-3019E-1-182

Welder: 044830

WPS-B-T-2232-ESAB

PCMK: SEG-3019D-1-178

Welder: 688994

WPS-B-T-2233-ESAB

PCMK: SEG-3019D-1-323

Welder: 644824

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhong Yang Gang.

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

Components: Segment 13AE

PCMK: SEG-3007AT-005

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Welder: 215553
Report: B-WR19143
WPS-345-SMAW-2G (2F)-Repair

PCMK: SEG-3007AT-043
Welder: 216086
Report: B-WR19150
WPS-345-SMAW-2G (2F)-Repair

PCMK: SEG-3007L-045
Welder: 66571
Report: B-WR18556
WPS-345-SMAW-2G (2F)-Repair

Components: Segment 13BE
PCMK: SEG-3009J-212
Welder: 067571
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3009G-194
Welder: 68097
WPS-B-P-2214-TC-U4b-FCM-1

Components: Segment 13CE
PCMK: SEG-3011E-278
Welder: 69683
Report: B-WR-17637
WPS-345-SMAW-4G (4F)-Repair

Components: Segment 14E
PCMK: SEG-3019D-2-165
Welder: 044772
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3019BB-103
Welder: 058102
WPS-B-P-2212-TC-U4b-FCM-1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; AP3031-001, on item number 1 of NWIT tracker document # 07952,

Blasting Bay 1

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QA performed after blasting inspection on Cross Beam 16, QA find out few locations need to Grinding work done. Detail information and locations inform to ABF QA and ZPMC QC inspector.

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

Summary of Conversations:

No relevant 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:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
