

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-019598**Date Inspected:** 20-Jan-2011**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 West

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

ZPMC was using the Submerged Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

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.

PCMK: DP-3133-001

Weld No: 019

Welder: 067611

WPS-B-P-2213-TC-U4B-FCM-1

PCMK: DP-3133-001

Weld No: 020

Welder: 037780

WPS-B-P-2213-TC-U4B-FCM-1

Bay 14 East

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

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

ZPMC QC is identified as Zhong Guo Hui.

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.

PCMK: SEG-3019AG

Weld No: 046 and 049

Welder: 066763

WPS-B-T-2231-ESAB

PCMK: SEG-3007AV

Weld No: 002 and 008

Welder: 066733

WPS-B-T-2233-ESAB

PCMK: SEG-3007AU

Weld No: 087 and 104

Welder: 037723

WPS-B-T-2233-ESAB

Bay 14 East

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

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

ZPMC QC is identified as Zhong Guo Hui.

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.

PCMK: SEG-3019BB

Weld No: 037

CWR: 2737

Welder: 215553

WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019BB

Weld No: 037

CWR: 2737

Welder: 216086

WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019A

Weld No: 001

WR: 19896

Welder: 066416

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WPS-345-SMAW-1G(1F)-FCM-Repair

PCMK: SEG-3019V

Weld No: 029

WR: 18912

Welder: 067656

WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3019Q

Weld No: 047

CWR: 2673

Welder: 067656

WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3019BB

Weld No: 185 and 186

Welder: 067571

WPS-B-P-2214-TC-U4B-FCM-1

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

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

ABF QA is identified as Peng Wen Jun.

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.

PCMK: SB-022-104

Weld No: 004

CWR: 2699

Welder: 259906

WPS-345-SMAW-3G(3F)-Repair

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

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:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
