

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-019884**Date Inspected:** 28-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:**

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 13

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Grillage SA7038 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Bay 14

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in FB3108A to Side Plate at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

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 Zhang Qiang, AB Fluor QA Yu Jiao.

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; OBG 14E,

PCMK: SEG3019V

Weld No: 003

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Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3019Z
Weld No: 010
Welder: 066416
Weld Repair No. CWR2775
WPS-345-SMAW-3G(3F)-FCM-Repair

Components; OBG Floor Beam to Longitudinal Diaphragm
PCMK: SEG3019L-1
Weld No: 092,093,044
Welder: 067571
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3019AA
Weld No: 002
Welder: 215553
Weld Repair No. CWR2774
WPS-345-SMAW-3G(3F)-FCM-Repair

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
