

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-020191**Date Inspected:** 21-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 14

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 Lin Fang.

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 13W

PCMK: SEG3013AV

Weld No: 042,043

Welder: 066163

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13W

PCMK: SEG3013AV

Weld No: 216,217

Welder: 067588

WPS-B-P-2213-TC-U4b-FCM-1

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This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on DP3172-001 weld location due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on DP3176-001 weld location due to contour grinding and visual indications as identified by ZPMC QC Inspectors. (see photos below)

Components; OGB 13CW
PCMK: DP3146-001
Weld No: 246,247,249,250
Welders: 067611, 037780
WPS-B-P-2213-TC-U4b-FCM-1

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 Zhan Hai Feng, 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; OGB 13AE
PCMK: SEG3013AX
Weld No: 089,090,091,092
Welder: 067876
WPS-B-T-2233-ESAB

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 Zhan Hai Feng, 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; OGB PP119 + 1500
PCMK: SEG3007AU
Weld No: 087,093,102,103,104,
Welder: 066733
WPS-B-T-2233-ESAB

Components; OGB 14E
PCMK: EP3027-001
Weld No: 019
Welder: 066763
WPS-B-T-2231-ESAB

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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 Zhan Hai Feng, 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 Lift 14E

PCMK: SEG3019J

Weld No: 011

Welder: 067656

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG

PCMK: SEG3019BB

Weld No: 037

Welders: 216086, 215553

Critical Weld Repair: CWR2737

WPS-345-SMAW-2G(2F)-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.

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Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer