

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020199**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in Bay 14:

FCAW welding of weld joint SEG3015F-002 located on PCMK OBG segment 13CW, deck plate diaphragm to east side of floor beam at panel point 123.5. Welders were identified as 066421, 066239. QC was identified as ABF CWI Ji Cai Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1. See photo below showing welding record with information entered by QCA1.

FCAW welding of weld joints DP3162-1-021,022 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate. Welders were identified as 037723, 066733. QC was identified as ABF CWI Yu Jiao (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Bay 14

787-B-QCR-500

Section name: 1300

Inspector: [Signature]

The welding process inspection

Weld joint no.: 06229

Weld joint name: SEG3015F-002

Weld joint size: 2.5 x 3.0

Weld joint material: 2.0

Weld joint position: 2.0

Weld joint temperature: 1300

Weld joint pressure: 2.0

Weld joint output: FCAW

Weld joint WPS no.: 787-T-222-ESM8

Weld joint date: 01-28-11

Weld joint year: 2018

Weld joint inspector: [Signature]

Weld joint date: 01-28-11

Weld joint year: 2018

ZPMC QC Inspector's record of welding joint SEG3015F-002 as presented to this QA Inspector

Summary of Conversations:

As noted above.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer