

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-020221**Date Inspected:** 17-Jan-2011**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:** Yu Jiao**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, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 13

This QA Inspector observed the following work in progress for Bay 13.

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

ZPMC QC is identified as Zhan Hai Feng

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

Component: Grillage

PCMK: SA7038C

Weld Number: 239

Welder: 216086

WPS-345-SMAW-1G-FCM-Repair

WR19722

Component: Grillage

PCMK: SA7038C

Weld Number: 228

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 216086
WPS-345-SMAW-1G-FCM-Repair
CWR2756

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 Zhan Hai Feng
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

Component: Sub Assembly
PCMK: SEG3019BB
Weld Number: 191
Welder: 201087
WPS-345-SMAW-2G-FCM-Repair
CWR2737

Component: Floor Beam
PCMK: SEG3007S
Weld Number: 028
Welder: 068124
WPS-B-T-2213

BAY 19

This QA Inspector observed the following work in progress for Bay 19.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Guo Xing 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

Component: Suspender Bracket
PCMK: SB022-104
Weld Number: 002
Welder: 259566
WPS-345-SMAW-1G-Repair
CWR2693

Component: Suspender Bracket
PCMK: SB022-104
Weld Number: 004
Welder: 259566

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-345-SMAW-3G-Repair
CWR2699

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08207 from ZPMC for Bay 19. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK005A5-002-112, 115, 118, 121, 122, 125, 128, 131, BK004B5-001-112, 115, 118, 121, 122, 125, 128, 131

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

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
