

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-020224**Date Inspected:** 20-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) Chanxing 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 Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08245 from ZPMC for Bay 13. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Grillage. The weld designations reviewed are as follows.

SA7038C-237, 238

BAY 14

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

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

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

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Weld Number: 185, 186

Welder: 067571

WPS-B-T-2112

Component: Sub Assembly

PCMK: SEG3019BB

Weld Number: 037

Welder: 215553, 216086

WPS-345-SMAW-2G-FCM-Repair

CWR2737

Component: Floor Beam

PCMK: SEG3019BB

Weld Number: 009, 010

Welder: 067571

WPS-B-T-2114

Component: Sub Assembly

PCMK: SEG3007AU

Weld Number: 087, 104

Welder: 037723

WPS-B-T-2233-ESAB

Component: Sub Assembly

PCMK: SEG3007AV

Weld Number: 002, 008

Welder: 066733

WPS-B-T-2233-ESAB

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 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

Component: Suspender Bracket

PCMK: SB22-104

Weld Number: 004

Welder: 259906

WPS-345-SMAW-3G-Repair

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

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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 , who represents the Office of Structural Materials for your project.

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