

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-020303**Date Inspected:** 20-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 Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Guo Hui. AB Fluor QA identified as Yu Jias.

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: SEG3007AU

Weld No: 087,104

Welder: 037723

WPS-B-T-2233-ESAB

Components; OBG 14 E

PCMK: SEG3019AG

Weld No: 046,049

Welder: 066736

Weld Repair No. WR19896

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

WPS-B-T-2231-ESA

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 Zhong Guo Hui. AB Fluor QA identified as Yu Jias.

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 14 E

PCMK: SEG3019Q

Weld No: 047

Welder: 067656

Weld Repair No. CWR2673

WPS-345-SMAW-3G(3F)-ECM-Repair

Components; OBG 14 E

PCMK: SEG3019A

Weld No: 001

Welder: 066416

Weld Repair No. WR19896

WPS-345-SMAW-1G(1F)-ECM-Repair

Components; OBG 14 E

PCMK: SEG3019BB

Weld No: 185,186

Welder: 067571

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E

PCMK: SEG3019BB

Weld No: 037

Welder: 215553

Weld Repair No. CWR2737

WPS-345-SMAW-2G(2F)-ECM-Repair

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on lift 14W in SEG3020H at 141 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 lift 14W in SEG3020T at 066 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 lift

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

14AW on DP3118 at 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 lift 14AW at panel point PP127 on LD3048 location due to contour grinding and visual indications as identified by ZPMC QC Inspectors. (see photo below)

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on lift 14AW for the inside I-stiffeners for end plate. This grinding is taking place to prepare these Complete Joint Penetration welds for ultrasonic testing identified by ZPMC QC Inspectors. (see photo below)

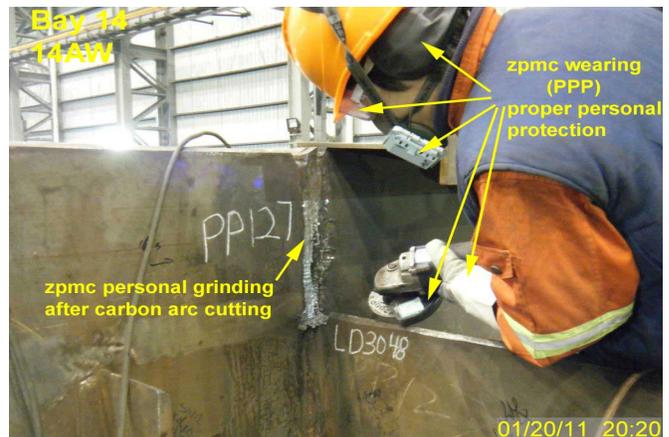
This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Li Ping.

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 13BW
PCMK: DP3133-001
Weld No: 019,022,023,
Welders: 067611, 037780
WPS-B-T-2213-TC-U4b-FCM-1

This Caltrans QA Inspector during random observation at ZPMC noted that back gouging was being performed using the Carbon Arc Cutting (CAC) process on SEG3022BB-010. Also noted at this location was ZPMC grinding these back gouge areas to a bright metal finish in preparation for the welding process as outlined in the contract documents.

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



WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
