

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-020745**Date Inspected:** 20-Feb-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 random 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 Zhan Hai Feng CWI QA Bao Qiam.

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 14E

PCMK: SEG3007AT

Weld No: 021,022

Welder: 037705

WPS-B-T-2233-ESAB

Components; OBG 14E

PCMK: SEG3019BB

Weld No: 028

Welder: 070046

WPS-B-T-2132-ESAB

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

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 CWI QA Bao Qiam.

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 14E

PCMK: DP3159-001

Weld No: 395,396,397,398,399

Welder: 044824

WPS-B-P-2212-TC-U4b-FMC-1

Components; OBG 14E

PCMK: DP3174-001

Weld No: 018, 019

Welder: 066480

WPS-B-P-2212-TC-U4b-FMC-1

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 14W (see photo below)

PCMK: SEG3020BB

Weld No: 055

Welder: 066038

Weld Repair No. B-CWR2752

WPS-345-SMAW-2G(2F)-FMC-Repair -1

Components; OBG 14W

PCMK: SEG3020T

Weld No: 286,287

Welder: 067609

WPS-B-P-2114-FCM-1

Components; OBG 14W

PCMK: SEG3007L

Weld No: 066,059

Welder: 068924

WPS-B-P-2213-B-U2-FCM-1

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

Components; OBG 14W
PCMK: SEG3020L
Weld No: 050,053
Welder: 037742
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 14W
PCMK: SEG3019Z
Weld No: 006,007
Welder: 037832
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14W
PCMK: SEG3019L
Weld No: 054
Welder: 215553
Weld Repair No. B-CWR2755
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14W
PCMK: SEG3019BB
Weld No: 051
Welder: 067610
WPS-B-P-2114-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 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 14W
PCMK: SEG3020BB
Weld No: 114
Welder: 067949
WPS-B-P-2233-ESAB

Components; OBG 14W
PCMK: SEG3013M
Weld No: 001
Welder: 067876
WPS-B-P-2132-ESAB

Bay 19

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

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 Ma Gain Li.

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 Bike Path (see photo below)

PCMK: BK005A2-001

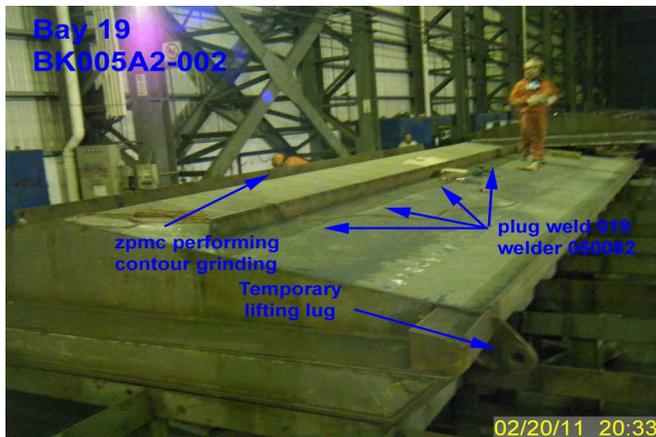
Weld No: 019,017

Welder: 050082, 062752

WPS-B-P-2112-Plug

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path BK005A2-001 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

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



WELDING INSPECTION REPORT

(Continued Page 5 of 5)

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Kelly	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
