

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-020994**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

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

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zha 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.

PCMK: SEG-3007AT

Weld No: 021 and 022

Welder: 037705

WPS-B-T-2233-ESAB

PCMK: SEG-3019BB

Weld No: 028 and 094

Welder: 070046

WPS-B-T-2132-ESAB

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

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

ZPMC QC is identified as Zha 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.

PCMK: SEG-3007L

Weld No: 066 and 069

Welder: 068924

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

PCMK: SEG-3007L

Weld No: 050 and 053

Welder: 037743

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

PCMK: SEG-3019Z

Weld No: 006 and 007

Welder: 037932

WPS-B-P-2214-TC-U4B-FCM-1

PCMK: SEG-3019Z

Weld No: 012

CWR: 2755

Welder: 066418

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

PCMK: SEG-3019Y

Weld No: 054

WR: 19720

Welder: 215553

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

PCMK: SEG-3019Z

Weld No: 014 and 015

CWR: 2755

Welder: 066418 and 067656

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

PCMK: SA-3358 to SEG-3019BB

Weld No: 051

Welder: 067610

WPS-B-P-2214-FCM-1

Bay 14 West

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

ZPMC was using the Flux Cored 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.

PCMK: SEG-3020BB

Weld No: 114

Welder: 067949

WPS-B-T-2233-ESAB

PCMK: SEG-3013

Weld No: 001

Welder: 067876

WPS-B-T-2132-ESAB

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.

PCMK: SEG-3020BB

Weld No: 055

CWR: 2752

Welder: 066038

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

PCMK: DP-3174-001

Weld No: 018

Welder: 037780

WPS-B-P-2212-TC-U4B-FCM

PCMK: DP-3174-001

Weld No: 019

Welder: 066480

WPS-B-P-2212-TC-U4B-FCM

PCMK: SEG-3020T

Weld No: 286 and 287

Welder: 067609 and 067764

WPS-B-P-2114-FCM-1

PCMK: SEG-3020BB

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Weld No: 055
CWR: 2752
Welder: 045246
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Bay 16

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 16;

BP-3095-001 and BP-3101-001

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

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 Ma Qian 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.

PCMK: BK-005A2-001

Weld No: 014

Welder: 066480

WPS-B-P-2212-Plug

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian 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.

PCMK: BK-005A2-001

Weld No: 021

Welder: 062752

WPS-B-T-2233-ESAB

PCMK: SB-027-001

Weld No: 003 and 004

Welder: 062752

WPS-B-T-2131-ESAB

Bay 28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge

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Girder (OBG) a total of approx. 150 +/- Splice Plates for U-Ribs at this location in bay 28;
This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
