

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-021793**Date Inspected:** 28-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: DP-3102-001

Weld No: 253

Welder: 044790

WPS-B-T-2233-ESAB

PCMK: SA-3067-001

Weld No: 025

Welder: 050242

WPS-B-T-2132-ESAB

PCMK: SA-3066-001

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Weld No: 013
Welder: 055564
WPS-B-T-2232-ESAB

PCMK: SA-3066-001
Weld No: 007
Welder: 055491
WPS-B-T-2232-ESAB

PCMK: SEG-3019L
Weld No: 219 and 221
Welder: 051356
WPS-B-T-2231-ESAB

PCMK: SEG-3019Q
Weld No: 206 and 214
Welder: 051356
WPS-B-T-2231-ESAB

PCMK: SEG-3019N
Weld No: 264, 265, and 273
Welder: 051356
WPS-B-T-2233-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 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-3019BB
Weld No: 169
CWR: 2737
Welder: 044779
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019X
Weld No: 100
CWR: 2615
Welder: 054013
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019X
Weld No: 099

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WR: 2614

Welder: 054013

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

PCMK: DP-3167-001

Weld No: 038

WR: 20271

Welder: 215553

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

PCMK: DP-3161-001

Weld No: 017

WR: 20250

Welder: 067610

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

PCMK: DP-3076-001

Weld No: 030

Welder: 216086

WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019Z

Weld No: 008

Welder: 067610

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

Bay 16

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 Xu Tao.

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: E5-SB24-004

Tack Weld No: 126~131

Welder: 222396

WPS-B-T-2132-ESAB

PCMK: W2-SB27-002

Tack Weld No: 013~016

Welder: 201074

WPS-B-T-2132-ESAB

PCMK: E5-SB32-001

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Tack Weld No: 044~047

Welder: 201888

WPS-B-T-2132-ESAB

PCMK: W2-SB1-001

Tack Weld No: 022~043

Welder: 201889

WPS-B-T-2132-ESAB

PCMK: W2-SB27-004

Tack Weld No: 025~078

Welder: 048625

WPS-B-T-2132-ESAB

Bay 19

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

ZPMC was using the Heat Straightening (HSR) process.

ZPMC QC is identified as Xu Tao.

Listed below are the locations that were identified by this QA inspector.

PCMK: BK-004B-001

Bottom Panel

HSR-1(B)-9501

ZPMC was observed on this date performing grinding on various welds for PCMK BK-005A-002 and BK-004A-013. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour

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



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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
