

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-021520**Date Inspected:** 06-Mar-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**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 Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13AW / Bay 14

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG Segment 13AW Grillage welds as per ZPMC notification # 08473.

The weld designations reviewed are as follows:

SA7512C-251, 243, 244, 245, 246, 247, 248, 264, 255, 256, 257, 258, 259, 260, 253, 265

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3007G-008. The welder is identified as 055564.

ZPMC Quality Control (QC) is identified as Zhong Tang Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

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OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019AP-038. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_001.

OBG Segment 13AE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3007L-011. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Zhong Tang Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019AW-100. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of repair weld # SA3067-001-014, as per B-WR # 20354. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

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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 (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
