

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-021613**Date Inspected:** 03-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #139 located on 14E, FB3260-001. Welder is identified as 050232. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

Repair welding of weld joint #147 located on 14E, SA3019E-2 as per the weld repair report# B-WR20332. Welder is identified as 069894. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-REPAIR-1. (See attached photo)

Weld joint #097 located on 14E, EP3027-001. Welder is identified as 050232. ZPMC Quality Control (QC)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1.

Repair welding of weld joint #155 located on 14E, SA3019E-2 as per the weld repair report# B-WR20332. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

Weld joint #136 located on 14E, FB2271-001. Welder is identified as 050232. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1. (See attached photo)

Weld joint #096 located on 14E, EP3027-001. Welder is identified as 050232. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1.

Repair welding of weld joint #168 located on 14E, SA3019E-2 as per the weld repair report# B-WR20332. Welder is identified as 037998. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-REPAIR-1.

Flux Cored Arc Welding (FCAW):

Weld joint #170 located on 14E, SEG3019AZ. Welder is identified as 068920. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #219 located on 13BE, SEG3019K. Welder is identified as 066439. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

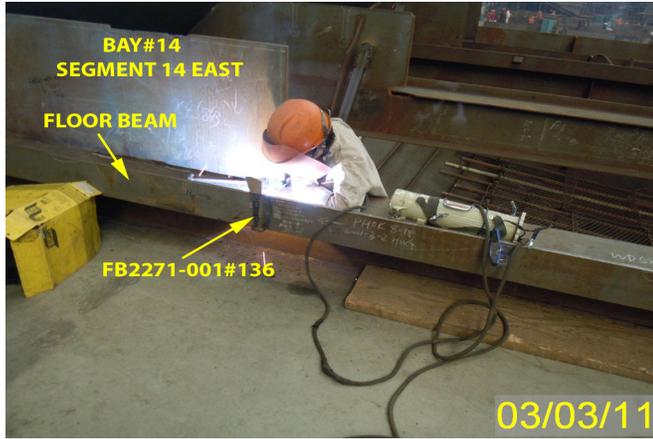
Weld joint #168 located on 14E, SEG3019AZ. Welder is identified as 068920. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #223 located on 13BE, SEG3019K. Welder is identified as 066439. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant 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: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer