

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-021703**Date Inspected:** 05-Mar-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 Shen Jian Bo, CWI Shi Zhi.

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 13 W

PCMK: SA3174-001

Weld No: 015,039,027

Welder: 048433

WPS-B-T-2233-ESAB

Components; OBG 13 W

PCMK: SA3173-001

Weld No: 017

Welder: 048696

WPS-B-T-2233-ESAB

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Components; OBG 13 W

PCMK: SA3173-001

Weld No: 015

Welder: 048433

WPS-B-T-2233-ESAB

Components; OBG 13 W

PCMK: SA3174-001

Weld No: 017,041,029

Welder: 048696

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SA8509A-001

Weld No: 038, 037

Welder: 066674

WPS-B-T-2233-ESAB

Components; OBG

PCMK: DP3138-001

Weld No: 009,010,011,016,017,018

Welder: 204730

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SEG3013Q

Weld No: 030

Welder: 067876

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SEG3020W

Weld No: 034

Welder: 047866

WPS-B-T-2231-ESAB

Components; OBG

PCMK: SEG3013B

Weld No: 263

Welder: 045143

WPS-B-T-2231-ESAB

Components; OBG

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PCMK: SEG3013AH
Weld No: 070
Welder: 203871
WPS-B-T-2231-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 Shen Jian Bo, CWI Shi Zhi.
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 13BW
PCMK: SA3231B-001
Weld No: 143,145
Welder: 066002, 066398
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13BW
PCMK: SA8509-001
Weld No: 038,037
Welder: 066674
WPS-B-P-221-B-U2-FCM-1

Components; OBG 13BW
PCMK: SEG3020AL
Weld No: 002
Welder: 051348, 045246
Weld Repair No. B-WR18585
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG
PCMK: SEG3013AA
Weld No: 091
Welder: 067764
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG
PCMK: SEG3013K
Weld No: 019
Welder: 045196
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13W
PCMK: SEG3013J

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Weld No: 005

Welder: 047864

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

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 14W. The weld designations reviewed are as follows:

DP3170-001-115~132,137~140,145~148,153~156,065~082, 087~090,095~098,103, 106,031~034,039~042, 047, 050,055,058,063, 064,

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

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
