

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-021918**Date Inspected:** 02-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:** An Qing Xiang**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 day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 066443 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015C-008. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. This QA Inspector noted welding variables were 134~145 amperes and 24 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 045213 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13BW. Weld joint is identified as SEG3014G-008. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. This QA Inspector noted welding variables were 142~150 amperes and 23.2 volts, which appears to be in compliance with the approved WPS.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC qualified welding personnel identified as 037996 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate I-Rib to I-Rib weld of OBG Segment 13CW. Weld joint is identified as SEG3015G-148. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. This QA Inspector noted welding variables were 138~145 amperes and 25.5 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 037996 perform welding by Shielded Metal Arc Welding (SMAW), on Corner assembly to Floor beam weld of OBG Segment 13CW. Weld joint is identified as SEG3015E-136, 137. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. This QA Inspector noted welding variables were 141~155 amperes and 22.8 volts, which appears to be in compliance with the approved WPS. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066443 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015J-012. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. This QA Inspector noted welding variables were 147~160 amperes and 25.3 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 045213 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015L-012. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. This QA Inspector noted welding variables were 135~145 amperes and 24.1 volts, which appears to be in compliance with the approved WPS.

This QA Inspector observed ZPMC qualified welding personnel identified as 066912, 045143 perform welding by Flux Cored Arc Welding (FCAW), on Edge plate to Side plate weld of OBG Segment 13AW. Weld joint is identified as SEG3013AA-113, 114. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB. This QA Inspector noted welding variables were 291~305 amperes and 25.8 volts, which appears to be in compliance with the approved WPS.

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 significant 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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