

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-021928**Date Inspected:** 13-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:**

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 Zhong Yong Gang.

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-3007AH

Weld No: 166

Welder: 055491

WPS-B-T-2232-ESAB

PCMK: SEG-3007Y

Weld No: 352 and 362

Welder: 050242

WPS-B-T-2231-ESAB

PCMK: DP-3001

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Weld No: 005 and 006
Welder: 055491
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 Zhong Yong Gang.
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-3009C
Weld No: 002 and 003
Welder: 070006
WPS-B-P-2213-B-U2-FCM-1

PCMK: SEG-3009J
Weld No: 002 and 003
Welder: 069493
WPS-B-P-2213-B-U2-FCM-1

PCMK: SEG-3007AH
Weld No: 007
Welder: 037748
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3007AH
Weld No: 030
WR: 19454
Welder: 054013
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Guo Xing Hui.
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: W5-SB32-001
Weld No: 007, 008, 011, and 012
Welder: 201905
WPS-B-P-2113

This QA Inspector observed the following work in progress for Bay 16.

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ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

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: E2-SB23-003

Weld No: 001, 002, 005, 006, 009, and 010

Welder: 201888

WPS-2132-ESAB

PCMK: E2-SB23-002

Weld No: 001, 002, 005, 006, 009, and 010

Welder: 062092

WPS-2132-ESAB

PCMK: E2-SB23-001

Weld No: 100~105, 116~121 and 126~131

Welder: 048625

WPS-2132-ESAB

WPS-2133-ESAB

PCMK: E2-SB31A-001

Weld No: 100~105

Welder: 201889

WPS-2133-ESAB

PCMK: W2-SB18-002

Weld No: 019, 050, 081

Welder: 222396

WPS-2132-ESAB

PCMK: W5-SB41B-001

Weld No: 094~099 and 110~115

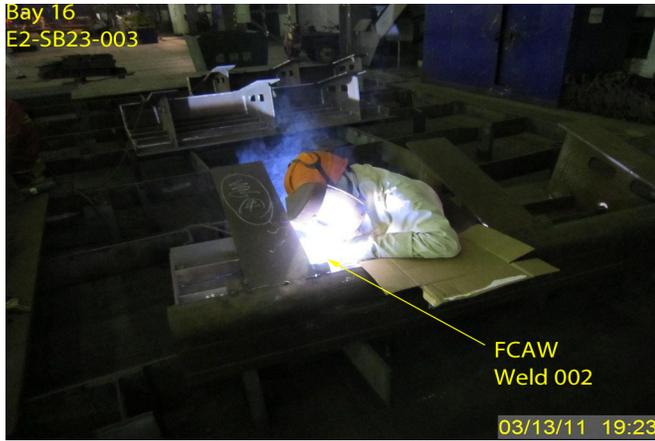
Welder: 201074

WPS-B-T-2132-ESAB

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
