

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-021946**Date Inspected:** 10-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:** Sha Zhi**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, DJ Shin was present during the times noted above for 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 Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013L-019

Welder: 045143

WPS-B-T-2233-ESAB

PCMK: SEG3013L-025

Welder: 066421

WPS-B-T-2233-ESAB

Components: 14W

PCMK: SEG3020AY-117~127

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Welder: 204730
WPS-B-T-2233-ESAB

PCMK: SEG3020AJ-403,464
Welder: 067949
WPS-B-T-2233-ESAB

PCMK: SEG3020AT-220
Welder: 045175
WPS-B-T-2233-ESAB

PCMK: SEG3020B-054
Welder: 047866
WPS-B-T-2233-ESAB

Components: Saddle Support sub-assembly
PCMK: SA8509-001-005,006
Welder: 215676
WPS-B-T-2132-ESAB

PCMK: SA8509-001-028
Welder: 048696
WPS-B-T-2132-ESAB

PCMK: SA7531-001-002
Welder: 048433
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhu Lin.

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: 13AW
PCMK: SEG3013K-121
Welder: 067829
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG3013D-149
Welder: 045196
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG3013D-131

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Welder: 067609

WPS-B-P-2214-TC-U4b-FCM-1

Components: 14AW

PCMK: SEG3020AL-279

Welder: 045246

Report: B-WR20374

WPS-345-SMAW-3G (3F)-FCM-repair

PCMK: SEG3020AL-087

Welder: 051248

Report: B-WR20371

WPS-345-SMAW-3G (3F)-FCM-repair

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

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: Shin,DJ

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer