

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-021975**Date Inspected:** 09-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: DP3173-001

Weld No: 138,139

Welder: 048433

WPS-B-T-2132-ESAB

Components; OBG 13 W

PCMK: SA3231D-001

Weld No: 024

Welder: 048696

WPS-B-T-2232-ESAB

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Components; OBG 13 W
PCMK: SEG3020AJ
Weld No: 355,356
Welder: 067949
WPS-B-T-2233-ESAB

Components; OBG 13 W
PCMK: SEG3020AJ
Weld No: 286
Welder: 045175
WPS-B-T-2232-ESAB

Components; OBG 13 W
PCMK: SEG3013G
Weld No: 019,020
Welder: 203871
WPS-B-T-2233-ESAB

Components; OBG 13 W
PCMK: SEG3013J
Weld No: 006,007,010
Welder: 066421
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Submerged Arc Welding (SAW) 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: SEG3007
Weld No: 001
Welder: 050502
WPS-b-t-2221-B-L2C-S-2

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 13 W

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PCMK: SA3173-001
Weld No: 015
Welder: 066022
Weld Repair No. WR10730
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 13 W
PCMK: SA3173-001
Weld No: 035
Welder: 067520
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13 W
PCMK: SA3173-001
Weld No: 017
Welder: 066398
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13 W
PCMK: SEG3013H
Weld No: 163
Welder: 067764
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13 W
PCMK: SEG3013F
Weld No: 100
Welder: 066459
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13 W
PCMK: SEG3013M
Weld No: 065
Welder: 067829
WPS-B-P-2213-B-U2-FCM-1

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, CWI Bao Gian.
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 14BE
PCMK: SEG3019G

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Weld No: 013,014,015
Welder: 215553
Weld Repair No. B-CWR2755
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14BE
PCMK: SEG3019M
Weld No: 256,257,258,259
Welder: 044779
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14BE
PCMK: SEG3019AQ
Weld No: 039,043,046,051
Welder: 044779
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14BE
PCMK: SEG3019P
Weld No: 236~245
Welder: 056013
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14BE
PCMK: SEG3019AA
Weld No: 028
Welder: 216086
Weld Repair No. B-CWR2755
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14BE
PCMK: SEG3019Z
Weld No: 012
Welder: 050969
Weld Repair No. B-CWR2755
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14BE
PCMK: SEG3007
Weld No: 007
Welder: 037748
WPS-B-P-2214-TC-U4b-FCM-1

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

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

ZPMC QC is identified as Zhong Yong Gang, CWI Bao Gian.

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 14BE

PCMK: SEG3019AZ

Weld No: 250

Welder: 066733

WPS-B-T-2233-ESAB

Components; OBG 14BE

PCMK: SA3013-001

Weld No: 010

Welder: 051356

WPS-B-T-2232-ESAB

Components; OBG 14BE

PCMK: SA3007AH

Weld No: 039,087,097,107,117

Welder: 055491

WPS-B-T-2231-ESAB

Components; OBG 14BE

PCMK: SA3007AH

Weld No: 061,089,099,109,117

Welder: 050242

WPS-B-T-2231-ESAB

Components; OBG 14BE

PCMK: SA3007Q

Weld No: 326

Welder: 055564

WPS-B-T-2233-ESAB

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

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your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer