

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-022006**Date Inspected:** 10-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:** Geng Wei**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 date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) 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

Shielded Metal Arc Welding (SMAW):

Weld joint #052 located on Deck Panel DP3096-001. Welder is identified as 066268. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-2.

Weld joint #051 located on Deck Panel DP3096-001. Welder is identified as 066268. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-2.

Repair welding of a weld joint #029 located on saddle support beam SA3173-001 as per the weld repair report#B-WR10720. Welder is identified as 037996. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR.

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Repair welding of a weld joint #013 located on saddle support beam SA3174-001 as per the weld repair report#B-WR10721. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-REPAIR.

Repair welding of a weld joint #019 located on saddle support beam SA3173-001 as per the weld repair report#B-WR10720. Welder is identified as 037996. ZPMC Quality Control (QC) Inspector is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-REPAIR. (See attached photo)

Flux Cored Arc Welding (FCAW):

Weld joint #071 located on Deck Panel DP3097-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #442 located on SA3013-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB. (See attached photo)

Weld joint #055 located on Deck Panel DP3096-001. Welder is identified as 067079. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #446 located on SA3013-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #025 located on Deck Panel DP3097-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #447 located on SA3013-001. Welder is identified as 052696. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

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

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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: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer