

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-022333**Date Inspected:** 30-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 Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.

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 14 W

PCMK: SEG3020BB

Weld No: 020

Welder: 025246

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

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 074

Welder: 069846

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

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Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 011
Welder: 066674
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 056
Welder: 066398
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020AV
Weld No: 006
Welder: 067609
WPS-B-P-2214-TC-U4b-FCM-1

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 Wong Xiang Pin, CWI Wang Jun.
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 Traveler Rail
PCMK: TR3004TRI-001
Weld No: 003,005
Welder: 201215
WPS-B-T-2231-ESAB

Components; OBG 14 W Traveler Rail
PCMK: TR3003TRI-001
Weld No: 003.005
Welder: 066398
WPS-B-T-2232-ESAB

Components; OBG 14 W Traveler Rail
PCMK: TR3007TRI-001
Weld No: 056
Welder: 066398
WPS-B-T-2232-ESAB

Heat straightening of PCMK, DP3173-1 under approved Heat Straightening procedure, HSR1 (B)-10124. The in

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process temperature was observed as 550°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 4mm.

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.

Components; OBG Steel Barrier

PCMK: SB30A-001

Weld No: 021

Welder: 201905

WPS-B-T-2212-ESAB

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in SB25D-002 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed at random intervals ZPMC fabricating guard rails for the Oakland / San Francisco Bay Bridge piece number FS2-3. This QA Inspector also observed contour grinding and of visual indications as identified by ZPMC QC Inspectors. (see photo below)

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

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.

Components; OBG Suspender Bracket

PCMK: SA6530-001

Weld No: 108,088

Welder: 062783

WPS-B-T-2233-ESAB

Components; OBG Suspender Bracket

PCMK: SA6029-001

Weld No: 030

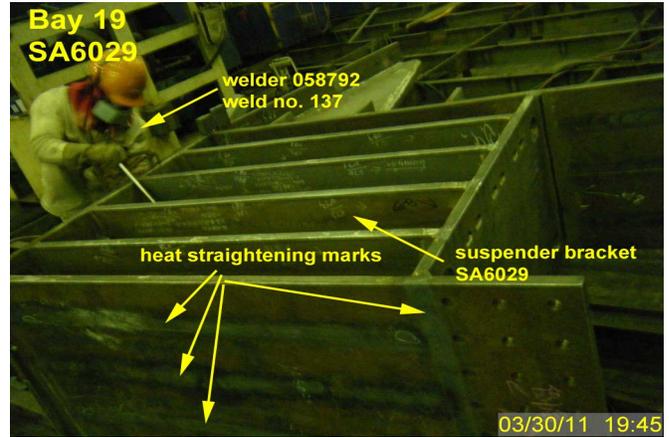
Welder: 059792

WPS-B-T-2233-ESAB

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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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
