

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-022344**Date Inspected:** 10-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 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 14 E

PCMK: SEG3019N

Weld No: 106,107

Welder: 054013, 216086

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14 E

PCMK: SEG3019Q-1

Weld No: 133,135,137,157

Welder: 054013, 216086

WPS-B-P-2213-TC-U4b-FCM-1

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Components; OBG 14BE
PCMK: SA3013-001
Weld No: 004
Welder: 043661
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13AE
PCMK: KP3001-001
Weld No: 009,010,011,012
Welder: 037748
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 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 14 E
PCMK: SEG3019B
Weld No: 029,030,031
Welder: 066733
WPS-B-T-2233-ESAB

Components; OBG 13BE
PCMK: SA30013H-001
Weld No: 081,082
Welder: 052696
WPS-B-T-2133-ESAB

Components; OBG 13AE
PCMK: SEG3007AH
Weld No: 037,164,095
Welder: 050242
WPS-B-T-2231-ESAB

Components; OBG 13AE
PCMK: SEG3007AH
Weld No: 039,087,097
Welder: 055491
WPS-B-T-2231-ESAB

Components; OBG 13AE

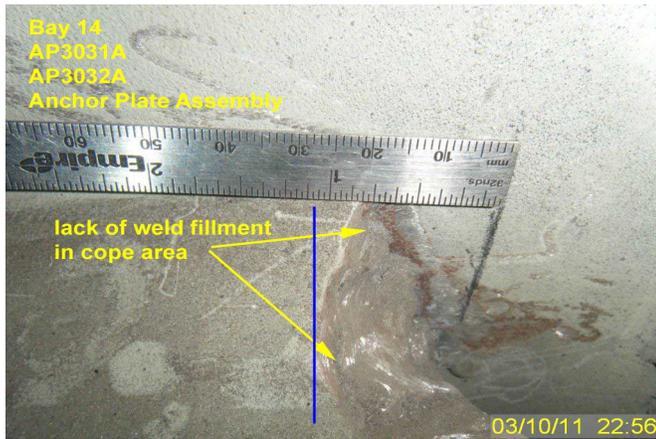
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PCMK: SEG3007N
Weld No: 034
Welder: 055564
WPS-B-T-2233-ESAB

This QA Inspector performed document review for information requested by James Devy, and the Office of Structural Materials. This information request addresses OBG 14 west and 14 east anchorage plate assembly AP3031 and AP3032. This QA Inspector performed random visual inspections of the weld size, cope hole size and condition listed in the information request. It appears to this QA Inspector ZPMC has completed the welds as referenced in the request. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive. (see photo below)

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 your project.

Inspected By:	Leavitt, Kelly	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
