

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026371**Date Inspected:** 23-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:** Lv Li Qing**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, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

WELDING**OBG Bay 14**

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AY-289 located on the OBG Segment 14W. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2212-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020AY-313 located on the OBG Segment 14W. The welder is identified as 037779. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with

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WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AG-009 located on edge plate of the OBG Segment 14W. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020BB-011 located on SA to Anchor plate of the OBG Segment 14W. The welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020BB-024 located on SA to Anchor plate of the OBG Segment 14W. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020BB-047 located on SA to Anchor plate of the OBG Segment 14W. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020BD-006 located on the OBG Segment 14W. The welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3153-001-127 located on deck plate at PP122.5 of the OBG Segment 13CW. The welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3153-001-041 located on deck at PP124 plate of the OBG Segment 13CW. The welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. For more details please see attached photo "A" below:

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AG-003 located on floor Beam to Edge Plate of the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20428. For more details please see attached photo "B" below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

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contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
