

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-026373**Date Inspected:** 21-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.

OBG Bay 14

WELDING

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020L-009 located on the OBG Segment 14W. The welder is identified as 067758. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3168-001-043 located on deck plate of the OBG Segment 14W. The welder is identified as 205098. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Tc-U4b-FCM-1.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AG-063 located on the OBG Segment 14W. The welder is identified as 045246. 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 Seg3020BB-002 located on the OBG Segment 14W. The welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Submerged Arc welding (SAW)

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as Seg3020AQ-030 located on deck plate of the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as Seg3020*-001 located on deck plate of the OBG Segment 14W. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020*-001 located on deck plate of the OBG Segment 14W. The welder is identified as 048696. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3014G-014 located on the OBG Segment 13CW. The welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

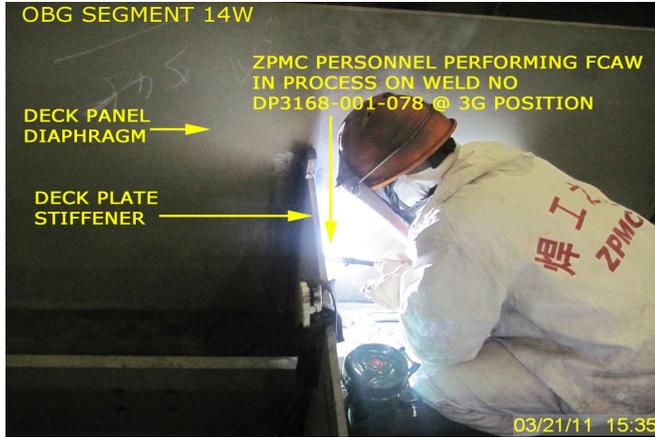
This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SA3416-001-057 located on deck plate of the OBG Segment 13BW. The welder is identified as 047866. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3168-001-078 located on deck panel diaphragm to stiffener of the OBG Segment 14W. The welder is identified as 068494. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB. For more details please see attached photo below:

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