

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-023220**Date Inspected:** 02-May-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 Caltrans QA Inspector during random observation at ZPMC noted that gouging was being performed, in preparation for weld repairs, using the Carbon Arc Cutting (CAC) process on BK016-001, Bike Path Support Arm. Also noted at this location was ZPMC grinding these back gouge areas to a bright metal finish in preparation for the welding process as outlined in the contract documents. (see photos below)

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Segment X3305K-041,047,043, and 049 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.

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 13AE

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

PCMK: SEG3007Y
Weld No: 424
Welder: 044772
Weld Repair No. B-WR20637
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13AE
PCMK: SEG3007
Weld No: 010
Welder: 067589
Weld Repair No. B-CWR2926
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 13AE
PCMK: SEG3007N
Weld No: 194
Welder: 068924
Weld Repair No. B-WR20731
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E
PCMK: SEG3019AH
Weld No: 003
Welder: 044779
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3019AH
Weld No: 002
Welder: 215553
WPS-B-T-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.
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 13AE
PCMK: SEG3007P
Weld No: 075
Welder: 055491
WPS-B-T-2232-ESAB

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

Components; OBG 13BE
PCMK: SEG3009C
Weld No: 005
Welder: 050977
WPS-B-T-2231-ESAB

Components; OBG 13CE
PCMK: SEG3009E
Weld No: 005
Welder: 066687
WPS-B-T-2232-ESAB

Components; OBG 14E
PCMK: SEG3019Q
Weld No: 074,077
Welder: 055564
WPS-B-T-3132-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wong Zhu and QA Cas Hai Zhon.

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 13CW (see photo below)
PCMK: SA3126
Weld No: 005~007
Welder: 045143
WPS-B-T-2231-ESAB

Components; OBG 13CW
PCMK: SA3126
Weld No: 020~025
Welder: 045280
WPS-B-T-2231-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shi Lei and QA Cas Hai Zhon.

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 13CW
PCMK: SEG3015K
Weld No: 209~220

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

Welder: 045196
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14W
PCMK: SEG3020U
Weld No: 591
Welder: 045246
Weld Repair No. B-CWR2943
WPS-345-SMAW-4G(4F)-FCM-1

Components; OBG 14W
PCMK: SEG3020AH
Weld No: 002,003,004
Welder: 066673, 066674
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14W
PCMK: SEG3020D
Weld No: 018,019
Welder: 067942
WPS-B-P-2114-FCM-1

Components; OBG 14W
PCMK: SEG3020B
Weld No: 236,137
Welder: 037779
WPS-B-P-2213-FCM-1

Components; OBG 13AW
PCMK: SEG3013M
Weld No: 188
Welder: 066109
Weld Repair No. B-WR20695
WPS-345-SMAW-3G(3F)-FCM-1

Components; OBG 13AW
PCMK: SEG3013P
Weld No: 198,203,208
Welder: 067904
Weld Repair No. B-WR20695
WPS-345-SMAW-4G(4F)-FCM-1

Components; OBG 13AW
PCMK: SEG3013M

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

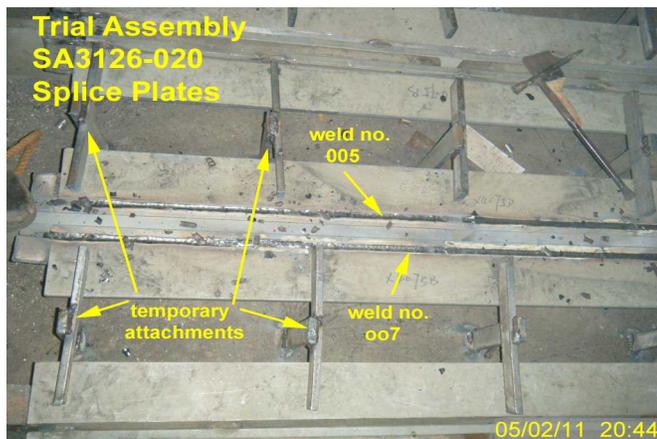
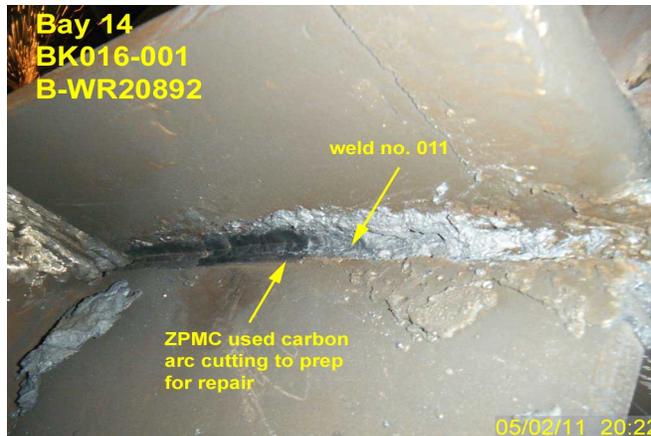
Weld No: 093,099,105

Welder: 067864

Weld Repair No. B-WR20695

WPS-345-SMAW-4G(4F)-FCM-1

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
