

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017680**Date Inspected:** 01-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 11CW-11DW, SP-SP, CW side.

SMAW welding of weld joint OBW11C-002; located at Trial assembly yard. Welders are identified as 040609, 040709; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2233T-1.

Trial assembly yard, 11CW-11DW, DP-EP, CW side.

SMAW welding of weld joint CA085-006, CA089-002; located at Trial assembly yard. Welder is identified as 046709; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Trial assembly yard, 11CW-11DW, Bottom Panel T-rib Hold back.

SMAW welding of weld joint BP107-001-020, 021, 022; located at Trial assembly yard. Welder is identified as 044351; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

Trial assembly yard, 11CE-11DE, BP-SP, Cross beam side.

SMAW welding of weld joint SEG070A-011, SEG072A-021; located at Trial assembly yard. Welder is identified as 500363; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables

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recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-WPS-B-P-2214-B-U2-FCM-1.

Trial assembly yard, 11BE-11CE, DP-DP, Repair after removal of temporary attachment area.

SMAW Critical base metal Repair welding (CWR# B-CWR1957); located at Trial assembly yard. Welder is identified as 040320; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The attached photographs provide additional detail.

Trial assembly yard, 11CW-11DW, DP-A1.

SAW welding of weld joint OBW11A-003; located at Trial assembly yard. Welders are identified as 044560, 042195; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-223(2)1T-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 Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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