

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-018641**Date Inspected:** 10-Nov-2010**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:** Chen Xi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

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

ZPMC QC is identified as Ai Wei.

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: Barrier Rail

PCMK: E2-SB1-034-126,127

Welder: 216872

WPS-B-T-2132-3

PCMK: E2-SB5-030-128,129

Welder: 215082

WPS-B-T-2132-3

PCMK: E2-SB5-027-094,095

Welder: 203710

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WPS-B-T-2132-3

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

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

ZPMC QC is identified as Zhu Jun.

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: Floor Beam

PCMK: FB3343-001-128

Welder: 066912

WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-238

Welder: 066236

WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-077

Welder: 066701

WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-020

Welder: 066734

WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-114

Welder: 068445, 067942

WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-064

Welder: 066239

Report: B-WR15585

WPS-345-FCAW-3G (3F)-Repair

Components: Anchor Plate

PCMK: AP3032-001-998,999

Welder: 068596

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-184,185

Welder: 045276

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

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PCMK: AP3032-001-526,527

Welder: 207465

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-479,480

Welder: 062708

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

Components: Longitudinal Diaphragm

PCMK: LD3048-001-181,101

Welder: 048696

WPS-B-T-2232-TC-U4b-F

PCMK: LD3048-001-043,047

Welder: 045209

WPS-B-T-2232-TC-U4b-F

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; VP3014-001, Item number 1 of NWIT tracker document # 07306

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

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

ZPMC QC is identified as Zhu Jun.

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: Floor Beam

PCMK: FB3286-001-294

Welder: 055491

WPS-B-T-2232-TC-U5-F

PCMK: FB3286-001-308

Welder: 050242

WPS-B-T-2232-TC-U5-F

PCMK: FB3286-001-320

Welder: 044830

WPS-B-T-2232-TC-U5-F

PCMK: FB3286-001-171

Welder: 052696

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WPS-B-T-2232-TC-U5-F

Components: Longitudinal Diaphragm

PCMK: LD3040-001-077,079

Welder: 206623

WPS-B-T-2233-TC-U4b-F

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

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

ZPMC QC is identified as Zheng Zhi Wei.

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.

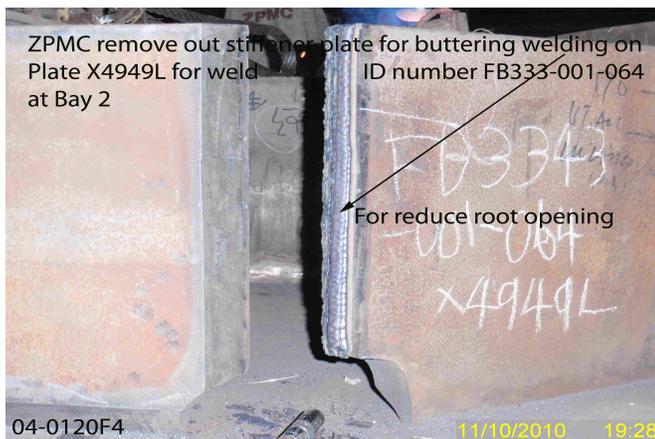
Components: Bike Path

PCMK: BK004A4-060-040,041

Welder: 500403

WPS-B-T-2132

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 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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