

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-018854**Date Inspected:** 24-Dec-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:** Tian Lei**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 performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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; Barrier Rail, on item number 1~2 of NWIT tracker document # 07917,

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhong Guo Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Segment 14E

PCMK: SEG-3019E-1-184,188

Welder: 044824

WPS-B-T-2233-ESAB

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PCMK: SEG-3019V-029
Welder: 068994
WPS-B-T-2233-ESAB

PCMK: SEG-3019L-1-246,250
Welder: 066283
WPS-B-T-2233-ESAB

PCMK: SEG-3019L-1-088
Welder: 066733
WPS-B-T-2233-ESAB

PCMK: SEG-3019AA-025
Welder: 066071
WPS-B-T-2232-ESAB

Components: Segment 13BE
PCMK: SEG-3009C-189
Welder: 052696
WPS-B-T-2233-ESAB

PCMK: SEG-3009J-218
Welder: 066041
WPS-B-T-2233-ESAB

Components: Segment 13CE
PCMK: SEG-3007L-021,022,023,024
Welder: 055564
WPS-B-T-2133-ESAB

PCMK: SEG-3007L-017,018
Welder: 050242
WPS-B-T-2133-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Guo Hui.
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: Segment 13BE
PCMK: SEG-3009G-194
Welder: 068091
WPS-B-P-2214-TC-U4b-FCM

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PCMK: SEG-3009J-212,213
Welder: 067571
WPS-B-P-2214-TC-U4b-FCM

Components: Segment 13CE
PCMK: SEG-3011V-002
Welder: 069683
WPS-B-P-2214-TC-U4b-FCM

Components: Segment 14E
PCMK: SEG-3019BB-103
Welder: 058102
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019BB-169
Welder: 048407
WPS-B-P-2212-TC-U4b-FCM-1

Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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; various PCMK on item number 1~3 of NWIT tracker document # 07915,

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.

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