

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-018996**Date Inspected:** 30-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 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 Geng Wei.

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 13AE

PCMK: SEG3007M-137,140

Welder: 050242

WPS-B-T-2233-ESAB

Components: Segment 13BE

PCMK: SEG3019V-002

Welder: 052696

Report: B-WR19705

WPS-345-FCAW-2G (2F)-FCM-ESAB-Repair

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Components: Segment 14E

PCMK: SEG3019Q-1-047

Welder: 066471

WPS-B-T-2233-ESAB

PCMK: SEG3019D-1-178

Welder: 068994

WPS-B-T-2233-ESAB

PCMK: SEG3019AL-002

Welder: 066733

WPS-B-T-2233-ESAB

PCMK: SEG3019X-099

Welder: 044824

Report: B-WR19578

WPS-345-FCAW-2G (2F)-FCM-ESAB-Repair

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 Geng 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: Segment 13AE

PCMK: SEG-3007Y-007,008

Welder: 200113

WPS-B-P-2114-FCM-1

PCMK: FB3122A-001-015,016

Welder: 044779

Report: B-WR 18309

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

PCMK: SEG3007K-039

Welder: 054013

Report: B-WR 19132

WPS-345-SMAW-2G (2F)-FCM-Repair

Components: Segment 14E

PCMK: LD3040A

Welder: 058102

Report: B-CWR 2596

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

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PCMK: LD3042A
Welder: 048047
Report: B-CWR 2596
WPS-345-SMAW-1G (1F)-FCM-Repair

PCMK: LD3043A
Welder: 201087
Report: B-CWR 2596
WPS-345-SMAW-1G (1F)-FCM-Repair

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
