

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019143**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**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 13 & 14**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Wai Pau was present during the times noted above for observations relative to the work being performed.

Submerged Arc Welding (SAW) process in the 1G position of desk plate components of lift 13AW. The welder is identified as #051348. The weld designation is SEG3013AD-034. ZPMC QC is identified as Mr. Li Ming Yang, Wang Jie and Wang Chao. The welding variables recorded by QC appeared to comply with Caltrans approved WPS.

Shielded Metal Arc Welding (SMAW) CJP weld process in the tack weld 3G position of the longitudinal diaphragm (LD) components of lift 13AW. The welder is identified as #045246. The weld designation is SEG3013P-095/097/099 is identified as Mr. Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-BV2-FCM.

Flux Cored Arc Welding (FCAW) process in the 3G, 3F position of the floor beam (FB) and longitudinal diaphragm (LD) components of lift 13E. The welder is identified as #047866, 066421, 045175, 067520, 066421 and 201215. The weld designation is SEG3013Q-235/236/215/216/221/222, SEG3013S-173/181, SEG3013AA-094/140/095/139/096/128/197/127 and SEG3013C-100/103/104. ZPMC QC identified as ZPMC QC Mr. Li Shi Kon, Wrong Shan, and Liu Dao Feng. The welding variables recorded by QC appeared to comply with Caltrans approved WPS -B-T-2133-EASB, WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

As notes within report above

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 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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