

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019273**Date Inspected:** 16-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Yan Hua**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 Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 13

This QA Inspector observed the following work in progress for Bay 13.

ZPMC was using the Shielded 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.

PCMK: SA-7038C

Weld No: 228 and 231

CWR: 2756

Welder: 216086

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

PCMK: SA-7038C

Weld No: 235, 237, and 238

WR: 19722

Welder: 215553

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

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Bay 14 West

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

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Xiang Pin.

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.

PCMK: SEG-3015

Weld No: 001

Welder: 250050

WPS-B-T-2221-B-L2C-S-2

Bay 14 East

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

ZPMC was using the Flux Cored 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 Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007AY

Weld No: 050

Welder: 066733

WPS-B-T-2233-ESAB

PCMK: SEG-3007AY

Weld No: 052

Welder: 066733

WPS-B-T-2232-ESAB

PCMK: SEG-3019AG

Weld No: 002

Welder: 066763

WPS-B-T-2233-ESAB

PCMK: SEG-3007Q-1

Weld No: 227, 229, 231, 233, and 235

Welder: 037723

WPS-B-T-2233-ESAB

Bay 14 East

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Guo Hui.

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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.

PCMK: SEG-3019X
Weld No: 087, 089, and 147
Welder: 067571
WPS-B-P-2112-FCM-1

PCMK: SEG-3019L-1
Weld No: 001
WR: 19631
Welder: 066416
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3019L-1
Weld No: 085
WR: 19737
Welder: 067656
WPS-345-SMAW-3G(3F)-FCM-Repair

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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: Rice, Brett

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer