

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-019281**Date Inspected:** 05-Jan-2011**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:** Sha Zhi**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 Lv Li Qing.

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: SEG3007E-036,041

Welder: 067877

WPS-B-T-2233-ESAB

PCMK: SEG3007M-101,106

Welder: 055564

WPS-B-T-2233-ESAB

Components: Segment 14AW

PCMK: SEG3013E-115

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Welder: 045240
WPS-B-T-2233-ESAB

PCMK: EP3020E to FB3193
Welder: 045280
WPS-B-T-2233-ESAB

Components: Segment 14W
PCMK: SEG3020R-034
Welder: 066421
WPS-B-T-2233-ESAB

PCMK: SEG3020M-019
Welder: 201215
WPS-B-T-2233-ESAB

PCMK: SEG3020Y-032
Welder: 066239
Report: B-CWR2666
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 Lv Li Qing.
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: SEG3007AT-030
Welder: 215553
Report: B-WR19149
WPS-345-SMAW-2G (2F)-FCM-Repair

PCMK: SEG3007AT-069
Welder: 200113
Report: B-WR19148
WPS-345-SMAW-2G (2F)-FCM-Repair

PCMK: SEG3007AT-043
Welder: 216086
Report: B-WR19150
WPS-345-SMAW-2G (2F)-FCM-Repair

PCMK: SEG3007F-034

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Welder: 054013
Report: 19062
WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: Segment 13BE
PCMK: SEG3009G-214
Welder: 067571
Report: B-WR19182
WPS-345-SMAW-2G (2F)-FCM-Repair

Components: Segment 13CE
PCMK: SEG3011L-249
Welder: 68097
WPS-B-P-2211-TC-U4b-FCM-1

Components: Segment 13CW
PCMK: SEG3015H-205
Welder: 045196
Report: B-WR 18942
WPS-345-SMAW-1G (1F)-Repair

Components: Segment 14E
PCMK: SEG3019BB-189
Welder: 201807
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3019BB-167
Welder: 048047
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3019BB-101
Welder: 058102
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3019L-001
Welder: 044830
Report: B-CWR2668
WPS-345-SMAW-2G (2F)-FCM-Repair

Components: Architectural Housing
PCMK: AH3001-044,045
Welder: 067572
WPS-B-P-2213-TC-U4b-FCM-1

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PCMK: AH3001-002,003
Welder: 045133
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SA8515-001
Welder: 067572
WPS-B-P-2211-B-U2-FCM-1

Components: Sub Assembly Grillage
PCMK: SA7512C-251
Welder: 066398
Report: B-CWR2629
WPS-345-SMAW-1G (1F)-FCM-Repair

PCMK: SA7512C-245
Welder: 067588
Report: B-CWR2631
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.

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Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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