

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-019545**Date Inspected:** 29-Nov-2010**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:** See below**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

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 Sun Tian Liang.

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.

Component; OBG 13CE

PCMK: SEG3015F

Weld No: 327

Welder: 045143

WPS-345-FCAW-2G(2F)-ESAB-Repair-1

Repair No. WR17581 (see picture)

Component; OBG 13CE

PCMK: SEG3014P

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld No: 037
Welder: 201583
WPS-345-FCAW-2G(2F)-ESAB-Repair-1
Repair No. WR17583

Component; OBG 13CE
PCMK: SEG3013AP
Weld No: 043,044,046,111,117,130,005,007,077,079,069,071,081,083,073,075,085,087,089,091,093
Welders: 069682, 041596
WPS-B-T-2232-ESAB

Component; OBG 13CE
PCMK: SEG3015F
Weld No: 003
Welder: 066739
WPS-B-T-2232-ESAB

Component; OBG 13CE
PCMK: SEG3013K
Weld No: 005~007
Welder: 069043
WPS-B-T-2233-TC-U4b-F (see picture)

Component; OBG 13CE
PCMK: SEG3020
Weld No: 009
Welder: 045265
WPS-B-T-2231-B-L2c-5-2

Component; OBG 13CE
PCMK: SEG3020
Weld No: 003
Welder: 202122
WPS-B-T-2231-ESAB

Component; OBG 13CE
PCMK: DP3135-001
Weld No: 061,062,051,052,178,177,145,146,
Welder: 203871
WPS-B-T-2132-ESAB

Component; OBG 13CE
PCMK: DP3136-001
Weld No: 019,020,083,084,108,109,148,149

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Welders: 207465, 048696

WPS-B-T-2132-ESAB

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

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

ZPMC QC is identified as Sun Tian Liang.

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.

Component; OBG 13CE

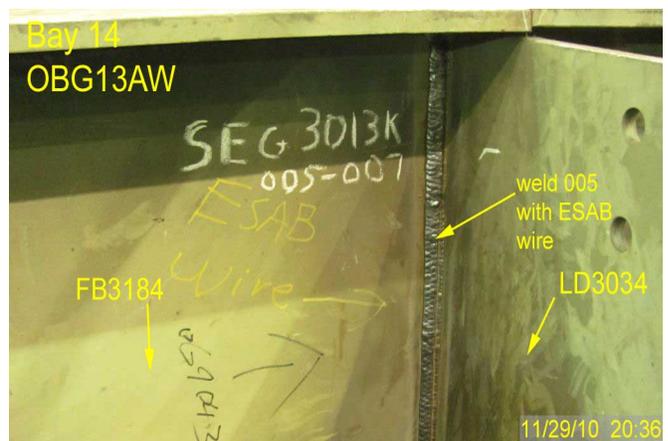
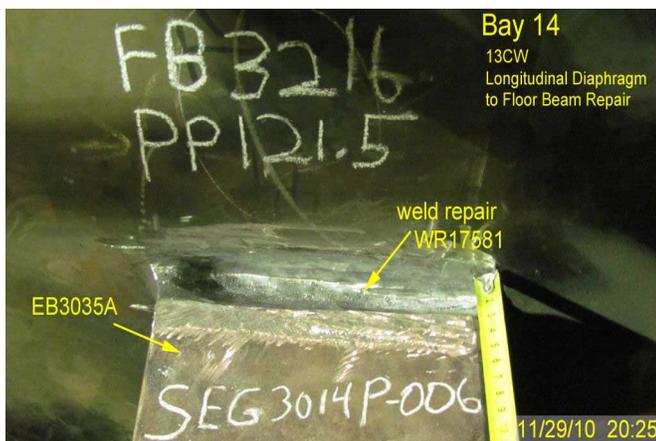
PCMK: FB3197 to LD3032

Weld No: fit up

Welder: 049972

WPS-B-T-2213

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



Summary of Conversations:

No significant 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: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
