

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-019568**Date Inspected:** 01-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.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Shao Hai Lang.

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; Cover Plates for Tower Lift 5

PCMK: WSD1-TL54-B/F-48E

Welder: 040699

WPS-B-T-3221-B-U30-S-1

This QA inspector observed in Bay 10 that ZPMC was performing weld repairs on weld number BK005B-004-043.

It was determined that ZPMC had excavated 100% of the 16mm plate. ZPMC had weld repair B-WR 16450 for this location. It was relayed to the ZPMC CWI that Critical Weld Repair (CWR) was required for this location due to the excavation was greater than 65% of the weld depth as required by the contract documents. The CWI stated that ZPMC would submit the CWR tomorrow (11-2-10) for the engineer's approval.

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This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Shao Hai Lang.

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; Bike Path

PCMK: BK004C-024,018

Welder: 205649

WPS-B-T-2231-B-L1B-F

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

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

ZPMC CWI is identified as Fu Guo Gang.

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; Bike Path

PCMK: BK004A1-030-044

Welder: 057239

WPS-B-T-2214-TC-U5B

Component; Bike Path

PCMK: BK004A6-025-63

Welder: 054547

WPS-B-P-2312-TC-P4

Bay 14

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 Li Ming Yang, CWI Lv Liqing.

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; Section 13AW

PCMK: LD3034 (north side) and LD 3021 (south side)

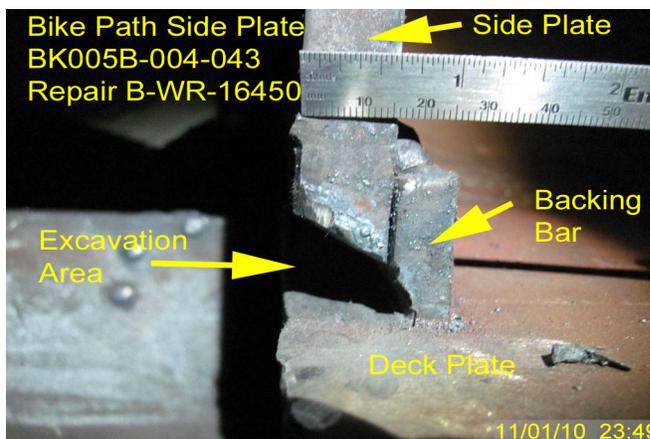
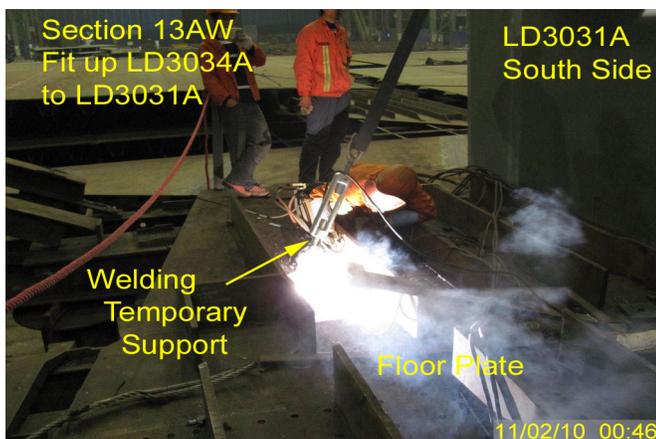
Welder: 049972

WPS-B-P-2112

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

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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.

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Inspected By:	Leavitt, Kelly	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
