

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-019577**Date Inspected:** 08-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:** 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 3

This Caltrans QA Inspector observed ZPMC using Carbon Arc Cutting (CAC) to excavate welds then grinding to bright metal of these welds in preparation for weld repairs.

Bay 28

This Caltrans QA Inspector observed at random intervals ZPMC performing match drilling of bolt holes for U-Rib splice plates on piece numbers SA3114D-047, 048, 049 and 050.

This QA Inspector observed ZPMC using the Flux Core Arc Welding (FCAW) process, using ESAB wire, for fit up on U-Rib splice plates SA3400A-032 and 033. This ZPMC welder was identified as tack welder 054416, WPS-B-P-2132-ESAB, and welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification.

This Caltrans QA Inspector observed at random intervals ZPMC performing contour grinding of welds located on guard rails located in bay 28.

Bay 14

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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

ZPMC QC is identified as Zhang Lin.

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

PCMK: SEG3020AB

Weld No: 100,101,102,103

Welder: 067610

WPS-B-P-2114-FCM-1

Component; OBG

PCMK: SEG3020M

Weld No: 015

Welder: 215553

Weld Repair No. B-WR19824

WPS-345-SMAW-2G(2F)-FCM-Repair

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 Zhang Lin.

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

PCMK: SEG3020BB

Weld No: 037

Welder: 068445

WPS-B-T-2232-ESAB

Component; OBG

PCMK: SEG3020BB

Weld No: 019

Welder: 067103

WPS-B-T-2232-ESAB

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 |
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| Reviewed By: | Riley, Ken | QA Reviewer |
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