

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-019588**Date Inspected:** 09-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:**

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 14 West

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 Li Yan Hua.

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-3020AG

Weld No: 001

Welder: 066421

WPS-B-P-2231-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 Li Yan Hua.

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.

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PCMK: SEG-3020AB
Weld No: 88 and 89
Welder: 067610
WPS-B-T-2114-FCM-1

PCMK: SEG-3020F
Weld No: 023 and 024
Welder: 067765
WPS-B-T-2114-FCM-1

PCMK: SEG-3020J
Weld No: 005
Welder: 037780
WPS-B-P-2212-B-U2-FCM-1

PCMK: SEG-3020E
Weld No: 056
CWR: 2734
Welder: 037840
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3020G
Weld No: 052
CWR: 2734
Welder: 067611
WPS-345-SMAW-2G(2F)-FCM-Repair

Bay 19

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

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

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: SB-025-108
Weld No: 001
CWR: 2731
Welder: 062761
WPS-345-FCAW-ESAB-2G(2F)-FCM-Repair

PCMK: SB-024-108
Weld No: 014
CWR: 2732
Welder: 062761

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

Bay 28

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

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Gnu Xing 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-3400A-009

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3400A-010

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3400A-011

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3400A-012

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

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

Photos please see ; Z:\Inspector Reports\B314 Rice

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.

Inspected By: Rice,Brett

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer