

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-019589**Date Inspected:** 11-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-3013AU

Weld No: 048 and 047

Welder: 067103

WPS-B-T-2233-ESAB

PCMK: SEG3013AU

Weld No: 104 and 105

Welder: 066421

WPS-B-T-2233-ESAB

PCMK: SEG-3013AU

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Weld No: 049 and 051
Welder: 066239
WPS-B-T-2233-ESAB

PCMK: SEG-3013AU
Weld No: 102 and 103
Welder: 068445
WPS-B-T-2233-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.

PCMK: SEG-3020R
Weld No: 138 and 139
Welder: 067610
WPS-B-P-2112-FCM-1

PCMK: DP-3175
Weld No: 301
Welder: 067611
WPS-B-P-2312-TC-P4

Bay 14 East

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 Zhong Guo 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: SEG-3019AL
Weld No: 295
Welder: 067656
WPS-B-P-2114-TC-U4B-FCM-1

PCMK: SEG-3019AL
Weld No: 009
Welder: 037723
WPS-B-P-2114-TC-U4B-FCM-1

PCMK: SEG-3019E
Weld No: 426, 428, and 429

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Welder: 037723

WPS-B-P-2114-TC-U4B-FCM-11

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-022-106

Weld No: 013

CWR: 2727

Welder: 066155

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

PCMK: SB-022-104

Weld No: 005

CWR: 2693

Welder: 259566

WPS-345-SMAW-1G(1F)-FCM-Repair

PCMK: BK-004B5-001

Weld No: 064, 065, 074, 075, 110, 111, 112, and 122

Welder: 062749

WPS-B-T-2233-ESAB

WPS-B-T-2133-ESAB

WPS-B-T-2132-ESAB

ZPMC was observed on this date performing grinding on various welds for PCMK BK-004-013, BK-004-001, SB-024-108 and SB-025-108. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

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

ZPMC QC is identified as Yang Bai Qiang.

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-3400B-014

Weld No: 001 and 002

Welder: 203805

WPS-B-T-2232-ESAB

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PCMK: SA-3400B-014
Weld No: 003 and 004
Welder: 203805
WPS-B-T-2232-ESAB

PCMK: SA-3400B-013
Weld No: 001 and 002
Welder: 203805
WPS-B-T-2232-ESAB

PCMK: SA-3400B-036
Weld No: 003 and 004
Welder: 0062265
WPS-B-T-2232-ESAB

PCMK: SA-3400B-001
Weld No: 003 and 004
Carbon arc back gouging

PCMK: SA-3400B-002
Weld No: 003 and 004
Carbon arc back gouging

PCMK: SA-3400B-003
Weld No: 003 and 004
Carbon arc back gouging

PCMK: SA-3400B-009
Weld No: 003 and 004
Carbon arc back gouging

PCMK: SA-3400B-010
Weld No: 003 and 004
Carbon arc back gouging

ZPMC was observed on this date performing grinding on various welds for PCMK SA-3400A-010 and SA-3400A-014. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour

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

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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
Reviewed By:	Riley,Ken	QA Reviewer
