

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019592**Date Inspected:** 07-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 East

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 Yu Jiao.

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-3007N

Weld No: 1931

Welder: 066733

WPS-B-T-2133-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 Yu Jiao.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

PCMK: SEG-3011J
Weld No: 423
Welder: 067656
WPS-B-P-2114-TC-U4B-FCM-1

PCMK: SEG-3007L
Weld No: 046
WR: 18557
Welder: 066416
WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3009J
Weld No: 218
WR: 19786
Welder: 070008
WPS-345-SMAW-3G(3F)-FCM-Repair

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-3020X
Weld No: 012
CWR: 2661
Welder: 066239
WPS-345-2G(2F)-FCAW-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-3020AB
Weld No: 80~83
Welder: 067620
WPS-B-P-2112-FCM-1

PCMK: SEG-3020X
Weld No: 010
CWR: 2659

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Welder: 037780

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 Sha Zhi.

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: BK-005A8-002

Weld No: 001, 002, 007, 165

Welder: 062806

WPS-B-T-2233-ESAB

WPS-B-T-2232-ESAB

PCMK: BK-004B6-001

Weld No: 001, 002, 007, 165

Welder: 062749

WPS-B-T-2233-ESAB

WPS-B-T-2232-ESAB

ZPMC was observed on this date performing grinding on various welds for PCMK BK-004-001, BK-005-002, SB-024-104 and SB-025-104. 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

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