

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-019594**Date Inspected:** 10-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-3013AW

Weld No: 084

Welder: 066421

WPS-B-T-2233-ESAB

PCMK: SEG3013AW

Weld No: 083

Welder: 066239

WPS-B-T-2233-ESAB

PCMK: SEG-3013AW

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Weld No: 041
Welder: 069712
WPS-B-T-2233-ESAB

PCMK: SEG-3013AW
Weld No: 042
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-3020G
Weld No: 016 and 017
Welder: 067610
WPS-B-P-2414-FCM-1

PCMK: SEG-3020V
Weld No: 075
CWR: 2622
Welder: 067611
WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3020Q
Weld No: 058
CWR: 2620
Welder: 037780
WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3020X
Weld No: 012
CWR: 2659
Welder: 067765
WPS-345-SMAW-3G(3F)-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.

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PCMK: SB-025-108

Weld No: 001

CWR: 2731

Welder: 062761

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

PCMK: BK-004B5-001

Weld No: 014, 015, 034, 035

Welder: 062749

WPS-B-T-2133-ESAB

PCMK: BK-004A8-013

Weld No: 001

Welder: 062757

WPS-B-T-2233-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-007

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3400A-005

Weld No: 001 and 002

Welder: 203805

WPS-B-T-2232-ESAB

PCMK: SA-3400B-008

Weld No: 001 and 002

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3400B-006

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Weld No: 003 and 004

Welder: 0062265

WPS-B-T-2232-ESAB

PCMK: SA-3221A-051

Weld No: 001 and 002

Welder: 059378

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
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