

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-019597**Date Inspected:** 21-Nov-2010**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

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

ZPMC was using the Fluxed Cored Arc Welding (FCAW) 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.

Components; Deck Panel

PCMK: DP-3088-001

Weld No: 012, 013, 022, 023, 030, 031

Welder: 044744

WPS-B-T-2133-TC-U4B-F

PCMK: DP-3073-001

Weld No: 050, 051, 058

Welder: 044795

WPS-B-T-2133-TC-U4B-F

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

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

ZPMC QC is identified as Lv Li Qing.

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.

Components; Anchor Plate

PCMK: AP-3002-001

Weld No: 195,196

Welder: 067079

WPS-B-T-2132

PCMK: AP-3003-001

Weld No: 137, 138

Welder: 066283

WPS-B-T-2132

PCMK: AP-3003-001

Weld No: 171, 172

Welder: 044824

WPS-B-T-2132

PCMK: AP-3002-001

Weld No: 161, 162

Welder: 067079

WPS-B-P-2233-B-L1B-F

PCMK: AP-3005-001

Weld No: 104, 105, 113, 114, 122, 123, 131, 132

Welder: 006283

WPS-B-T-2132

PCMK: AP-3006-001

Weld No: 122, 123

Welder: 067079

WPS-B-T-2132

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 Lv Li Qing.

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: AP-3002-001
Weld No: 205, 206
Welder: 044772
WPS-B-P-2214-B-U2-FCM-1

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

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

ZPMC QC is identified as Zheng 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.

Components; Floor Beam

PCMK: FB-3343-001

Weld No: 315

WR: 17386

Welder: 066763

WPS-345-FCAW-2G-2F-Repair-1

PCMK: SEG-3020-K

Weld No: 394

WR: 17478

Welder: 045240

WPS-345-FCAW-3G-3F-Repair

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



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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
