

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019603**Date Inspected:** 26-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 13

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 Zhan Hai Feng.

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-7038C

Weld No: 002

Welder: 066763

WPS-B-T-2231-ESAB

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 Zhan Hai Feng.

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-3019BB

Weld No: 037

CWR: 2737

Welder: 215553

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019BB

Weld No: 059

CWR: 2737

Welder: 216086

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019BB

Weld No: 125

CWR: 2737

Welder: 066416

WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019E

Weld No: 163, 165, and 169

Welder: 037723

WPS-B-P-2214-TC-U4B-FCM-1

PCMK: SEG-3019AG

Weld No: 007

Welder: 067571

WPS-B-P-2214-TC-U4B-FCM-1

Bay 19

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 Ma Qia 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: Various locations

VT Repairs

Welder: 259566

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

ZPMC was observed on this date performing Heat Straightening on SB-025-108E. It was noted that during the Heat Straightening operation ZPMC was using Procedure Specification HSR(B)-10028

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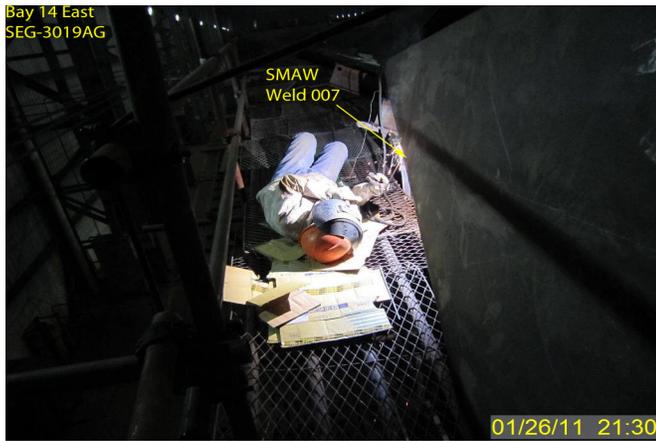
ZPMC was observed on this date performing grinding on various welds for PCMK SB-106E and SB-106W. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 28

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

Performing Match drilling on SA-3400B-019-023

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



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
