

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-019675**Date Inspected:** 29-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Chen Xi	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:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #19

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint 037, Located on Suspender Bracket SB 106E. Welder is identified as 066038. ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR.

Bay #14

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

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Weld joint 003, Located on Lift 14 East components between Anchor plates to Bottom plate, SEG3019U. Welder is identified as 066236. ZPMC Quality Control Inspector (QC) is identified as Guo Zhi Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Esab.

Weld joint 047, Located on Lift 14 East components, SEG3019BB. Welder is identified as 066763. ZPMC Quality Control Inspector (QC) is identified as Guo Zhi Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Esab.

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint 157, Located on Lift 13BE, East components SEG3009K, as per CWR no. B –CWR-2778. Welder is identified as 066258. ZPMC Quality Control Inspector (QC) is identified as Gao Zhi Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-REPAIR-FCM-1.

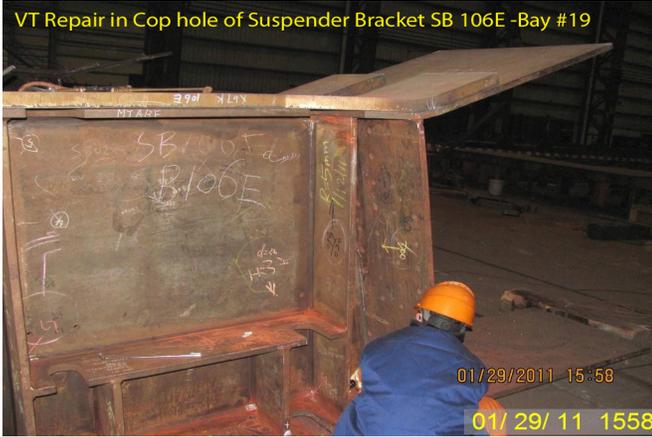
Repair welding of Weld joint 001, Located on Lift 14E, components, Floor beam FB 3287 to LD 3041, SEG3019Z, as per CWR no. B –CWR-2652. Welder is identified as 066422. ZPMC Quality Control Inspector (QC) is identified as Gao Zhi Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-REPAIR-FCM-1.

For further information see below pictures:-

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.

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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
