

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019783**Date Inspected:** 21-Dec-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:**

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

This QA Inspector observed the following work in progress:

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Peng Wen Jun.

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.

Component; Steel Barriers

PCMK: W5-SB1-094

Weld No: 032~043

Welder: 201905

WPS-B-T-2113

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds W5-SB1-095. It appears that ZPMC is performing grinding of visual rejects and contour where ZPMC QC had marked VT indications. (picture attached below)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Peng Wen Jun.

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.

Component; Bike Path

PCMK: BK004B1-001

Weld No: 043

Welder: 259566

Repair No. B-WR19179

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

Component; Bike Path

PCMK: BK004B1-001

Weld No: 044

Welder: 259566

Repair No. B-WR19179

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

Bay 28

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

ZPMC was using the Flux Core 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.

Component; U-rib Splice Plates

PCMK: SA3117D-005

Weld No: 007,008

Welder: 059378

WPS-B-T-2231-EASB

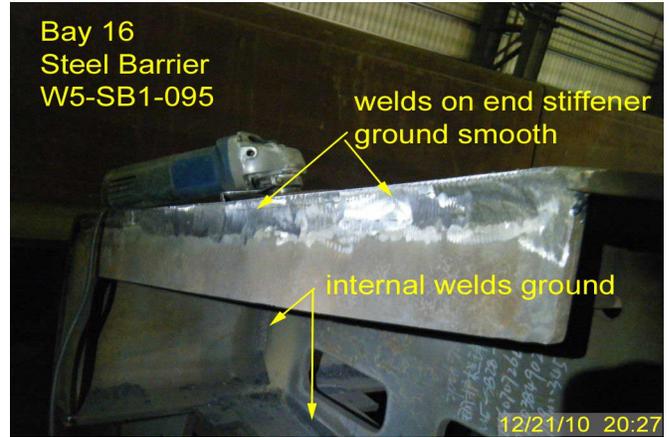
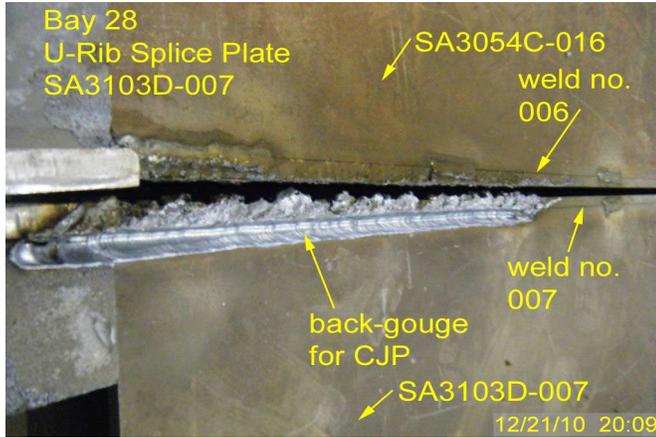
This Caltrans QA Inspector during random observation at ZPMC noted that back gouging was being performed using the Carbon Arc Cutting (CAC) process on thirty four u-rib splice plates. Also noted at this location was ZPMC grinding these back gouge areas to a bright metal finish in preparation for the welding process as outlined in the contract documents. (picture attached below)

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located on BK004A1-014 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
