

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-019796**Date Inspected:** 05-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 14

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

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wong Xiang Pin.

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; Segment Assembly

PCMK: SEG3013G

Weld No: 005,007

Welder: 201215

WPS-B-T-2233-ESAB

Component; 13BW to 13CW

PCMK: DP3146-001

Weld No: 248

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Welders: 203871, 207465
WPS-B-T-2232-ESAB

Component; Segment Assembly
PCMK: DP3133-001
Weld No: 027
Welder: 204730
WPS-B-T-2232-ESAB

Component; OBG14AE,
PCMK: SEG3019AY
Weld No: fit up
Welder: 044824
WPS-B-T-2231-ESAW

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
This QA Inspector observed the following work in progress for Bay 14.
ZPMC QC is identified as Wong Xiang Pin.
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; OBG13AW,
PCMK: SEG3013AW
Weld No: 025~033
Welders: 047866, 202122
WPS-B-T-2214-Tc-U4b

ZPMC was using the Submerged Arc Welding (SAW) process.
This QA Inspector observed the following work in progress for Bay 14.
ZPMC QC is identified as Zhong Yong Gang.
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; OBG14AE, SEG3019
PCMK: DP3167A to DP3160A
Weld No: 005
Welder: 044771
WPS-B-T-2221-B-L2C-S-2

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

Summary of Conversations:

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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
