

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-019801**Date Inspected:** 28-Oct-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 10

This QA Inspector observed the following work in progress for Bay 10. Shielded Metal Arc Welding (SMAW) of weld joint SSD1-TL5-1B-F, and SSD1-TL5-1B-1-51 located on Tower Lift 5. Welder was identified as 061938. ZPMC QC was identified as Liu Yang and QC Li Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-3211-B-U4b

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

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

ZPMC QC is identified as Li Bim.

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; Bike Path

PCMK: BK004A1-023

Weld No. 016,017

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Welder: 205649
WPS-B-T-2132

PCMK: BK004A6-020
Weld No. 010, 020, and 032
Welder: 040723
WPS-B-T-2132

PCMK: BK004C1-024
Weld No. 040, 041
Welder: 054400 and 040759
WPS-B-T-2132

Trial Assembly

This QA Inspector observed the following work in progress for trial assembly. Flux-Core Arc Welding (FCAW) of weld joint OBE11C-003 located on segment 11BE to 11CE. Welders were identified as 040367, 040458, 052763 and 044473. ZPMC QC was identified as Li Yong. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-T-1.

This QA Inspector observed the following work in progress at trial assembly.

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

ZPMC QC is identified as Zhu Yuan Yuan and Shi Lei.

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; 11BE-11CE
PCMK: OBE11C
Weld No. 003
Welder: 040532 and 042280
WPS-B-T-2233-B-U4b

PCMK: DP692-001
Weld No. 013~018
Welder: 062935
WPS-B-T-4114

PCMK: DP693-001
Weld No. 007~012
Welder: 062935
WPS-B-T-4114

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

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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
