

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-019834**Date Inspected:** 08-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. Yu Jiao (ABF)**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:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

This QA Inspector observed the following work in progress:

SMAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007Q Floor Beam to Floor Beam weld number(s) 310. Welder is identified as welder no. 066416. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM-1.

SMAW welding of fillet weld joint(s) located on lift 13C East Line DP3109A Deck Plate to Diaphragm Beam weld number(s) 112, 091, and 097. Welder is identified as welder no. 066478. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2212-TC-U4b-FCM-1 and WPS(s) WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of fillet weld joint(s) located on lift 13C East Line DP3108A Deck Plate to Diaphragm Beam weld number(s) 068, 067, 137, and 088. Welder is identified as welder no. 008087. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s)

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WPS-B-P-2212-TC-U4b-FCM-1 and WPS(s) WPS-B-P-2213-TC-U4b-FCM-1.

FCAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007M Floor Beam to Bottom Plate weld number(s) 251. Welder is identified as welder no. 066283. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007D Floor Beam to Bottom Plate weld number(s) 197 and 196. Welder is identified as welder no. 067947. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Lift 13 DP3091A-001, weld joint(s) 018, 021, 024, 027, and 030. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li Ping was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR-9984.

Summary of Conversations:

As mentioned above between QA and QC concerning this project.



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: DeArmond, Robert

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer