

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-019886**Date Inspected:** 27-Jan-2011**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.

Bay 13

This QA Inspector observed the following work in progress for Bay 13.

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

ZPMC QC is identified as Zhang Qiang, AB Fluor QA Yu Jiao.

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; OBG Grillage Plate

PCMK: SA7038

Weld No: 003,009,014

Welder: 066733

WPS-B-T-2231-ESAB

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Grillage SA7038 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Bay 14

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in FB3108a

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

to Side Plate at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

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

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

ZPMC QC is identified as Zhang Qiang, AB Fluor QA Yu Jiao.

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; OBG 14E, FB3287 to LD3043

PCMK: SEG3019AA (see photo below)

Weld No: 002

Welders: 216086, 066416, 215553

Weld Repair No. CWR2774

WPS-345-SMAW-3G(3F)-FCM-Repair

Components; OBG 14E

PCMK: SEG3019Z

Weld No: 010

Welder: 216085

Weld Repair No. CWR2775

WPS-345-SMAW-3G(3F)-FCM-Repair

Components; OBG Side Plate to End Plate

PCMK: SEG3019AG

Weld No: 007

Welder: 067571

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E, FB to LD PP 128.3

PCMK: SEG3019E-2

Weld No: 166,169

Welder: 037723

WPS-B-P-2214-TC-U4b-FCM-1

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 Li Ping, AB Fluor QA is Ji Cai Jamg (Jim).

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; OBG 13CW

PCMK: SEG3015H

Weld No: 002

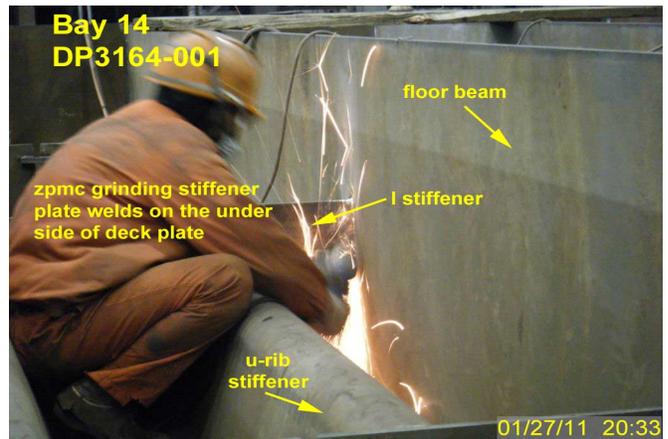
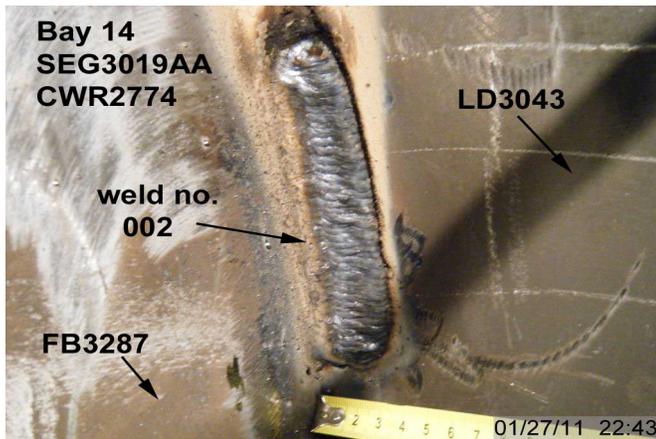
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Welders: 066239, 066421,
WPS-B-T-2232-ESAB

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Deck Plate DP3164-001 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

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
