

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-019892**Date Inspected:** 26-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 14

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 Xie Ming Feng, 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

PCMK: SEG3019BB

Weld No: 037,059,125

Welders: 215553, 216086, 066416

Weld Repair No. CWR2737

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG PP 128.3

PCMK: SEG3019E-1

Weld No: 163,165,169

Welder: 037723

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

Components; OBG PP 127~128

PCMK: SEG3019AG

Weld No: 007

Welder: 067571

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

Components; OBG 14E Longitudinal Diaphragm

PCMK: SEG3019AV

Weld No: 048

Welder: 044772

Weld Repair No. WR20180

WPS-345-SMAW-4G(4F)-FCM-Repair

WPS-345-SMAW-1G(1F)-FCM-Repair

Components; OBG

PCMK: SEG3019BB

Weld No: 059

Welder: 216086

Weld Repair No. CWR2737

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

Components; OBG

PCMK: SEG3019BB

Weld No: 081

Welder: 215553

Weld Repair No. CWR2737

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

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 Xie Ming Feng, 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

PCMK: SEG3007AT

Weld No: 060,061

Welder: 055564

WPS-B-T-2233-ESAB

Components; OBG

PCMK: SEG3007AT

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Weld No: 036,039
Welder: 055491
WPS-B-T-2233-ESAB

Components; OBG
PCMK: SEG3007AT
Weld No: 049,053
Welder: 044795
WPS-B-T-2233-ESAB

Components; OBG
PCMK: KP3006-001
Weld No: 014,015
Welder: 0502421
WPS-B-T-2232-ESAB

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 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
PCMK: SEG3015B
Weld No: 002
Welders: 066239, 066421, 067765
WPS-B-T-2132-ESAB

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
