

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020139**Date Inspected:** 18-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:** Yu Jiao**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, Dennis Combs, was present during the times noted above for the 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), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zhan Hai Feng

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: Diaphragm to LD

PCMK: SEG3019G

Weld Number: 089

Welder: 067571

WPS-B-T-2213

Component: I Rib

PCMK: SEG3019R

Weld Number: 138, 139

Welder: 037723

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WPS-B-T-2213

Component: Longitudinal Diaphragm

PCMK: SEG3019K

Weld Number: 012

Welder: 067656

WPS-345-SMAW-2G-FCM-Repair

WR18926

Component: Longitudinal Diaphragm

PCMK: SEG3019Z

Weld Number: 012

Welder: 066416

WPS-345-SMAW-2G-FCM-Repair

WR19726

Component: Edge Plate

PCMK: SEG3007AB

Weld Number: 040

Welder: 215553

WPS-345-SMAW-1G-FCM-Repair

WR20166

BAY 19

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Guo Xing Hui

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: Suspender Bracket

PCMK: SB025-108

Weld Number: 014, 022

Welder: 259906

WPS-345-SMAW-1G-Repair

CWR2731

BAY 28

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08217 from ZPMC

for Bay 28. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had

performed their MT inspection. The segment is identified as OBG Sub Assembly. The weld designations reviewed

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are as follows.

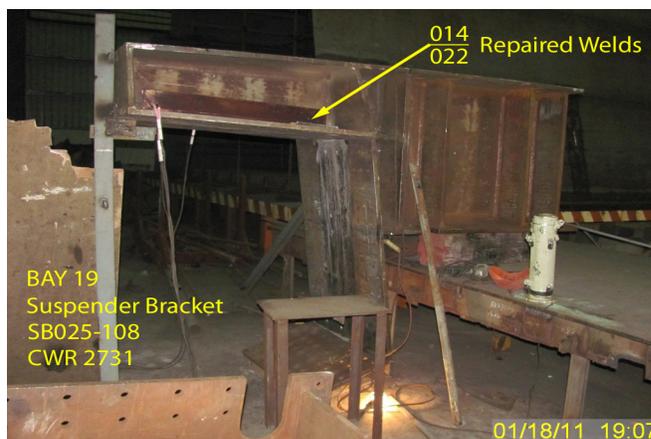
SA3400A-008-001, 002

SA3400A-016-001, 002

SA3400A-028-001, 002

SA3400A-036-001, 002

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



Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer