

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020188**Date Inspected:** 26-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 9BE / North of Blast Shop

This Caltrans QA inspector observed shielded metal arc welding (SMAW) in progress. Welder is identified as #049339 welding Critical Weld Repair (CWR). The CWR procedure is identified CWR-731, Revision 1. The welding repair, location is identified at SSD16A-PP74-024, where unapproved cope hole was fabricated into the weld connection, joining deck panel diaphragm plate to upper floor beam flange. The cope hole is being filled in with weld metal using welding procedure specification, WPS-345-SMAW-2G(2F)-Repair. ZPMC QC inspectors are identified as Mr. Wang Wei Ming and certified welding inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS. The following digital picture illustrates repair welding of the cope hole. See SharedDocs on 'Team China Server (P12.168.0.2Y) (Z:), folder B293 for photo viewing.

OBG Segment Name: 11DW / Bay 14

This Caltrans QA inspector observed submerged arc welding (SAW) in progress. Welder operator is identified as #045265 welding CJP weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG071A-031. ZPMC QC inspectors are identified as Mr. Li Ming Yang and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

WELDING INSPECTION REPORT

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This Caltrans QA inspector observed flux cored arc welding (FCAW) in progress. Welder is identified as #058551 welding complete joint penetration weld (CJP), identified as #SEG072B-002 in the 1G position using WPS-B-T-2231-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI, Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

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

Summary of Conversations:

“As noted within the contents of this report.”

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
