

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-020190**Date Inspected:** 24-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: 9CE / North of Blast Shop

This Caltrans QA inspector observed shielded metal arc welding (SMAW) in progress. Welders are identified as #067609 & 066179 welding fillet weld (FW) in the 4G position using welding procedure specification WPS-B-P-2114-B-FCM-1. The weld is identified as OBE9D-004 & OBE9D-005. ZPMC QC inspector / certified welding inspector (CWI) is identified as, Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 9BW / North of Bay 17

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #037840 welding complete joint penetration (CJP) weld in the 3G position using welding procedure specification WPS-B-P-2213-TC-U4b-FCM-1. The weld is identified as SSD11A-PP75-181. ZPMC QC inspectors are identified as Mr. Li Ping and CWI inspector, Mr. Li Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 12CE / Bay 14

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #050242 welding repair weld identified as #SEG3003A-006 in the 1G position using WPS-345-FCAW-1G(1F)-FCM-Repair. ZPMC QC inspectors are identified as Mr. Zhong Guo Hai and CWI inspector, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

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OBG Segment Name: 12AC / Bay 14

This Caltrans QA inspector observed submerged arc welding (SAW) in progress. Welder operator is identified as #044771 welding CJP weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG3003A-012. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI inspector, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #058551 welding CJP weld identified as #SEG072A-024 in the 2G position using WPS-B-T-2233-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI inspector, Mr. Lv Liqing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11CE / Bay 13

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #200113 welding CJP weld in the 4G position using welding procedure specification WPS-B-P-2214-B-U2-FCM-1. The weld is identified as SEG069A-010. ZPMC QC inspectors are identified as Mr. Guo Xing Hui and CWI inspector, Mr. Zhu Zhong Hai. 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
