

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-020304**Date Inspected:** 17-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 10

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path BK008A-002 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, American Bridge Fluor (ABF) Inspectors performing Magnetic Particle Testing (MT) on Deck Plate DP3136 to DP3135A, then ZPMC performing grinding of visual indications identified by those ABF QC Inspectors.

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 Zhong Guo Hui. AB Fluor QA identified as Yu Jias.

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

PCMK: SEG3019L-1

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Weld No: 107
Welder: 037723
WPS-B-P-2232-ESAB

Components; OBG 13AE
PCMK: SEG3007AY
Weld No: 050
Welder: 066733
WPS-B-T-2232-ESAB

Components; OBG 14E
PCMK: SEG3019AG
Weld No: 001
Welder: 066763
WPS-B-T-2232-ESAB

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 Wang Xiang Ping. AB Fluor QA identified as 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 DP3136 to DP3135A
PCMK: SEG3014
Weld No: 003
Welder: 066734
WPS-B-T-223(2)1T-ESAB-1

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 Zhong Guo Hui. AB Fluor QA identified as Yu Jias.
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
PCMK: SEG3019Z
Weld No: 012
Welders: 066416
WPS-345-SMAW-2G(2F)-FCM-Repair

Components; OBG 14E
PCMK: SA3019J
Weld No: 261
Welder: 067571

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WPS-B-T-2214-

Components; OBG 14E

PCMK: SA3019G

Weld No: 089

Welder: 0067571

WPS-B-T-2214-

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

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Xiang Ping. AB Fluor QA identified as 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 DP3136 to DP3135A (see photo below)

PCMK: SEG3014

Weld No: 003

Welders: 250050

WPS-B-T-2221-B-L2C-S-2

Bay 13

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 Zhong Guo Hui. AB Fluor QA identified as Yu Jias

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; Grillage Plate

PCMK: SA7038C

Weld No: 223,228,231,262,

Welders: 216086

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

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

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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