

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-020399**Date Inspected:** 25-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Qiu Wen**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 Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) Bay 13.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as 026,027 located on SA7038- K3811A of the EAST LINE GRILLAGE. The welder is identified as 067079. ZPMC Quality Control (QC) is identified as Mr. Zhang Quo Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) Bay 13.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as 001 located on SA3011-001. The welder is identified as 07440. ZPMC Quality Control (QC) is identified as Mr. Zhang Quo Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2233 -ESAB

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

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Flux Cored Arc Welding (FCAW) Bay 13.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as 003 located on SA3011-002. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Zhang Quo Hui. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG AP3003-001. The welds designations reviewed are as follows: 139,140,149,150,159,160,169,170,143,144,153,154,163,164,173,174,136,146,156,166,137,138,141,142, 147,148,151,152,157,158,161,162,167,168,171,172,007,008,011,012,015,016,019,020,021,022,024,025,028,029, 032,033,036,037,040,041,044,045,048,049,052,053,056,057,060,061,064,065,068,069,072,073,076,077,080,081, 084,085,088,089,092,093,096,097,100,101,104,105,108,109,112,113,116,117,119,120,122,123,125,126,128, 129,

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG AP3004-001. The welds designations reviewed are as follows: 002,003,006,007,010,011,014,015,024,025,028,029,032,033,036,037,040,041,044,045,049,052,053,056, 057,060,061,064,065,068,069,072,073,076,077,080,081,084,085,088,089,092,093,098,099,102,103,108,109,112, 113,118,119,122,123,094,104,114,124,090,091,095,096,100,101,105,106,110,111,115,116,120,121,125,087,097, 107,117.

Summary of Conversations:

No relevant conversations were reported on this date.

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:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
