

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-020611**Date Inspected:** 04-Dec-2010**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:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07622. The member(s) is/are identified as Longitudinal Diaphragm. The weld designations reviewed are as follows:

LD3031-001-132, 131, 037, 035, 130, 034, 031, 029, 136, 135, 044, 134, 040

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OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Segment 3020*-010 Deck Plate to Deck Plate identified as DP3176 to DP3177 weld number(s) 010. Welder is identified as welder no. 045175. The welding variables recorded by ZPMC QC identified as Shao Jian Yuan appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as VP3007A (Plate 3279A), weld joint(s) 011~012, 024, 025, 037, 038, 050, 051, 063, 064, 076, and 077. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Xle Ming Feng was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-9831 dated 11-11-2010.

FCAW welding of complete joint penetration weld joint(s) located on Segment 3020*-010 Deck Plate to Deck Plate identified as DP3176 to DP3177 weld number(s) 010. Welder is identified as welder no. 045175. The welding variables recorded by ZPMC QC identified as Shao Jian Yuan appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

SMAW welding of complete joint penetration weld joint(s) located on Segment 3020*-007 Deck Plate to Deck Plate identified as DP3173 to DP3174 weld number(s) 007. Welder is identified as welder no. 200569. The welding variables recorded by ZPMC QC identified as Shao Jian Yuan appeared to comply with applicable WPS(s) WPS-B-P-2211-B-U2.

SAW welding of complete joint penetration weld joint(s) located on Deck Plate identified as KP3017A to KP3018 weld number(s) 004. Welder is identified as welder no. 045265. The welding variables recorded by ZPMC QC identified as Mr. Shao Jian Yuan appeared to comply with applicable WPS(s) WPS-B-T-2221-B-L2C-S-2.

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

Summary of Conversations:

As mentioned above between QA and QC concerning this project

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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 Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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