

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020704**Date Inspected:** 22-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiung**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, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

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

ZPMC was using the Flux Cored Arc Welding (FCAW), and Shielded Metal Arc Welding (SMAW) processes.

ZPMC QC is identified as Wang Xi

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.

Component: Floor Beam

PCMK: SEG3019K-1

Weld Number: 002

Welder: 066733

WPS-B-T-2233-ESAB

Component: Longitudinal Diaphragm

PCMK: SEG3019Y

Weld Number: 056

Welder: 044824

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WPS-B-T-2132-ESAB

Component: Bottom Plate

PCMK: SEG3007AC

Weld Number: 009

Welder: 200113

WPS-345-SMAW-4G-FCM-Repair

B-WR19173

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui

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

Component: Bike Path

PCMK: BK004A5-014

Weld Number: 121, 131

Welder: 062783

WPS-B-T-2233-ESAB

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

ZPMC was using the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Yang Bai Qiung

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

Component: U Rib Splice Plate

PCMK: SA3084D-009

Weld Number: 007, 008

Welder: 062265

WPS-B-T-2231-ESAB

Component: U Rib Splice Plate

PCMK: SA3084P-014

Weld Number: 007, 008

Welder: 062265

WPS-B-T-2231-ESAB

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

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documents.

Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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