

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-020746**Date Inspected:** 19-Feb-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 random 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 Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

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; 14W

PCMK: DP3174-001

Weld No: 018, 019

Welder: 037780, 066480

WPS-B-P-2212-TC-U4b-FMC-1

Components; 14W

PCMK: SEG3020BB

Weld No: 019

Welder: 066038

WPS-345-SMAW-2G(2F)-FCM-Repair-1

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Repair No. CWR2752

Components; 14W
PCMK: SEG3020W
Weld No: 021,023
Welder: 067609
WPS-B-P-2114-FCM-1

Components; 14W
PCMK: SEG3020W
Weld No: 043,045
Welder: 067764
WPS-B-P-2114-FCM-1

Components; 14W AP3017 to FB3316
PCMK: SEG3020W
Weld No: 021,023
Welder: 067609
WPS-B-P-2114-FCM-1

Components; 14W AP3017 to FB3316
PCMK: SEG3020V
Weld No: 043,045
Welder: 067764
WPS-B-P-2114-FCM-1

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 Li Ping.
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; 13W
PCMK: SEG3020BB
Weld No: 109
Welder: 067949
WPS-B-P-2233-ESAB

Components; 13W
PCMK: SEG3013M
Weld No: 001
Welder: 067876
WPS-B-P-2132-ESAB

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Components; 14W
PCMK: SEG3020BB
Weld No: 110
Welder: 201215
WPS-B-P-2233-ESAB

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 Zhan Hai Feng, QA is Bao Qian.
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; 13AE (see photo below)
PCMK: SEG3007AD
Weld No: 041
Welder: 037743
WPS-345-SMAW-1G(1F)-FCM-Repair-1
Repair No. WR20210

Components; 14E
PCMK: SEG3019G
Weld No: 007
Welder: 037932
WPS-B-P-2214-TC-U4b-FCM-1

Components; 14E
PCMK: SEG3019BB
Weld No: 114,115
Welder: 067610
WPS-B-P-2114-FCM

Components; 14E
PCMK: SEG3019G
Weld No: 007
Welder: 037932
WPS-B-P-2214-TC-U4b-FCM-1

Components; 14E
PCMK: SEG3019AA
Weld No: 025
Welder: 067656, 066418
WPS-345-SMAW-2G(2F)-FCM-Repair-1
Repair No. B-CWR2755

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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 Zhan Hai Feng, QA is Bao Qian.

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; 13AE

PCMK: SEG3007H

Weld No: 099,101

Welder: 037705

WPS-B-P-2233-ESAB

Components; 13AE

PCMK: SEG3019BC

Weld No: 023

Welder: 070046

WPS-B-P-2131-ESAB

Bay 19

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path BK005A2-002 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors. (see photo below)

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



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 James Devey 1500026784, who represents the Office of Structural Materials for

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your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer