

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-020750**Date Inspected:** 14-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 Guo Xing Hui, CWI as Sha Zhi.

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; 14E

PCMK: SEG3019D-1

Weld No: 323

Welder: 215553

Weld Repair: CWR2678

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

Components; 14E

PCMK: DP3161-001

Weld No: 019

Welder: 050969

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

Components; 13AE

PCMK: SEG3007AB

Weld No: 030, 032

Welder: 037743

WPS-B-P-2214-TC-U4b-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 Guo Xing Hui, CWI as Sha Zhi.

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; 14E

PCMK: SEG3019N

Weld No: 302,303,307,308

Welder: 066733

WPS-B-T-2233-ESAB

Components; 13AE

PCMK: SEG3007AX

Weld No:033

Welder: 055491

WPS-B-T-2233-ESAB

This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds on DP3163.

It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications.

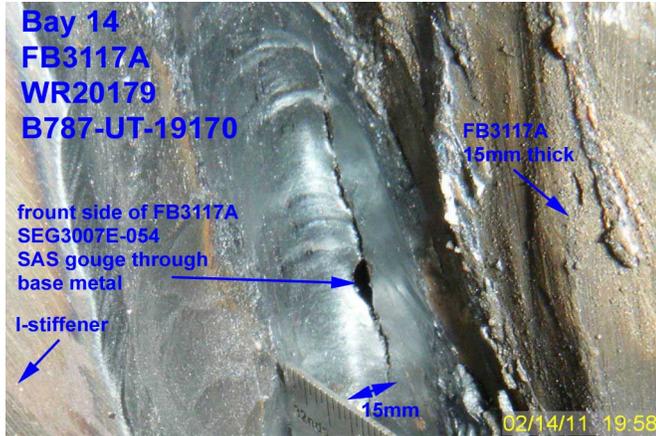
This Caltrans QA Inspector observed at random intervals ZPMC using a milling machine to surface or flatten Grillage Plate SA7038. (see photo below)

During in-process visual inspection of welds located on OBG-13AE, SEG3007E-045 panel point 119.65, this Quality Assurance Inspector (QA) observed that ZPMC personnel had performed Carbon Arc Cutting (CAC) resulting in a base metal gouge which extends through the full base material thickness (15mm). ZPMC had used weld repair document B-WR20179 to remove ultrasonic indications on Floor Beam FB3117A weld 045. The B-WR20179 indicates this repair is not to exceed 65% of base metal thickness and this groove extends through the base metal. This QA informed ZPMC QC Zhang Qiang and a TL-015 Incident Report will be issued for this condition. (see photo below)

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

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer