

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-020788**Date Inspected:** 17-Feb-2011**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:** Zhou Zhong Hai**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Bay#10

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Traveler rail ,weld No.3005TR1-008. The welder is identified as #054069. ZPMC QC is identified as Mr. Yin Chun Fang. The welding variables recorded by QC appear to comply with WPS-B-T-2132-ESAB. The welding variables were recorded at, Amperage 286, volts 24.3. The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2F position for the OBG Bike Path ,weld No. BK004A-064-MEP016. The welder is identified as #040655. ZPMC QC is identified as Mr. Shao Hai Lang. The welding variables recorded by QC appear to comply with WPS-B-P-2112. The welding variables were recorded at, Amperage 210, volts 23.6. The In-process SMAW appears to be progressing in compliance with approved contract documents.

Trial Assembly

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW in the 3G position for the OBG Segment 12BE to 12CE,UT repair weld No. OBE12E-001. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR-FCM-1.The weld repair report is identified as WR20176. The welding variables were recorded at, Amperage 156, volts 25.5 .The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12BE to 12CE,UT repair weld No. OBE12E-002. The welder is identified as #040320. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR-FCM-1.The weld repair report is identified as WR20176. The welding variables were recorded at, Amperage 167, volts 25.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12BW to 12CW ,weld No.SP3053-001-032. The welder is identified as #040611. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1. The welding variables were recorded at, Amperage 152, volts 24.1 . The In-process SMAW appears to be progressing in compliance with approved contract documents.

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

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Dsouza,Christopher

QA Reviewer