

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-020886**Date Inspected:** 22-Feb-2011**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:** Sha Zhi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for 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 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 Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013F-019

Welder: 066421

WPS-B-T-2132-ESAB

PCMK: SEG3013BB-255

Welder: 201583/045643

WPS-B-T-2132-ESAB

Components: 14W

PCMK: SEG3020B-112

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Welder: 067949
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Submerged Arc Welding (SAW) 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: SEG3020AP-002
Welder: 045265
WPS-B-T-2221-B-U2C-S-2

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shield 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: SEG3020W-022
Welder: 066038/067764
WPS-B-P-2114-FCM-1

PCMK: SEG3020W-020
Welder: 067609
WPS-B-P-2114-FCM-1

Components: Deck Panel
PCMK: DP3172-001-020
Welder: 066480
WPS-B-P-2212-TC-U4b-FCM

PCMK: DP3172-001-019
Welder: 037780
WPS-B-P-2212-TC-U4b-FCM

Components: Grillage Sub-Assembly
PCMK: SA7512C-258
Welder: 047864
Report: B-CWR 2629
WPS-345-SMAW-4G (4F)-FCM-repair

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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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
