

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-020892**Date Inspected:** 09-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:** Zhu Jun**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 2

This QA Inspector observed the following work in progress for Bay 2.

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

ZPMC QC is identified as Tian Lei

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: Longitudinal Diaphragm

PCMK: LD3049-001

Weld Number: 169

Welder: 045209

WPS-345-FCAW-3G-Repair

B-WR18651

Component: Longitudinal Diaphragm

PCMK: LD3048-001

Weld Number: 052

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Welder: 045268
WPS-345-SMAW-3G-FCM-Repair
B-WR18353

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Core Arc Welding (FCAW) processes.
ZPMC QC is identified as Feng Ya Jun
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: CB19
PCMK: BP3099-2-001
Weld Number: 015
Welder: 054467
WPS-345-SMAW-3G-FCM-Repair
B-CWR2278

Component: CB19
PCMK: BP3097-2-001
Weld Number: 013
Welder: 049769
WPS-B-P-2231-B-U2-FCM
B-CWR2278

Bay 14

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07704 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3015D-329, 330
SEG3015F-326~329
SEG3015H-326~329
SEG3015C-147, 149
SEG3015E-147~150
SEG3015G-163~166
SEG3015J-147~150

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 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
Reviewed By:	Riley,Ken	QA Reviewer
