

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020991**Date Inspected:** 25-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:** Lv Li Qing**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 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zhu Yuan Yuan.

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: Bottom Plate I Rib

PCMK: SEG3019M

Weld Number: 093, 098

Welder: 054013

WPS-345-SMAW-3G-FCM-REPAIR-1

WR 20248

Component: Floor Beam Diaphragm

PCMK: SEG3007C

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld Number: 252
Welder: 050242
WPS-B-T-2233-ESAB

Component: Deck Plate Diaphragm
PCMK: SEG3007M
Weld Number: 018
Welder: 20009
WPS-B-T-2232-ESAB

Component: Deck Plate Diaphragm
PCMK: SEG3007D
Weld Number: 231
Welder: 055491
WPS-B-T-2233-ESAB

Component: Bottom Plate I Rib
PCMK: SEG3019R
Weld Number: 147
Welder: 067610
WPS-B-T-2211-B-U2-FCM-1
WPS-B-T-2214-B-U2-FCM-1

Component: Bottom Plate I Rib
PCMK: SEG3019P
Weld Number: 172, 177, 182
Welder: 066418
WPS-345-SMAW-3G-FCM-REPAIR-1
WR 20247

Component: Floor Beam
PCMK: FB3287
Weld Number: 020
Welder: 067610
WPS-B-T-2214-FCM-1

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Ma Qian Li.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Component: Suspender Bracket Drip Plate

PCMK: SBDP-P1-027

Weld Number: 001, 002

Welder: 062808

WPS-B-T-2231-ESAB

WPS-B-T-2232-ESAB

Component: Suspender Bracket Drip Plate

PCMK: SBDP-P3-055

Weld Number: 001, 002

Welder: 062808

WPS-B-T-2231-ESAB

WPS-B-T-2232-ESAB

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:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
