

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-021193**Date Inspected:** 13-Dec-2010**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:** 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 Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 13CE deck panel to deck panel diaphragm weld, DP3105-001-050. ZPMC welder was identified as 066746. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding repair report WR-18697 and with welding procedure specification, WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CE deck panel to deck panel diaphragm weld, DP3105-001-076. ZPMC welder was identified as 044830. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G(2F)-ESAB-Repair-FCM.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE bearing seat weld, SEG30007AT-005. ZPMC welder was identified as 050242. ZPMC CWI was identified as Wang Xue. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE bearing seat weld, SEG30007AT-095. ZPMC welder

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was identified as 062782. ZPMC CWI was identified as Wang Xue. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE longitudinal diaphragm to floor beam weld, SEG30007P-041. ZPMC welder was identified as 044774. ZPMC CWI was identified as Wang Xue. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-ESAB.

Caltrans QA observed that approximately 600mm of weld was removed from FL1 Floor beam welds FB3107-001-025 and 026 (Floor beam flange to web). ZPMC CWI Lv Li Qing relayed that weld removal was to align FL1 and FL2-1 for vertical offset.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
