

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-021218**Date Inspected:** 28-Jan-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:** Geng Wei**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

Segment 14East

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint #010 located on 14E, SEG3019Z as per the critical weld repair report # B-CWR2775. Welder is identified as 216086. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair.

Repair welding of a weld joint #002 located on 13AE, SEG3019A as per the critical weld repair report # B-CWR2774. Welder is identified as 044772. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Repair welding of a weld joint #010 located on 14E, SEG3019Z as per the critical weld repair report # B-CWR2775. Welder is identified as 066416. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair.

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Repair welding of a weld joint #085 located on 14E, SEG3019Z-1 as per the critical weld repair report # B-CWR2645. Welder is identified as 068097. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair.

Flux Cored Arc Welding (FCAW):

Weld joint #003 located on 14E, anchor plate to vertical shear plate, SEG3019BB. Welder is identified as 066763. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #104 located on 14E, SEG3019G. Welder is identified as 066471. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #003 located on 14E, SEG3019U. Welder is identified as 066422. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #207 located on 14E at Panel Point 125, SEG3019V. Welder is identified as 068501. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #025 located on 14E, anchor plate to vertical shear plate, SEG3019BB. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB. (See attached photo)

Weld joint #136 located on 14E, SEG3019G. Welder is identified as 066471. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

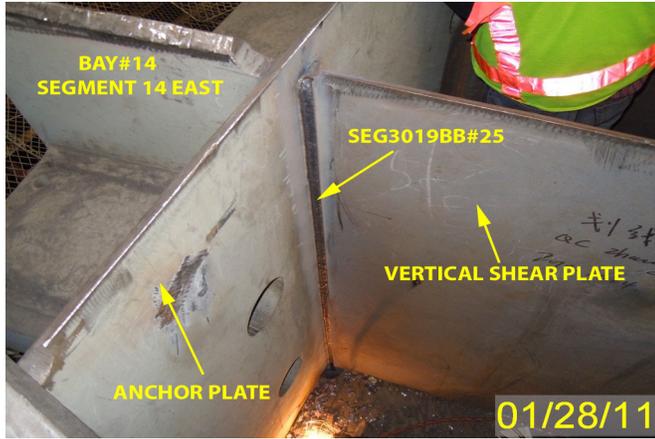
Weld joint #003 located on 14E, SEG3019U. Welder is identified as 066418. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #206 located on 14E at Panel Point 125, SEG3019V. Welder is identified as 068501. ZPMC Quality Control (QC) Inspector is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

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

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
