

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-021227**Date Inspected:** 08-Feb-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

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint #037 located on 14E, SEG3019BB as per the critical weld repair report # B-CWR2737. Welder is identified as 21553. 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-2G (2F)-FCM-Repair.

Repair welding of a weld joint #040 located on 13AE, SEG3007AD as per the weld repair report # B-WR20210. Welder is identified as 044772. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Repair welding of a weld joint #044 located on 14E, SEG3019AV as per the weld repair report # B-WR20180. 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-1G (1F)-FCM-Repair. (See

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attached photo)

Repair welding of a weld joint #129 located on 13AE, SEG3007L as per the weld repair report # B-WR19475. Welder is identified as 200113. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Repair welding of a weld joint #032 located on 13AE, SEG3007AB as per the weld repair report # B-WR19314. Welder is identified as 037743. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Repair welding of a weld joint #017 located on 13AE, SEG3007AD as per the weld repair report # B-WR20210. Welder is identified as 037723. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Flux Cored Arc Welding (FCAW):

Weld joint #076 located on 13AE, SEG3007AZ. Welder is identified as 050242. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #157 located on 14E, 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.

Weld joint #074 located on 13AE, SEG3007AY. Welder is identified as 050242. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #47 located on 14E, 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.

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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