

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-021611**Date Inspected:** 01-Mar-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):

Weld joint #032 located on 13AE, SA3007J. Welder is identified as 068917. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U5b-FCM.

Repair welding of weld joint #003 located on 14E, SEG3019U as per the weld repair report #CWR-2822. Welder is identified as 066326. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-REPAIR-1.

Weld joint #042 located on 13AE, SA3007L. Welder is identified as 068097. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U5b-FCM.

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Weld joint #045 located on 13AE, SA3007G. Welder is identified as 200113. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U5b-FCM.

Repair welding of weld joint #003 located on 14E, SEG3019U as per the weld repair report #CWR-2822. Welder is identified as 062268. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-REPAIR-1.

Flux Cored Arc Welding (FCAW):

Weld joint #006 located on 13AE, saddle support beam SA3066-001. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #219 located on 14E, SEG3019L. Welder is identified as 066733. ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint #004 located on 13AE, saddle support beam SA3067-001. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #032 located on 13AE, SEG3019AH. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #001 located on 13AE, saddle support beam SA3066-001. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #007 located on 13AE, saddle support beam SA3067-001. Welder is identified as 044824. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB. (See attached photo)

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
