

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-021702**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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, Kelly Leavitt, was present during the times noted above for random 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 Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.

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.

Components; OBG 13 W

PCMK: SEG3020AJ

Weld No: 239,240

Welder: 045175

WPS-B-T-2232-ESAB

Components; OBG 13 W (see photo below)

PCMK: SEG3020AW

Weld No: 089

Welder: 067949

WPS-B-T-2232-ESAB

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Components; OBG 13AW

PCMK: SEG3013R

Weld No: 005

Welder: 203871

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: SEG3013F

Weld No: 022

Welder: 066421

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: SEG3013Q

Weld No: 022

Welder: 067876

WPS-B-T-2233-ESAB

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

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shen Jian Bo, CWI Shi Zhi.

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.

Components; OBG 13AW

PCMK: SEG3013AH

Weld No: 021

Welder: 066038

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13AW

PCMK: DP3120-001

Weld No: 011

Welder: 047864

WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document #TC-RFI-0039R0. This RFI addresses OBG 14 West and 14 East cope holes in PL45x1000, PL50x700, PL50x600 bearing stiffeners , and Longitudinal Bulkhead at E2 between panel point 199.3 and 118.7. This QA Inspector performed random visual inspections of the cope holes listed in the RFI and observed ZPMC appears to have completed the cope holes as referenced in the RFI.

This QA Inspector took random photographs of the cope holes and copies of the photographs have been placed in “TC-RFI Documentation” folder located on Team China common Z drive.

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

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping, CWI Boa Qian.

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.

Components; OBG 14BE

PCMK: SA3013-001

Weld No: 003

Welder: 051356

WPS-B-T-2232-ESAB

Components; OBG 13AE

PCMK: SEG3007G

Weld No: 014

Welder: 055491

WPS-B-T-2233-ESAB

Components; OBG 13AE

PCMK: SEG3007L

Weld No: 040

Welder: 050242

WPS-B-T-2232-ESAB

Components; OBG 13AE

PCMK: SEG3007C

Weld No: 255

Welder: 055564

WPS-B-T-2232-ESAB

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

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping, CWI Boa Qian.

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.

Components; OBG 14 E

PCMK: SEG3019AW

Weld No: 096

Welder: 054013

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E

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PCMK: SEG3019AW
Weld No: 100
Welder: 215553
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019Q-1
Weld No: 117,119,121,123,125,139,143,147
Welder: 050969
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019L
Weld No: 047,048,049,053,056,057,060,066,067
Welder: 044779
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13AE
PCMK: SEG3007P
Weld No: 186,183,188,191
Welder: 216086
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 13AE
PCMK: SEG3007P
Weld No: 193,196,198,201
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

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 significant 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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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