

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-021706**Date Inspected:** 26-Feb-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 10

This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Li Jun.

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 Bike Path

PCMK: BK014A2-001

Weld No: fit up

Welder: 057239, 057186

WPS-B-P-2112-TC-U5b

Components; OBG Traveler Rail (see photo below)

PCMK: 20TR2-039

Weld No: 011

Welder: 057258, 052493, 052930, 050363, 044511

WPS-B-P-2211-TC-U5b

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This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path BK009A-001 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors. (See photo below)

This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Li Jun.

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 Bike Path

PCMK: BK009A-001

Weld No: temporary lifting attachment

Welder: 040302

WPS-B-T-2231-ESAB

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 Zhan Yuan Yuan, CWI Luli Ging.

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 PP127.5 EB to SP

PCMK: SEG3019A2

Weld No: 147, 148

Welder: 051356

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 Zhan Yuan Yuan, CWI Luli Ging.

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

PCMK: DP3163-001

Weld No: 219

Welder: 215553

Weld Repair No. B-WR20222

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG

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PCMK: DP3167-001
Weld No: 023
Welder: 050969
Weld Repair No. B-WR20250
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG
PCMK: SEG3019D-1
Weld No: 323
Welder: 066418
Weld Repair No. B-CWR2677
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG
PCMK: SEG3019Z-1
Weld No: 182
Welder: 054013
Weld Repair No. B-CWR2677
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG
PCMK: SEG3019BB
Weld No: 169
Welder: 044719
Weld Repair No. B-CWR2737
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG
PCMK: FB3287-001
Weld No: 020
Welder: 067610
WPS-B-P-2114-FCM-1

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 An Qing Xiang.
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 14W
PCMK: DP3174-001
Weld No: 019
Welder: 066038
Weld Repair No. B-WR20313

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WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14W

PCMK: DP3172-001

Weld No: 023

Welder: 067588

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

Components; OBG 13CW

PCMK: SEG3015B

Weld No: 001

Welder: 066443

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

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 An Qing Xiang.

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 W

PCMK: SEG3020U

Weld No: 589

Welder: 067949

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: SEG3013M

Weld No: 001

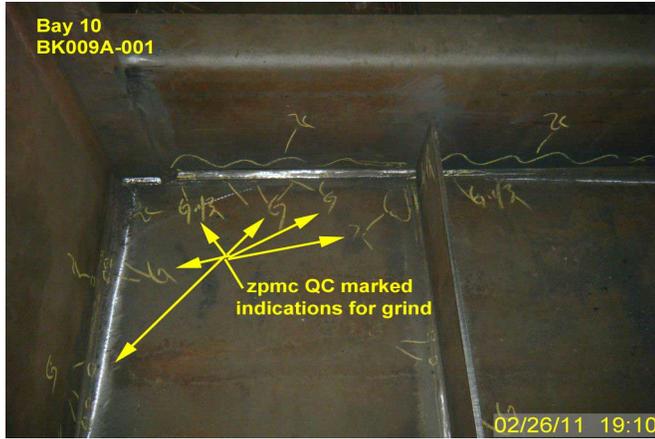
Welder: 066421, 067826

WPS-B-T-2232-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 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

Reviewed By: Riley, Ken

QA Reviewer