

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-021707**Date Inspected:** 28-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 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's is identified as Zhu Lin, Li Ping and Shen Jian Bo CWI Liu Yang.

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 13W

PCMK: SEG3013M

Weld No: 014

Welder: 067876, 045143

WPS-B-T-2232-ESAB

Components; OBG Saddle Support 13AW

PCMK: SA3174-001

Weld No: 001, 002

Welder: 215676

WPS-B-T-2132-ESAB

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Components; OBG 13W
PCMK: SEG3020L
Weld No: 033, 034
Welder: 067949, 045175
WPS-B-T-2133-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's is identified as Zhu Lin, Li Ping and Shen Jian Bo CWI Liu Yang.
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 13W
PCMK: SEG3013K
Weld No: 031
Welder: 045196
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13W
PCMK: SEG3013F
Weld No: 052
Welder: 066421
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13W
PCMK: SEG3013M
Weld No: 050
Welder: 045213
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13W (see photo below)
PCMK: SEG3013AH
Weld No: 179, 180
Welder: 067876, 066038
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13W (see photo below)
PCMK: SEG3013AH
Weld No: 178
Welder: 047864
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG Deck Plate 14W

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PCMK: DP3172-001

Weld No: 250

Welder: 066155

Weld Repair No. B-WR20289

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

Components; OBG Deck Plate 14W

PCMK: DP3172-001

Weld No: 036

Welder: 067588

Weld Repair No. B-WR20289

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

Components; OBG Deck Plate 14W

PCMK: DP3174-001

Weld No: 020

Welder: 066398

Weld Repair No. B-WR20513

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

Components; OBG Deck Plate 14W

PCMK: DP3173-001

Weld No: 004

Welder: 066459

Weld Repair No. B-WR20289

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

Components; OBG 13W

PCMK: SEG3020Z

Weld No: 007

Welder: 045246

WPS-B-P-2214-TC-U5-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's is identified as Zhu Yuan Yuan.

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 Deck Plate 14E

PCMK: DP3161-001

Weld No: 017

Welder: 050969

Weld Repair No. B-WR20250

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

Components; OBG Deck Plate 14E

PCMK: DP3167-001

Weld No: 038

Welder: 215553

Weld Repair No. B-WR20271

WPS-345-SMAW-2G(2F)-FMC-Repair-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's is identified as Zhu Yuan Yuan.

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 Saddle Support 13AE

PCMK: SA3066-001

Weld No: 006,018,012

Welder: 055564, 0555491, 050242

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