

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-021737**Date Inspected:** 22-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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

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

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

ZPMC QC is identified as Zha Hai Feng.

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.

PCMK: SEG-3007AT

Weld No: 009

Welder: 020009

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 Zha Hai Feng.

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.

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PCMK: SEG-3007N

Weld No: 158, 163, 168, and 173

Welder: 068924

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

PCMK: SEG-3007Y

Weld No: 348 and 350

WR: 19769

Welder: 037743

WPS-B-P-2211-TC-U4b-FCM-1

PCMK: SEG-3019BC

Weld No: 020

Welder: 067610

WPS-B-P-2214-FCM-1

PCMK: SEG-3019BC

Weld No: 018

Welder: 037748

WPS-B-P-2214-FCM-1

PCMK: SEG-3019BC

Weld No: 014

Welder: 037932

WPS-B-P-2214-FCM-1

PCMK: SEG-3019E-2

Weld No: 159

WR: 20273

Welder: 215553

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

PCMK: SEG-3019BB

Weld No: 179

WR: 20270

Welder: 066418

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Bay 16

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in bay 16;

BP-3095-001 and BP-3101-001

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This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Ma Qian Li.

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.

PCMK: SB-027-110

Weld No: 003

Welder: 062772

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

PCMK: BK-004A-013

Weld No: Tack welding perimeter of bottom plate

Welder: 062811

WPS-B-P-2112

Bay 28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) a total of approx. 150 +/- Splice Plates for U-Ribs at this location in bay 28;

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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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:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
