

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-021791**Date Inspected:** 25-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-3019AZ

Weld No: 141, 143, and 145

Welder: 051356

WPS-B-T-2233-ESAB

PCMK: SEG-3009J

Weld No: 006

Welder: 037705

WPS-B-T-2232-ESAB

PCMK: SA-3214A-001

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Weld No: 007 and 008
Welder: 070254
WPS-B-T-2233-ESAB

PCMK: DP-3104-001
Weld No: 252 and 253
Welder: 044790
WPS-B-T-2233-ESAB

PCMK: SEG-3007C
Weld No: 262
Welder: 050242
WPS-B-T-2233-ESAB

PCMK: SEG-3007M
Weld No: 003 and 004
Welder: 055491
WPS-B-T-2233-ESAB

PCMK: SEG-3007D
Weld No: 228 and 231
Welder: 055564
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.

PCMK: DP-3161-001
Weld No: 021
WR: 20268
Welder: 215553
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3161-001
Weld No: 017
WR: 20250
Welder: 050969
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3161-001
Weld No: 212

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WR: 20250

Welder: 037932

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

PCMK: DP-3160-001

Weld No: 041

WR: 20272

Welder: 067656

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

PCMK: SEG-3019M

Weld No: 093 and 098

WR: 20248

Welder: 054013

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

PCMK: SEG-3019P

Weld No: 172 and 177

WR: 20247

Welder: 066418

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

PCMK: SEG-3019R

Weld No: 135, 139, 143, and 159

Welder: 067610

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

PCMK: SEG-3007F

Weld No: 005 and 006

Welder: 216086

WPS-B-P-2212-B-U2-FCM-1

Bay 19

ZPMC was observed on this date performing grinding on various welds for PCMK BK-005A-002 and BK-004B-001. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour

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

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Summary of Conversations:

No relevant conversations were reported on this date.

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
