

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-021794**Date Inspected:** 01-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:**

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-3019V

Weld No: 229

Welder: 051356

WPS-B-T-2233-ESAB

PCMK: SA-3214-001

Weld No: 002

Welder: 044790

WPS-B-T-2133-ESAB

PCMK: SEG-3007G

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Weld No: 040
Welder: 050242
WPS-B-T-2233-ESAB

PCMK: SEG-3007J
Weld No: 031
Welder: 055564
WPS-B-T-2233-ESAB

PCMK: SEG-3007L
Weld No: 041
Welder: 055491
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: SEG-3019U
Weld No: 003
CWR: 2822
Welder: 215553 and 054013
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019Z
Weld No: 008
Welder: 067610
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: DP-3160-001
Weld No: 005
WR: 20269
Welder: 050969
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019BB
Weld No: 147
CWR: 2737
Welder: 044779
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Bay 16

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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 Peng Wen 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.

PCMK: W2-SB16B-001

Tack Weld No: 075~078, 082~087, and 126~131

Welder: 201889

WPS-B-P-2112

Bay 19

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

ZPMC was using the Heat Straightening (HSR) process.

ZPMC QC is identified as Peng Wen Jun.

Listed below are the locations that were identified by this QA inspector.

PCMK: BK-005A-002

Bottom Panel

HSR-1(B)-9501

ZPMC was observed on this date performing grinding on various welds for PCMK BK-004B-001 and BK-004A-013. 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.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
