

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-021796**Date Inspected:** 03-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-3019AP

Weld No: 027 and 028

Welder: 051356

WPS-B-T-2232-ESAB

PCMK: SEG-3019AQ

Weld No: 037, 038, 041 and 042

Welder: 051356

WPS-B-T-2132-ESAB

PCMK: SEG-3019N

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Weld No: 018, 019, 320, and 321

Welder: 044790

WPS-B-T-2132-ESAB

PCMK: SEG-3007G

Weld No: 033 and 036

Welder: 050242

WPS-B-T-2132-ESAB

PCMK: SEG-3007L

Weld No: 032 and 035

Welder: 055491

WPS-B-T-2132-ESAB

PCMK: SA-3066-001

Weld No: 005, 008 and 017

WR: 20179

Welder: 055564

WPS-345-FCAW-3G(3F)-ESAB-Repair

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-3019D-2

Weld No: 160

WR: 18781

Welder: 037748

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

PCMK: DP-3160-001

Weld No: 038, 039, 041, 215, 216, and 217

WR: 20272

Welder: 050969

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

PCMK: DP-3161-001

Weld No: 019

WR: 20267

Welder: 215553

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

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PCMK: SEG-3019BB
Weld No: 144 and 166
CWR: 20246
Welder: 054013
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019AJ
Weld No: 054 and 064
WR: 20245
Welder: 044779
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3019AG
Weld No: 050
Welder: 067610
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019Q-1
Weld No: 105
Welder: 050232
WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Submerged Arc Welding (SAW) 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-3007
Weld No: 007C
Welder: 058100
WPS-B-T-2221-B-L2C-S-2

Bay 16
This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Flux Cored Arc Welding (FCAW) 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-SB16-002
Tack Weld No: 126~131
Welder: 222396
WPS-B-T-2132-ESAB

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PCMK: E5-SB24-002

Tack Weld No: 029, 030, 060, 061, 091 and 092

Welder: 201074

WPS-B-T-2132-ESAB

PCMK: W2-SB16B-001

Tack Weld No: 063~072, 79, and 80

Welder: 201888

WPS-B-T-2133-ESAB

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

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
