

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021803**Date Inspected:** 06-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Jun**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, Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 2

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07663 from ZPMC for Bay 2. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The members are identified as OBG Sub Assemblies. The weld designations reviewed are as follows.

LD3049-001-019, 021, 028, 030, FB3343-001-212, 296, 326, 393

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07664 from ZPMC for Bay 2. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The members are identified as OBG Sub Assemblies. The weld designations reviewed are as follows.

FB3343-001-127, 141, 373, 375, FB3343-001-051, 065, 365, 367

This QA Inspector observed the following work in progress for Bay 2.
ZPMC was using the Flux Core Arc Welding (FCAW) process.

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ZPMC QC is identified as Tian Lei

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

Component: Longitudinal Diaphragm

PCMK: LD3049-001

Weld Number: 419

Welder: 045209

WPS-B-T-2231-ESAB

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

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

ZPMC QC is identified as Tian Lei

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

Component: Longitudinal Diaphragm

PCMK: LD3041-001

Weld Number: 004, 005

Welder: 050977

WPS-B-T-2231-ESAB

Bay 6

This QA Inspector observed the following work in progress for Bay 6.

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

ZPMC QC is identified as Feng Ya 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

Component: Deck Plate

PCMK: DP3168-001

Weld Number: 123

Welder: 048659

WPS-345-SMAW-2G-FCM-Repair

B-CWR2302

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

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

ZPMC QC is identified as Feng Ya Jun

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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

Component: CB19 Diaphragm Plate
PCMK: CB3003K-002
Weld Number: 056, 058, 060, 062
Welder: 054467
WPS-B-P-2114-FCM

Bay 8

This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Feng Ya 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

Component: Bike Path
PCMK: BK004A-061
Weld Number: 067
Welder: 040673
WPS-345-SMAW-3G-Repair

Bay 14

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07656 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3020AB-104, 105, 106, 107, 108, 109

Bay 19

This QA Inspector observed the following work in progress for Bay 19.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Guo Xing Hui
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

Component: Bike Path
PCMK: BK004B-001
Weld Number: 039, 128
Welder: 062732

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WPS-B-T-2133-ESAB

Component: Bike Path
PCMK: BK004B-001
Weld Number: 037, 038
Welder: 208632
WPS-B-T-2133-ESAB

Component: Bike Path
PCMK: BK004B-001
Weld Number: 092, 096, 070, 078
Welder: 208641
WPS-B-T-2134-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
