

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-021805**Date Inspected:** 27-Feb-2011**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:** Lu Li Qing**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:**

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 14

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

ZPMC was using the Shielded Metal Arc Welding (SMAW), and the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zhu Yuan Yuan.

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: Floor Beam

PCMK: SEG3019E

Weld Number: 182

Welder: 054013

WPS-345-SMAW-2G-FCM-REPAIR

CWR 2677

Component: Vertical Shear Plate

PCMK: SEG3019BB

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Weld Number: 169
Welder: 044779
WPS-345-SMAW-2G-FCM-REPAIR
CWR 2737

Component: Bottom Plate I Rib
PCMK: SEG3019H
Weld Number: 132, 139
Welder: 051356
WPS-B-T-2233-ESAB

Component: Deck Plate Diaphragm
PCMK: SEG3007D
Weld Number: 231
Welder: 055491
WPS-B-T-2233-ESAB

Component: Floor Beam I Rib
PCMK: FB3287
Weld Number: 018
Welder: 067610
WPS-B-P-2114

Component: Edge Plate
PCMK: SEG3007AB
Weld Number: 020
Welder: 044772
WPS-345-SMAW-4G-FCM-REPAIR
WR 20184

Component: Floor Beam
PCMK: SEG3019E
Weld Number: 178
Welder: 054013
WPS-345-SMAW-3G-FCM-REPAIR-1
CWR 2650

Bay 16

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

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

ZPMC QC is identified as Xu Tao.

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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Component: Steel Barrier
PCMK: W2-SB27-003
Weld Number: 116~121
Welder: 201888
WPS-B-T-2132-ESAB

Component: Steel Barrier
PCMK: W2-SB16B-001
Weld Number: 126~131
Welder: 201889
WPS-B-T-2132-ESAB

Component: Steel Barrier
PCMK: W2-SB16-002
Weld Number: 126~131
Welder: 201074
WPS-B-T-2132-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.

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Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer