

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-021808**Date Inspected:** 01-Mar-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: Peng Wen Jun
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan 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.

Component: Anchor Plate

PCMK: SEG3019U

Weld Number: 003

Welder: 215553

WPS-345-SMAW-2G-FCM-REPAIR-1

CWR 2822

Component: Anchor Plate

PCMK: SEG3019U

Weld Number: 003

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Welder: 044779
WPS-345-SMAW-2G-FCM-REPAIR-1
CWR 2822

Component: Anchor Plate
PCMK: SEG3019U
Weld Number: 003
Welder: 054013
WPS-345-SMAW-2G-FCM-REPAIR-1
CWR 2822

Component: Grillage
PCMK: SEG3007G
Weld Number: 040
Welder: 215553
WPS-B-T-2233-ESAB

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08424 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 Edge Beam. The weld designations reviewed are as follows.

SEG3011J-400, 401, 402, 403
SEG3011L-226, 228

Bay 16

This QA Inspector observed the following work in progress for Bay 16. ZPMC was using the Shielded Metal Arc Welding (SMAW) processes. 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.

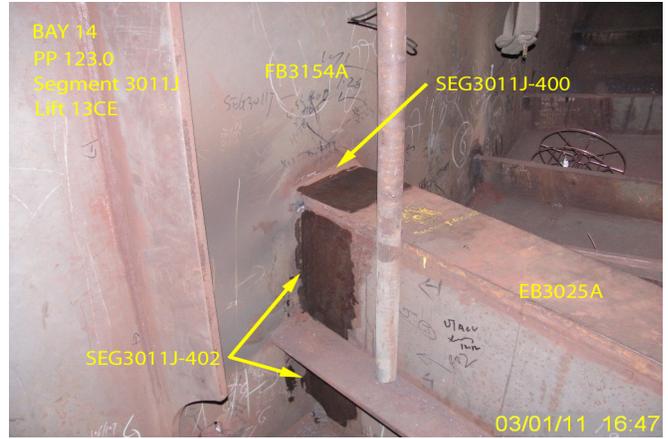
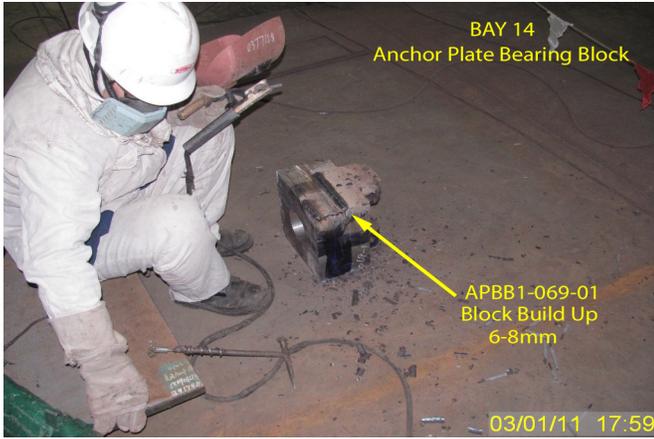
Component: Steel Barrier
PCMK: E5-SB30-001
Weld Number: 126~131
Welder: 216839
WPS-B-T-2112

Component: Steel Barrier
PCMK: W2-SB29-001
Weld Number: 017
Welder: 201889
WPS-B-T-2112

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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
