

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-021899**Date Inspected:** 14-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:** Mr. Li Yan Hua**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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint- 126, Located on Crash Barrier E2-SB30-001. Welder is identified as 206296. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 102 Located on Crash Barrier W2-SB18-003. Welder is identified as 053742. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint- 075, Located on Crash Barrier E2-SB32-001. Welder is identified as 062092. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

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Weld joint- 076 Located on Crash Barrier E2-SB23A-001. Welder is identified as 222396. ZPMC Quality Control Inspector (QC) is identified as Guo Xin Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint- 128, Located on Crash Barrier, W5-SB14B-001. Welder is identified as 201074. ZPMC Quality Control Inspector (QC) is identified as Guo Xin Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 118, Located on Crash Barrier, E2-SB23-003. Welder is identified as 201888. ZPMC Quality Control Inspector (QC) is identified as Guo Xin Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW)

Weld joint- 039, Located on Crash Barrier E5-SB32-003. Welder is identified as 201861. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Weld joint- 004, Located on Crash Barrier E2-SB25B-001. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Weld joint- 032, Located on Crash Barrier E5-SB29-001. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Guo Xin Hui. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Heat Straightening:

Heat Straightening being performed on Crash Barrier identified as W5-SB8-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Guo Xin Hui present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9367.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint-010, Located on Deck Panel 3081A to Deck panel 3082A, SEG 3007. Welder is identified as 068917.

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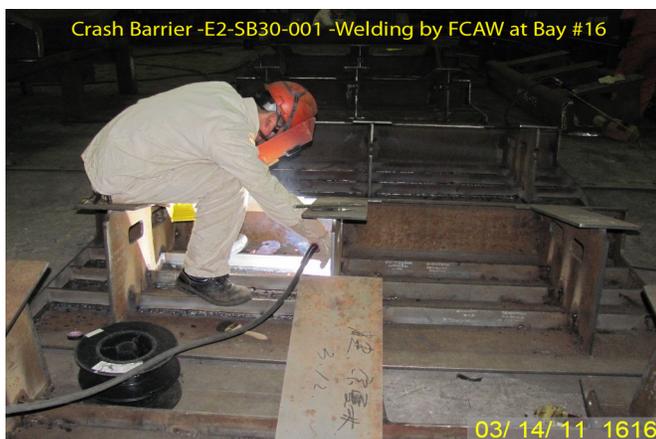
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ZPMC Quality Control Inspector (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-B-U2-FCM-1.

Weld joint-009, Located on segment 13BE to 13CE. Welder is identified as 066326. ZPMC Quality Control Inspector (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevent 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 Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer