

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-021911**Date Inspected:** 20-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm of OBG Segment 14W. Weld joint is identified as DP3173-001-022. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067520 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm of OBG Segment 14W. Weld joint is identified as DP3172-001-018. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037780 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm of OBG Segment 14W. Weld joint is

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identified as DP3174-001-021. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067611 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm of OBG Segment 14W. Weld joint is identified as DP3174-001-019. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067588 perform welding by Shielded Metal Arc Welding (SMAW), on sub assembly component of OBG Segment 13CW. Weld joint is identified as SA3174-001-005. ZPMC Quality Control (QC) Inspector identified as Wang Xiang Pin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-B-U3b.

This QA Inspector observed ZPMC qualified welding personnel identified as 067707 perform welding by Shielded Metal Arc Welding (SMAW), on Bottom plate to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020U-588. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 067829 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020R-021. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-Tc-U4b-FCM.

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

Summary of Conversations:

No significant 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, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
