

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-021939**Date Inspected:** 28-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:** Sha Zhi**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for 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 Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

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

Components: 13AW

PCMK: SEG3013K-031

Welder: 045196

WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3013M-050

Welder: 045213

WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3013AH-178

Welder: 047864

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG3013AH-179

Welder: 067876

WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG3013AH-180

Welder: 066038

WPS-B-P-2214-TC-U4b-FCM-1

Components: 14W

PCMK: SEG3020Z-007

Welder: 045296

WPS-B-P-2214-TC-U5-FCM-1

Components: Deck Panel

PCMK: DP3172-001-250

Welder: 066155

Report: B-WR20289

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: DP3172-001-036

Welder: 067588

Report: B-WR20289

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: DP3174-001-020

Welder: 066398

Report: B-WR20289

WPS-345-SMAW-2G (2F)-FCM-repair

PCMK: DP3173-001-004

Welder: 066459

Report: B-WR20289

WPS-345-SMAW-2G (2F)-FCM-repair

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

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

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013F-052

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Welder: 066421
WPS-B-T-2233-ESAB

PCMK: SEG3013M-014
Welder: 067876, 045143
WPS-B-T-2232-ESAB

Components: 14W
PCMK: SEG3020L-033
Welder: 067949
WPS-B-T-2133-ESAB

PCMK: SEG3020L-034
Welder: 045175
WPS-B-T-2133-ESAB

Components: Saddle Support
PCMK: SA3174-001-001
Welder: 215676
WPS-B-T-2132-ESAB

PCMK: SA3174-001-002
Welder: 207465
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:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
