

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-022245**Date Inspected:** 21-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**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 Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

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

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

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.

PCMK: DP-3091-001

Weld No: 019 and 020

Welder: 044779 and 054013

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

PCMK: SEG-3019BB

Weld No: 016, 038, 060, 082 and 104

Welder: 216086

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

PCMK: SEG-3019BB

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Weld No: 223 and 224
Welder: 215553
WPS-B-P-2213-TC-U4b-FCM-1

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Cored Arc Welding (FCAW) process.
ZPMC QC is identified as Zhong Yong Gang.
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.

PCMK: SEG-3019B
Weld No: 091 and 092
Welder: 051356
WPS-B-T-2133-ESAB

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Ma Qian Li.
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.

PCMK: E5-SB24A-001
Weld No: 138 and 139
Welder: 201905
WPS-B-P-2112-FCM-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Flux Cored Arc Welding (FCAW) process.
ZPMC QC is identified as Ma Qian Li.
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.

PCMK: W5-SB30-004
Weld No: 144 and 145
Welder: 048625
WPS-B-T-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Ma Qian Li.

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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.

PCMK: SB27-001-110E

Weld No: 035

Welder: 062814

WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SB26-001-110W

Weld No: 053

Welder: 259566

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

Bay 19

This QA Inspector observed the following work in progress for Bay 16.

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

ZPMC QC is identified as Ma Qian Li.

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.

PCMK: X6549B

Weld No: Surfacing

CWR: 2835

Welder: 062783

WPS-345-FCAW-1G-ESAB-FCM-Repair

PCMK: X6550B

Weld No: Surfacing

CWR: 2835

Welder: 062806

WPS-345-FCAW-1G-ESAB-FCM-Repair

PCMK: X6043B

Weld No: Surfacing

CWR: 2835

Welder: 062749

WPS-345-FCAW-1G-ESAB-FCM-Repair

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

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Summary of Conversations:

No relevant 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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
