

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-022336**Date Inspected:** 24-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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

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

ZPMC QC is identified as Zhan Hai Feng, CWI Wu Ke Wen.

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; OBG 13AE

PCMK: SEG3007L

Weld No: 007,089,090,093

Welder: 068924

Weld Repair No, B-WR20380

WPS-345-SMAW-3G(3F)-FCM Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.

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

ZPMC QC is identified as Zhan Hai Feng, CWI Wu Ke Wen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AE
PCMK: SEG3007B
Weld No: 086,093
Welder: 055564
WPS-B-T-2231-ESAB

Components; OBG 13AE
PCMK: SEG3007D
Weld No: 153,154,158,159
Welder: 050242
WPS-B-T-2231-ESAB

Bay 14

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 An Qing Xcing, CWI Wang Jun.

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; OBG 14 W
PCMK: SEG3020BB
Weld No: 020
Welder: 051348
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13BW
PCMK: SEG3014A
Weld No: 007
Welder: 067572
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14CW
PCMK: DP3146-001
Weld No: 246,249
Welder: 067588
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13BW
PCMK: SEG3014A
Weld No: 007
Welder: 067829, 067609
WPS-B-P-2214-B-U2-FCM-1

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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 An Qing Xcing, CWI Wang Jun.

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; OBG 13CW

PCMK: SEG3015G

Weld No: 147,146

Welder: 045143

WPS-B-T-2233-ESAB

Components; OBG 13BW

PCMK: SEG3014G

Weld No: 015,016,129,130

Welder: 201583

WPS-B-T-2233-ESAB

Components; OBG 13AW

PCMK: AH3001

Weld No: 001

Welder: 067876

WPS-B-T-2231-ESAB

Components; OBG 13CW

PCMK: SEG3015K

Weld No: 192

Welder: 066673, 066674

WPS-B-T-2233-ESAB

Components; OBG Traveler Rails

PCMK: TR36

Weld No: 010,011

Welder: 047866

WPS-B-T-2132-ESAB

Components; OBG Traveler Rails

PCMK: TR3004

Weld No: 001,016

Welder: 201215

WPS-B-T-2231-ESAB

Components; OBG Traveler Rails

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PCMK: TR3007
Weld No: 001
Welder: 201215
WPS-B-T-2231-ESAB

Components; OBG Traveler Rails

PCMK: TR3008
Weld No: 001,002
Welder: 201215
WPS-B-T-2231-ESAB

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document #TC-RFI-0196R0. This RFI addresses OBG 14 one-sided/one-weld fit lugs for vertical plate stiffeners at floorbeam web plates. This QA Inspector performed random visual inspections of the welds listed in the RFI and observed ZPMC appears to be in process for the welds referenced in the RFI. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in “TC-RFI Documentation” folder located on Team China common Z drive.

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
