

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-022343**Date Inspected:** 06-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.

Bay 14

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 Shen Jian Bo, CWI Shi Zhi.

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 13 W

PCMK: SA7005-001

Weld No: 001

Welder: 214945, 044824

WPS-B-T-2231-ESAB

Components; OBG 13 W

PCMK: SEG3007G

Weld No: 008

Welder: 055564

WPS-B-T-2232-ESAB

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Components; OBG 13 W
PCMK: SA7005-001
Weld No: 011
Welder: 055491
WPS-B-T-2232-ESAB

Components; OBG 13 W
PCMK: SEG3007L
Weld No: 124
Welder: 050242
WPS-B-T-2232-ESAB

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 Shen Jian Bo, CWI Shi Zhi.
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 13BW
PCMK: SEG3007R
Weld No: 018,019,188,189
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document # TC-RFI-0038R0. This RFI addresses OBG lift 13A, add rat holes for Plate C X3789A and proposal to modify grillage plate B. This QA Inspector performed random visual inspections of the rat holes listed in the RFI and observed ZPMC appears to have completed the rat holes as 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. (see photo below)

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document # TC-RFI-0039R1. This RFI addresses weld access hole size (rathole) at Hinge A stiffeners (PP127, 127.3, & 128). This QA Inspector performed random visual inspections of the rat holes listed in the RFI and observed ZPMC appears to have completed the rat holes as referenced in the RFI. This QA Inspector took random photographs of the ratholes and copies of the photographs have been placed in “TC-RFI Documentation” folder located on Team China common Z drive. (see photo below)

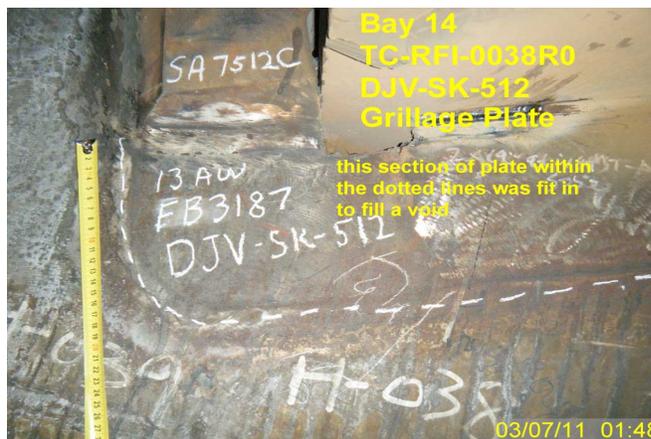
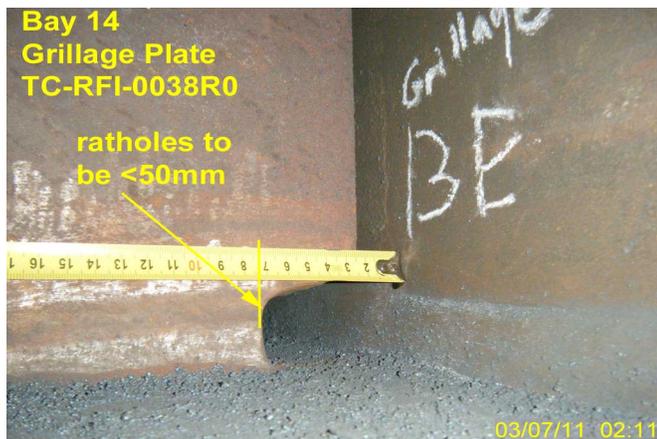
This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document # TC-RFI-0039R0. This RFI addresses OBG 13AE and 13AW stiffener diaphragm plates and pier E2 stiffener plates, cope sizes. This QA Inspector performed random visual inspections of the cope holes listed in the RFI and observed ZPMC appears to have completed the cope holes as referenced in the RFI. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in “TC-RFI

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Documentation” folder located on Team China common Z drive. (see photo below)

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



Summary of Conversations:

No significant 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