

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-022399**Date Inspected:** 26-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 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: SEG3020AP

Weld No: 039,035,031,027,014,010,006

Welder: 066398

Weld Repair No. B-WR20503

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 13 W

PCMK: SEG3014F

Weld No: 216

Welder: 067588

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

Components; OBG 13CW

PCMK: OBW13AD

Weld No: 001,002

Welder: 066673

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

Components; OBG 14 W

PCMK: SEG3020U

Weld No: 591

Welder: 066673

WPS-B-P-2212-B-U2-1

Components; OBG 13AE (see photos below)

PCMK: SA3416C

Weld No: Fit Up

Welder: 067609, 067829

WPS-B-P-2212

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 Traveler Rail

PCMK: TR3027TR1-001

Weld No: 012

Welder: 067876

WPS-B-T-2231-ESAB

Components; OBG Traveler Rail

PCMK: TR3021TR1-001

Weld No: 012,013

Welder: 067876

WPS-B-T-2231-ESAB

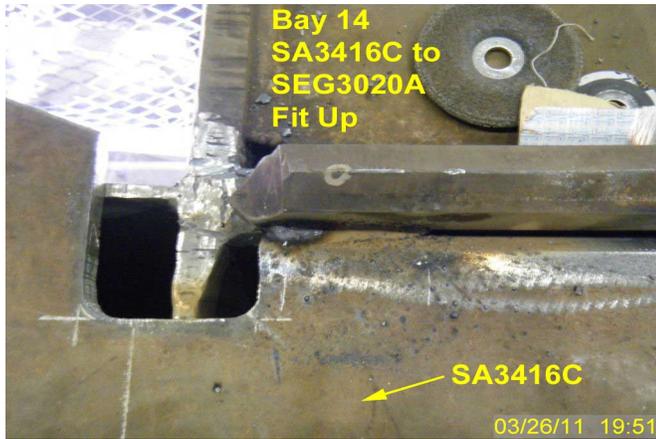
Trial Assembly

During QA observation of the OBG CB18, it was noted that this QA inspector performed photo documentation for the completion of TC-RFI 0227R0. The photos taken were of the fit lugs used on CB18 PL40X200 Web Stiffener to Diaphragms. At the time of the documentation it appeared that ZPMC had completed these areas as outlined within the TC-RFI documentation. (see photo below)

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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