

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022773**Date Inspected:** 20-Mar-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:** Zhao Chen Sun**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, Bike Path**Summary of Items Observed:**

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

BAY 8

This QA Inspector observed the following work in progress for Bay 8.

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

ZPMC QC is identified as Liu Chuan 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.

Component: Saddle Housing

PCMK: SA7047-001

Weld Number: 044

Welder: 047470

WPS-B-P-2112

BAY 10

This QA Inspector observed the following work in progress for Bay 10.

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

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ZPMC QC is identified as Shao Hai Lang.

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.

Component: Bike Path

PCMK: BK010A1-001-A1

Weld Number: 044

Welder: 057258

WPS-B-P-2214-B-U2

Component: Bike Path

PCMK: BK010A1-001-A1

Weld Number: 044

Welder: 040302

WPS-B-P-2214-B-U2

BAY 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Shao Hai Lang.

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.

Component: Traveler Rail Support

PCMK: SA6022B-001

Weld Number: 029, 030

Welder: 041271

WPS-B-P-2212-TC-U4c

Component: Bike Path

PCMK: BK012A5-001

Weld Number: 016, 017

Welder: 053316

WPS-B-T-2132-ESAB

Component: Bike Path

PCMK: BK012A5-001

Weld Number: 022, 023

Welder: 046769

WPS-B-T-2132-ESAB

BAY 14

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This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08585 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Deck Plate Sub Assembly. The weld designations reviewed are as follows.

DP3097-001-010, 011, 016, 017, 025, 026, 031, 032, 040, 041, 046, 047, 055, 056, 061, 062, 070, 071, 076, 077, 085, 086

DP3094-001-094, 102, 110, 115, 120, 128

DP3095-001-077, 080, 085, 090, 095

DP3096-001-055, 067, 068

SA3013A-001-047, 051, 055, 059, 063, 065, 069, 073

Trial Assembly

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

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Liu Huajie.

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.

Component: I Rib to FB

PCMK: SEG3007C

Weld Number: 053

Welder: 055491

WPS-B-T-2233-ESAB

Component: Grillage to Stiffener

PCMK: SEG3007AH

Weld Number: 030

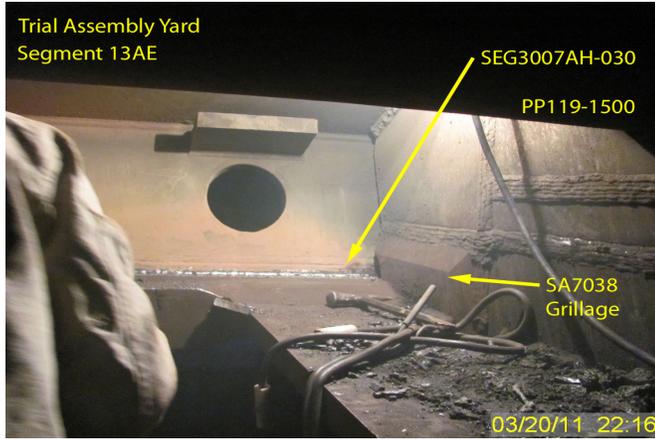
Welder: 050232

WPS-B-T-4212-B-U2c

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

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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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
