

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-022776**Date Inspected:** 23-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:** Cui Zheng Hua**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 Suspender Bracket**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 14

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

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Xiang Pin.

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: Vertical Shear Plates

PCMK: SEG3019BB

Weld Number: 089

Welder: 216086

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

Component: Vertical Shear Plates

PCMK: SEG3019BB

Weld Number: 133

Welder: 215553

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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

Component: Vertical Shear Plates

PCMK: SEG3019AQ

Weld Number: 025

Welder: 058100

WPS-B-T-2221-B-L2C-S-2

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.

Component: Steel Barrier

PCMK: E5-SB25A-003

Weld Number: 132~167

Welder: 053753

WPS-B-P-2113

Component: Steel Barrier

PCMK: W2-SB16B-002

Weld Number: 132~167

Welder: 201861

WPS-B-P-2112

BAY 19

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Guo Xing Hui.

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: Cable Bracket

PCMK: SA6529-001

Weld Number: 014

Welder: 062808

WPS-B-T-2233-ESAB

Component: Cable Bracket

PCMK: SA6529-001

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Weld Number: 094
Welder: 062806
WPS-B-T-2233-ESAB

Component: Cable Bracket
PCMK: SA6029-001
Weld Number: 064
Welder: 062749
WPS-B-T-2231-ESAB

Component: Cable Bracket
PCMK: SA6029-001
Weld Number: 028
Welder: 062783
WPS-B-T-2231-ESAB

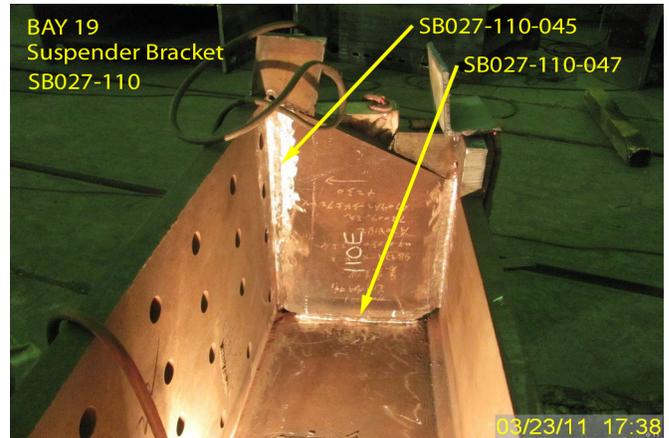
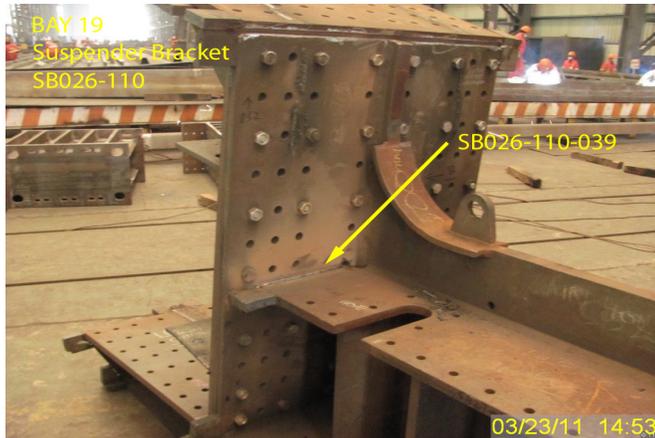
Component: Suspender Bracket
PCMK: SB027-110
Weld Number: 039
Welder: 259906
WPS-B-P-2211-TC-U4b-FCM-1

Component: Suspender Bracket
PCMK: SB026-110
Weld Number: 045, 047
Welder: 259566
WPS-B-P-2212-TC-U4b-FCM-1
WPS-B-P-2213-TC-U4b-FCM-1

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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