

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-022779**Date Inspected:** 27-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:** Wang Jun**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, 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 Flux Cored Arc Welding (FCAW) processes.

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: Anchor Plate

PCMK: SEG3020U

Weld Number: 591

Welder: 067609

WPS-B-P-2214-TC-U4b-FCM-1

Component: Anchor Plate

PCMK: SEG3020U

Weld Number: 591

Welder: 067829

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WPS-B-P-2214-TC-U4b-FCM-1

Component: Traveler Rail

PCMK: TR3015TR1-001

Weld Number: 001

Welder: 201215

WPS-B-T-2132-ESAB

Component: Traveler Rail

PCMK: TR3015TR1-001

Weld Number: 001

Welder: 067876

WPS-B-T-2132-ESAB

Component: Traveler Rail

PCMK: TR3015TR1-001

Weld Number: 001

Welder: 047866

WPS-B-T-2231-ESAB

Component: Vertical Plate

PCMK: SEG3015K

Weld Number: 192

Welder: 066673

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

Component: Vertical Plate

PCMK: SEG30115H

Weld Number: 213, 215, 217

Welder: 066674

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

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08651 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 Traveler Rails. The weld designations reviewed are as follows.

TR3002TR1-001-001, 009

TR3002TR2-001-014, 022

TR3008TR1-001-001, 009

TR3008TR2-001-014, 022

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
