

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-022787**Date Inspected:** 06-Apr-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:** Lv Li Qing**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 Zheng Zhi Wei.

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: SEG3019BB

Weld Number: 046

Welder: 058102

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

Component: Anchor Plate

PCMK: SEG3019BB

Weld Number: 156

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Welder: 044772

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

Component: Vertical Shear Plate

PCMK: SEG3019BB

Weld Number: 111

Welder: 067571

WPS-345-SMAW-4G-FCM-REPAIR-1

WR20589

Component: Deck Plate Diaphragm

PCMK: SEG3019Q

Weld Number: 166

Welder: 067079

WPS-B-T-2232-ESAB

Component: Deck Plate Diaphragm

PCMK: SEG3019Y

Weld Number: 058

Welder: 051946

WPS-B-T-2212-B-U2-FCM-1

Component: Deck Plate Diaphragm

PCMK: SEG3019Y

Weld Number: 057

Welder: 215553

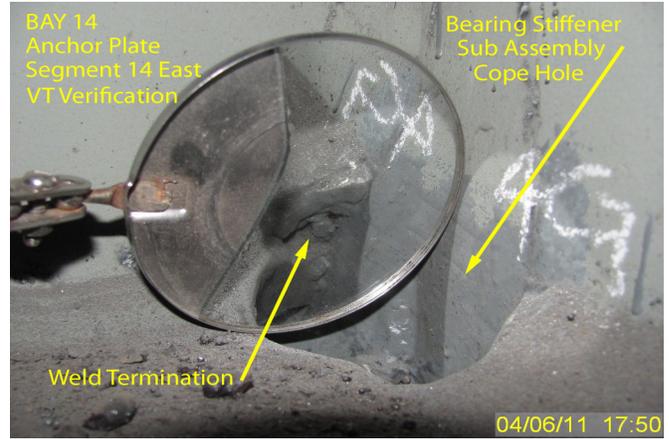
WPS-B-T-2212-TC-U4b-FCM-1

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08752 from ZPMC for Bay 14. This QA inspector performed visual testing (VT) verification of welds after ZPMC had performed their VT inspection. The segment is identified as OBG Anchor Plate Cope Holes. The cope holes were inspected at random and were found to have rejectable weld profiles, areas inspected were documented and recorded.

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