

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022975**Date Inspected:** 15-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:** Man Kit Lee**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 14

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08553 from ZPMC for Bay 14. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Deck Plate 14W. The weld designations reviewed are as follows.

DP3173-001-020~024

DP3174-001-017~021, 394

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 Xie Ming Feng.

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: Deck Plate Diaphragm

PCMK: SEG3019X

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Weld Number: 008, 009
Welder: 054013
WPS-345-SMAW-2G-FCM-REPAIR
WR20369

Component: Anchor Plate
PCMK: SEG3019BB
Weld Number: 105
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

Component: Anchor Plate
PCMK: SEG3019BB
Weld Number: 171
Welder: 215553
WPS-B-P-2212-TC-U4b-FCM-1

BAY 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.
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: Steel Barrier
PCMK: W2-SB21-001
Weld Number: 094, 095
Welder: 201889
WPS-B-T-2332

Component: Steel Barrier
PCMK: W5-SB30-003
Weld Number: 032, 043
Welder: 201905
WPS-B-P-2113

Component: Steel Barrier
PCMK: W2-SB14-004
Weld Number: 126~131
Welder: 201074
WPS-B-T-2132

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Component: Steel Barrier
PCMK: E2-SB35-001
Weld Number: 019, 050, 081
Welder: 062092
WPS-B-T-2231

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: Bike Path
PCMK: BK005A-002
Weld Number: 038, 044
Welder: 062749
WPS-B-T-2132

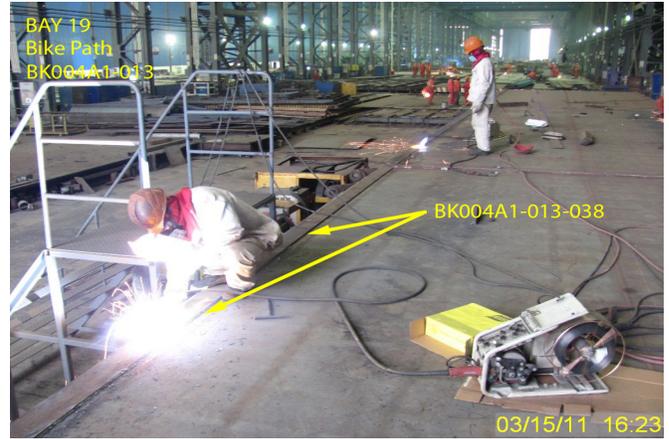
Component: Bike Path
PCMK: BK004A1-013
Weld Number: 038, 044
Welder: 062783
WPS-B-T-2132

Component: Bike Path
PCMK: BK004B-001
Weld Number: 038, 044
Welder: 058792
WPS-B-T-2132

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