

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-022976**Date Inspected:** 16-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, Steel Barrier**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 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-SB18B-001

Weld Number: 079, 080

Welder: 201861

WPS-B-T-2113

Component: Steel Barrier

PCMK: W5-SB30B-001

Weld Number: 048, 049

Welder: 053753

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WPS-B-P-2113

Component: Steel Barrier

PCMK: W5-SB30-002

Weld Number: 126~131

Welder: 053742

WPS-B-T-2132

Component: Steel Barrier

PCMK: E5-SB34-001

Weld Number: 126~131

Welder: 048625

WPS-B-T-2132

Component: Steel Barrier

PCMK: W5-SB33A-002

Weld Number: 126~131

Welder: 206296

WPS-B-T-2132

Component: Steel Barrier

PCMK: W5-SB30-001

Weld Number: 001~012

Welder: 201905

WPS-B-T-2113

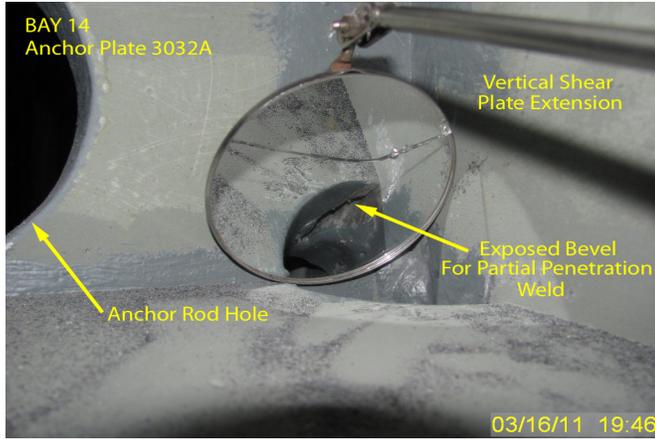
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Meeting with Kit Man AB/F QA at Bay 14 Segment 14W anchor plate AP3032A regarding weld termination on partial penetration welds at plate cope holes. Weld termination is unacceptable according to AWS D1.5 sec.3.12 at all anchor plate cope holes. AB/F and ZPMC performed grinding on two PP cope holes, welds were reinspected and found to be unacceptable. AB/F Kit Man was informed of unacceptable welds, AB/F was undecided regarding repair and will meet with superiors on March 17, 2011.

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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
