

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022987**Date Inspected:** 22-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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, Kelly Leavitt, was present during the times noted above for random 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 Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Lin, CWI Sun Tian Liang.

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.

Components; OBG 14W

PCMK: X3305K-024

Weld No: 001,002

Welder: 045240

WPS-B-T-2233-ESAB

Components; OBG 14W

PCMK: X3305K-023

Weld No: 001,002

Welder: 067876

WPS-B-T-2233-ESAB

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Components; OBG 14W
PCMK: SEG3020W
Weld No: 007
Welder: 045280
WPS-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Li Yang, CWI Li Yang.
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.

Components; OBG 14W
PCMK: BK016-001
Weld No: 011
Welder: 053869
WPS-B-T-2231-ESAB

Components; OBG 14W
PCMK: BK015D-001
Weld No: 001
Welder: 040302
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: BK015D-001
Weld No: 003
Welder: 040458
WPS-B-T-2233-ESAB

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 Zhong Lin, CWI Sun Tian Liang.
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.

Components; OBG
PCMK: TR3008TR2-001
Weld No: 021
Welder: 066674
Repair No. B-WR20714
WPS-345-SMAW-2G(2F)-Repair-1

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This Caltrans QA Inspector observed ZPMC performing match drilling in OBG, Rib Stiffener Plates, X3866F.

This Caltrans QA Inspector observed ZPMC performing flame cut beveled edge on stiffeners X4002D then heat straightening these stiffeners using the information provided on form HSR-1-10246.

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, CWI Sun Zhang Qi 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.

Components; OBG 14E

PCMK: SEG3019V

Weld No: 001

Welder: 044772

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

Components; OBG 14E

PCMK: SEG3019*

Weld No: 013

Welder: 058102

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

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

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
