

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-023073**Date Inspected:** 25-Jan-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:** Jicai Fang**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, Robin Sharma was present during the times noted above for observations relative to the work being performed at ZPMC.

This QA Inspector observed the following work in progress:

BAY # 14

Shielded Metal Arc Welding (SMAW) on weld joint SEG3015K-239 located on R.S. to floor beam 13West in bay 14. The Welder is identified as 037932. ZPMC Quality Control (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1 & repair report B-WR-20190.

Shielded Metal Arc Welding (SMAW) on weld joint SEG3014D-330 located on R.S. to floor beam 13West in bay 14. The Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1 & repair report B-WR-20191.

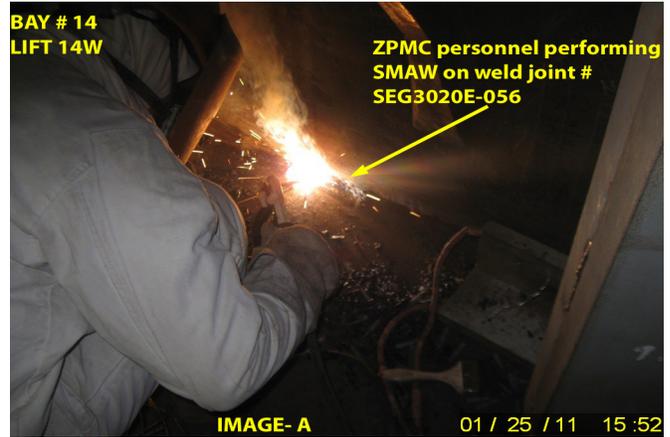
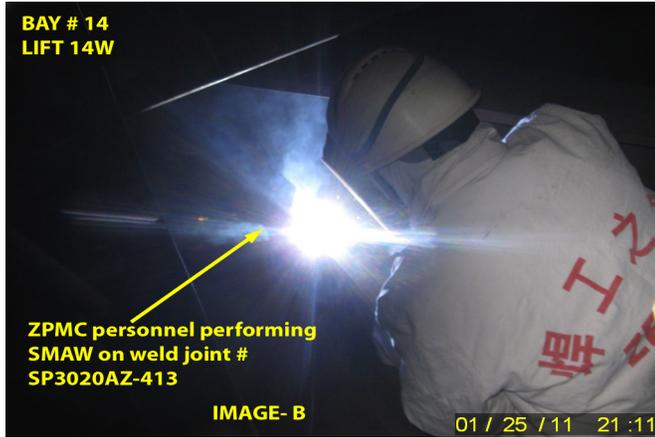
Flux Cored Arc Welding (FCAW) on weld joint SP3020AZ-415 located on stiffener to diaphragm in 14West in bay 14. The Welder is identified as 068445. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

Shielded Metal Arc Welding (SMAW) on weld joint SP3020AZ-413 located on stiffener to diaphragm in 14West in bay 14. The Welder is identified as 037780. ZPMC Quality Control (QC) is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1. For detail see Image-B below

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Shielded Metal Arc Welding (SMAW) on weld joint SEG3020E-056 located on floor beam to bottom plate in 14West in bay 14. The Welder is identified as 066398, 066038. ZPMC Quality Control (QC) is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-REPAIR & repair report B-CWR-2734. For detail see Image-A below



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 Thomas Ho (150002048250) , who represents the Office of Structural Materials for your project.

Inspected By:	Sharma,Robin	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
