

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-023126**Date Inspected:** 18-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:** Lu 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 Cross Beam**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 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: Deck Diaphragm

PCMK: SA3232B

Weld Number: 010

Welder: 066421

WPS-B-T-2233-ESAB

Component: Anchor Plate

PCMK: SEG3019U

Weld Number: 003

Welder: 215553

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WPS-345-SMAW-2G-FCM-REPAIR-1
CWR2822

Component: Edge Beam

PCMK: SEG3019N

Weld Number: 265

Welder: 044779

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

WR20407

Component: Anchor Plate

PCMK: SEG3019BB

Weld Number: 017

Welder: 216086

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

TRIAL ASSEMBLY YARD

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08572 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Cross Beam 17. The weld designations reviewed are as follows.

FB3056-013, 014, 015, 016, 017, 018

FB3081-007, 008, 009, 010, 011, 012

SEG3004AG-073, 074, 077, 078, 081, 082, 127, 128, 131, 132, 163, 164, 167, 168, 175, 176

12AW/CB17 I Rib Holdback Welds PP111~PP112

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 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