

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-023135**Date Inspected:** 20-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: SEG3020V

Weld No: 039

Welder: 045280

WPS-B-T-2232-ESAB

Components; OBG Traveler Rail

PCMK: TR3015TR1-001

Weld No: 002

Welder: 045240

WPS-2233-ESAB

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Components; OBG Traveler Rail
PCMK: TR3027TR3-001
Weld No: 011
Welder: 067876
Weld Repair No. B-WR20755
WPS-345-FCAW-3G(3F)-FCM-Repair-1

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 Traveler Rail
PCMK: TR3002TR2-001
Weld No: 002,008
Welder: 066673, 067611
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W (see photo below)
PCMK: SEG3020 Fit Up
Weld No: (011) Temporary Attachments
Welder: 218662, 047866
WPS-B-P-2112

This Caltrans QA Inspector observed ZPMC performing match drilling in OBG, Rib Stiffener Plates, X4000 ~ X4066.

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, QA 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 14 E
PCMK: SEG3019S
Weld No: 009
Welder: 215553
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019*
Weld No: 001

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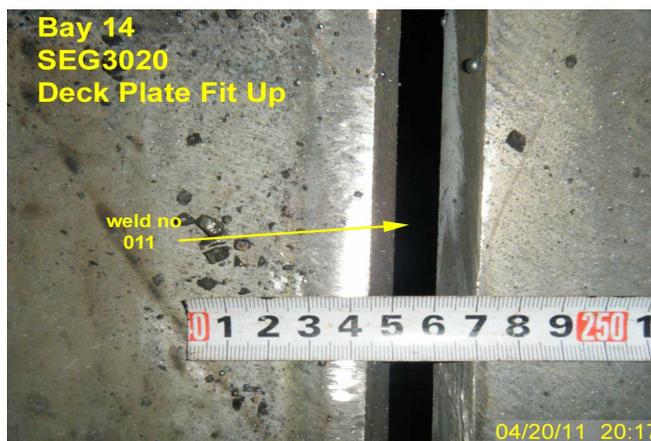
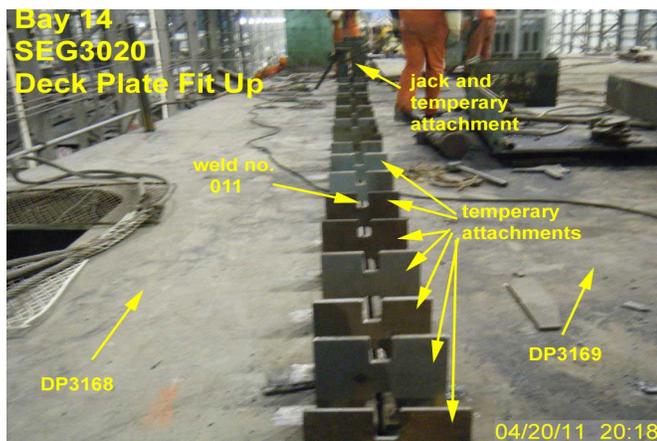
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019N
Weld No: 005,009,007,011.013
Welder: 501946
WPS-B-P-2214-TC-U4b-FCM-1

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 Xie Ming Feng, QA 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: SEG3019E
Weld No: 185,189,193
Welder: 051356
WPS-B-T-2232-ESAB

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.

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Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer