

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-023136**Date Inspected:** 21-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: SEG3020BE-001

Weld No: 002

Welder: 045241

WPS-B-T-2232-ESAB

Components; OBG 14W (see photo below)

PCMK: BK16-001

Weld No: 003,019

Welder: 044473, 040436

WPS-2233-ESAB

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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: SEG3020BE-001

Weld No: 002

Welder: 045246

WPS-B-P-2214-TC-U4b-FCM-1

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 Submerged Arc Welding (SAW) 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 14 W

PCMK: SEG3020*

Weld No: 011

Welder: 065175, 067876

WPS-B-T-223(2)1T-ESAB-1

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

This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates OBG13-X4113A.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 14 East. The weld designations reviewed are as follows:

SEG3019V-35,37,39,41,43,45,47,49,51,53,55,57,169,171,173,175,177,179,181

SEG3019W-52,54,56,58,60,62,64,66,68,86,88,90,92,94,96,98,100,102

SEG3019S-295,299,303,307,311,315,339,324,328,332,297,301,305,309,313,317,322,326,330,291

SEG3019X-95,96,11~26,55~74

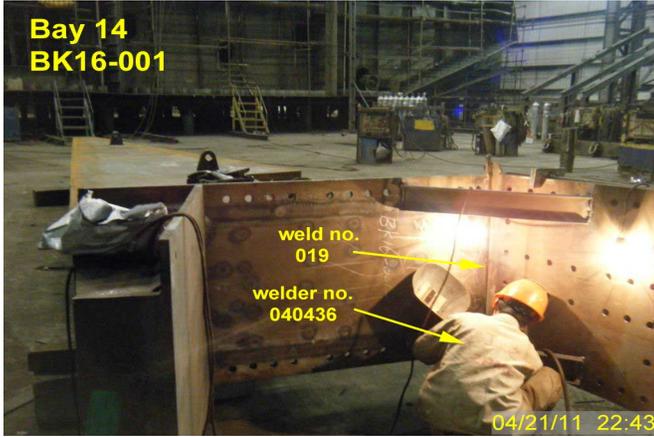
SEG3019Z-14,15

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

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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
