

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-023270**Date Inspected:** 29-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 14

This QA observed ZPMC qualified welding personnel identified as 067611 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint TR3027TR2-001-004,001. ZPMC Quality Control Personnel (QC) identified as Mr. An qing xiang present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and Weld Repair Report B-WR20755.

OBG # SEGMENT 13AW

This QA observed ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SP3091B-011. ZPMC Quality Control Personnel (QC) identified as Mr. Shen jian bo present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 069683 perform Shielded Metal Arc Welding

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

(SMAW) Process on weld joint SP3091-144. ZPMC Quality Control Personnel (QC) identified as Mr. Shen jian bo present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 066002 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint FB3178-001-167. ZPMC Quality Control Personnel (QC) identified as Mr. Shen jian bo present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and Weld Repair Report B-WR20819.

OBG # CROSSBEAM CB18

This QA observed ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW) Process on weld joint DP3112-018-026,027. ZPMC Quality Control Personnel (QC) identified as Mr. Liyang present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 220066 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3114-018-026,027. ZPMC Quality Control Personnel (QC) identified as Mr. Li yang present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG # CROSSBEAM CB19

This QA observed that ZPMC personnel perform Crossbeam CB19 fit-up to lift 14 East line and west line. No significant work was being performed on this crossbeam during the time QA was present.

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

Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
