

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-023579**Date Inspected:** 08-May-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.

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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 BK24A7-001. The weld designations reviewed are as follows:

BK24A6-001-005~008,013~017,054~059,110,090,098,100,105,108,109,120~123

BK24A7-001-047,048,053,054,059,060,061,062,067,068,073,074,168~172,245~256

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.

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: VP3016-001

Weld No: 003,004

Welder: 044779

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Weld Repair No. B-WR20779
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14E

PCMK: SEG3019*

Weld No: 033

Welder: 215553

Weld Repair No. B-WR20889

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14 E

PCMK: SEG3019AL

Weld No: 009,010

Welder: 058087

Weld Repair No. B-WR20235

WPS-345-SMAW-2G(2F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.

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 13CE

PCMK: SEG3019K

Weld No: 347,350,349

Welder: 051556

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wang Xiang Pin.

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 (see photos)

PCMK: OBW13

Weld No: 001

Welder: 045270

WPS-B-T-223(3)1T-ESAB-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Xiang Pin.

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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: CA3015A
Weld No: 001
Welder: 067942
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: DP3116-001
Weld No: 052,053
Welder: 066673
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3013A
Weld No: 018,022
Welder: 066674
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Xiang Pin.

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: OBW13B
Weld No: 005
Welder: 067876
WPS-B-T-2231-ESAB

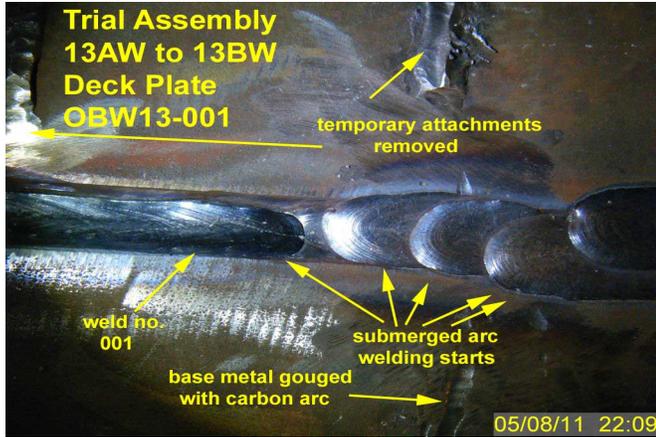
Components; OBG 14E
PCMK: OBW13B
Weld No: 004
Welder: 067275
WPS-B-T-2231-ESAB

Components; OBG 14E
PCMK: SEG3013A
Weld No: 001
Welder: 045175
WPS-B-T-2232-ESAB

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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.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer