

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023735**Date Inspected:** 12-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.

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 Xie Ming Feng and ABF QA Sha Zhi.

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: SEG3019AF

Weld No: 005,006,072,073,012,013

Welder: 0044779

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14E

PCMK: SEG3019AF

Weld No: 087,088,040,041,047,048

Welder: 215553

WPS-B-P-2213-TC-U4b-FCM-1

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Components; OBG 13CE
PCMK: CA3014A
Weld No: 127,131,135,139,143
Welder: 058102
WPS-B-P-2213-b-U2-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 Xie Ming Feng and ABF QA Sha Zhi.
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 13BE
PCMK: OBE13K
Weld No: 1~4
Welder: 050977
WPS-B-T-2231-ESAB

Components; OBG 13BE
PCMK: SEG3009H
Weld No: 091,086,081,096
Welder: 055564
WPS-B-T-2233-ESAB

Components; OBG 13AE
PCMK: SEG3007L
Weld No: 065,069,073,077
Welder: 052696
WPS-B-T-2233-ESAB

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 Shen Jian Bo and ABF QA Sha Zhi.
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 13BW
PCMK: OBW13B
Weld No: 005
Welder: 067520
WPS-B-P-2214-B-V2a-FCM-1

Components; OBG 13AW

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PCMK: DP3122-001
Weld No: 244
Welder: 067829
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG
PCMK: SEG3013C
Weld No: 059,065,096,100,102
Welder: 066398
Weld Repair No. B-WR20824
WPS-345-SMAW-3G(3F)-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 Shen Jian Bo and ABF QA Sha Zhi.
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: OBE13AD
Weld No: 005
Welder: 050242
WPS-B-T-2233-ESAB

Components; OBG
PCMK: SEG3013B
Weld No: 101,107,143,178
Welder: 067876
Weld Repair No. B-WR20824
WPS-345-FCAW-3G(3F)-ESAB-Repair-1

Components; OBG 13BE
PCMK: SEG3009H
Weld No: 071,076,081,086,091,101
Welder: 055564
WPS-B-T-2133-ESAB

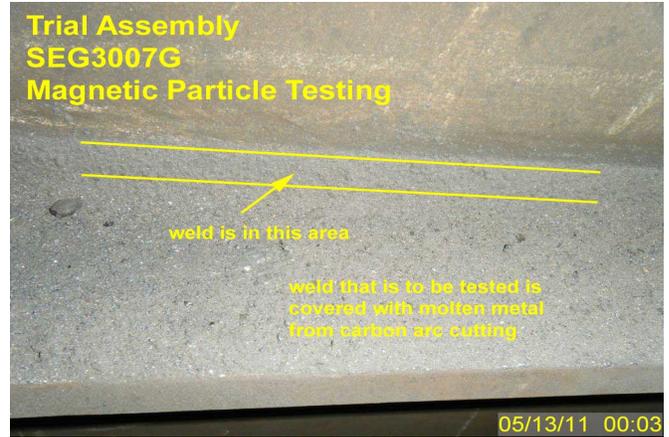
This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBE13AE. The weld designations reviewed are as follows: (see photos)

SEG3007F-007
SEG3007G-001,008
SEG3007H-008
SEG3007J-001,007

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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
