

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-024056**Date Inspected:** 26-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 Wong Xiang Pin 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: OBW13B

Weld No: 001

Welder: 067520, 066398

Weld Repair No. B-WR21077

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

Components; OBG 14E

PCMK: OBW13B

Weld No: 003

Welder: 067829

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Weld Repair No. B-WR21077
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 14E
PCMK: VP3016-001
Weld No: 003,004
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E
PCMK: VP3017-001
Weld No: 002,003
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: SEG3079V
Weld No: 244
Welder: 058087
WPS-B-P-2211-B-U2-FCM-1

Components; OBG 13CE (see photo)
PCMK: SEG3019V
Weld No: 243,245
Welder: 058087
WPS-B-P-2211-TC-U4b-FCM-1

Components; OBG
PCMK: AH3151A
Weld No: 032,065
Welder: 051359
WPS-B-P-2212-B-U2-FCM-1

Components; OBG 13CE
PCMK: VP3007-001
Weld No: 011,036,075
Welder: 216086
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: VP3008-001
Weld No: 014,028
Welder: 216086
WPS-B-P-2214-TC-U4b-FCM-1

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Components; OBG 13CE
PCMK: VP3014-001
Weld No: 020,031
Welder: 068494
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: VP3015-001
Weld No: 011,022
Welder: 068494
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: VP3018-001
Weld No: 002,003
Welder: 068494
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE
PCMK: VP3019-001
Weld No: 008,009
Welder: 068494
WPS-B-P-2212-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 Wong Xiang Pin 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: SEG3019E-1
Weld No: 162
Welder: 050242
WPS-B-T-2233-ESAB

Components; OBG 13CE
PCMK: SEG3011H
Weld No: 003
Welder: 052696
Weld Repair No. B-WR21038
WPS-345-FCAW-3G(3F)-FCM-Repair-1

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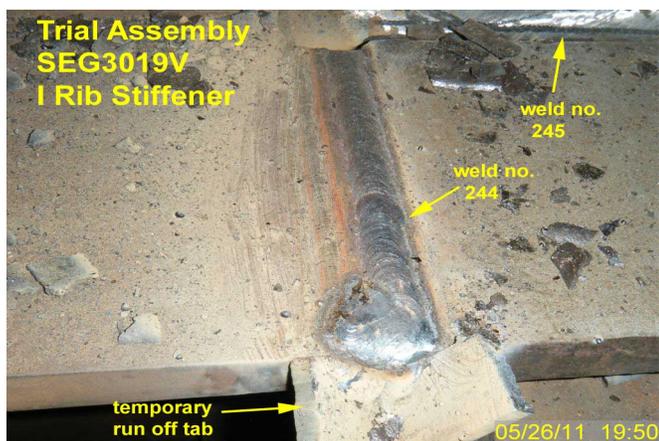
Components; OBG 13CE
PCMK: SEG3009
Weld No: 086,090,075
Welder: 055491
WPS-B-T-2233-ESAB

Components; OBG 13CE
PCMK: FB3134-001
Weld No: 134,129,122
Welder: 050977
WPS-B-T-2132-ESAB

Components; OBG 13CE
PCMK: SEG3007AD
Weld No: 092,093,098,099
Welder: 055491
WPS-B-T-2132-ESAB

Components; OBG 13CE
PCMK: SEG3007AD
Weld No: 090,091,096,097,094,095
Welder: 055491
WPS-B-T-2133-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

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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
