

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-024225**Date Inspected:** 02-Jun-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 Zhan Hal Fang.

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: DP3161-001

Weld No: 038

Welder: 066258, 016086

Repair No. B-WR20276

WPS-345-SMAW-4G(4F)-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 Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BW
PCMK: SA3134-(001~008)
Weld No: 006,008
Welder: 045143
WPS-B-T-2132-ESAB

Components; OBG
PCMK: SA6003D
Weld No: 007,008
Welder: 215676
WPS-B-T-2231-ESAB

Components; OBG
PCMK: SA3152B-001
Weld No: 001~004
Welder: 037705, 048696
WPS-B-T-2231-ESAB

Components; OBG
PCMK: SA3152B-002
Weld No: 001~004
Welder: 037705, 048696
WPS-B-T-2231-ESAB

Components; OBG
PCMK: SA3152B-003
Weld No: 001~004
Welder: 037705, 048696
WPS-B-T-2231-ESAB

Components; OBG
PCMK: SA3152B-004
Weld No: 001~004
Welder: 037705, 048696
WPS-B-T-2231-ESAB

Components; OBG
PCMK: SA3155C
Weld No: 005,006
Welder: 069469
WPS-B-T-2232-ESAB

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Components; OBG
PCMK: SA3155D
Weld No: 007,008
Welder: 069469
WPS-B-T-2232-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 Zhang Lin.

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 13CW
PCMK: SEG3015H
Weld No: 198,199
Welder: 045196
WPS-B-P-2113-FCM-1

Components; OBG 13BW
PCMK: AH3002A
Weld No: 049
Welder: 069866, 070009
WPS-B-P-2114-FCM-1

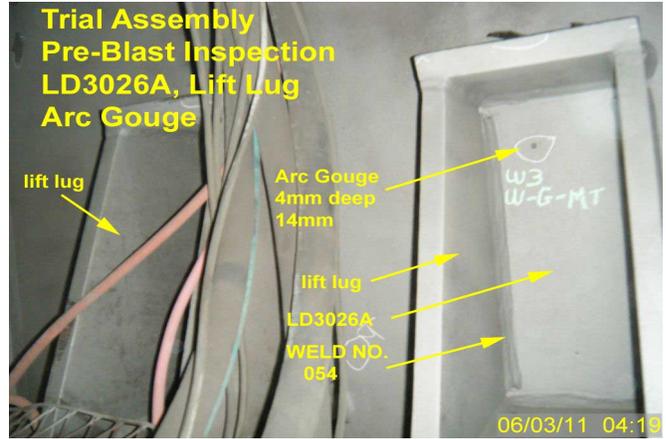
Components; OBG
PCMK: SEG3020AX
Weld No: 007,012,017,022,027
Welder: 037998
Repair No. B-WR21177
WPS-345-SMAW-3G(3F)-FCM-Repair-1

This Caltrans QA Inspector performed a pre-blast visual inspection in OBG13AW. This inspection included the bottom surface of Deck Plates DP3079A, DP3080A, SA7040A, and approximately 1500mm of the top sides of all Floor Beams and Diaphragms between Panel Point 119 + 1500 through 120 and Longitudinal Diaphragm LD3026A through Longitudinal "K" Plate KP3093A. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with black masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings. (see photos)

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

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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