

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-024227**Date Inspected:** 05-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 Flux Core Arc Welding (FCAW) 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 13AE

PCMK: SEG3007Q

Weld No: 336~338

Welder: 055491

WPS-B-T-2231-ESAB

Components; OBG 13AE

PCMK: SEG3009V

Weld No: 009,011,013,015

Welder: 050977, 052696

WPS-B-T-2231-ESAB

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Components; OBG 13AE + 13BE

PCMK: SA3032D-001

Weld No: 007,008

Welder: 066746

WPS-B-T-2231-ESAB

Components; OBG 13AE + 13BE

PCMK: SA3032D-002

Weld No: 007,008

Welder: 066746

WPS-B-T-2231-ESAB

Components; OBG 13AE + 13BE

PCMK: SA3032B-001

Weld No: 005,006

Welder: 066746

WPS-B-T-2231-ESAB

Components; OBG 13AE + 13BE

PCMK: SA3032B-002

Weld No: 005,006

Welder: 066746

WPS-B-T-2231-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 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 14E

PCMK: SEG3019S

Weld No: 111,112

Welder: 216086, 501946

Repair No, B-WR21050

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E

PCMK: SEG3019Q-002

Weld No: 180,181

Welder: 216086, 501946

Repair No, B-WR21050

WPS-345-SMAW-3G(3F)-FCM-Repair-1

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Components; OBG 14E
PCMK: CB3003A
Weld No: 019,001
Welder: 067795
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14E
PCMK: FB3329-001
Weld No: 010
Welder: 067795
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13AE + 13BE
PCMK: OBE13B
Weld No: 001~003
Welder: 043661
Repair No, B-CWR2992
WPS-345-SMAW-4G(4F)-FCM-Repair-1

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
