

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-024228**Date Inspected:** 30-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 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 OBG14 East. The weld designations reviewed are as follows:

SEG3020Z-11,12,15~18,41~50,74~76

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 Zhen Hal Fong.

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: SA3214-001

Weld No: 007

Welder: 058102

Repair No. B-WR20501

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

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

Components; OBG 13BE

PCMK: OBE13B

Weld No: 016,017,

Welder: 068859

WPS-B-P-2114-FCM-1

Components; OBG 13CE

PCMK: SEG3019G

Weld No: 089

Welder: 058087, 067611

Repair No. B-WR21054

WPS-345-SMAW-1G(1F)-FMC-Repair-1

Components; OBG 14E

PCMK: DP3165-001

Weld No: 002

Welder: 215553

WPS-B-P-2211-TC-U4b-FCM-1

Components; OBG 13CE

PCMK: SEG3019AH

Weld No: 002

Welder: 044779

Repair No. B-WR21107

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

Components; OBG 13CE

PCMK: SEG3009AH

Weld No: 003

Welder: 055733

Repair No. B-WR21107

WPS-345-SMAW-2G(2F)-FMC-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 Zhen Hal Fong.

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: FB3121-001

Weld No: 130,141,146,100,105,110

Welder: 066746

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

WPS-FCAW-2132-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 + 14W

PCMK: LD3029-001

Weld No: 122,123

Welder: 069469

WPS-B-P-2112-FCM-1

Components; OBG 13CW + 14W

PCMK: LD3040-001

Weld No: 158,159

Welder: 069469

WPS-B-P-2114-FCM-1

Components; OBG 13CW + 14W

PCMK: DP3155-001

Weld No: 039,040

Welder: 066881

WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 13CW + 14W

PCMK: DP3148-001

Weld No: 001,002

Welder: 066881

WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 13CW + 14W

PCMK: DP3172-001

Weld No: 017

Welder: 067829, 067275

WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 13CW + 14W

PCMK: DP3148-001

Weld No: 257

Welder: 067829, 067275

WPS-B-P-2114-TC-U4b-FCM-1

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

Components; OBG 13CW + 14W
PCMK: DP3146-001
Weld No: 257
Welder: 067829, 067275
WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 13AW + 13BW
PCMK: CA3015A
Weld No: 001
Welder: 037998
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13AW + 13BW
PCMK: SEG3013AA
Weld No: 120,108
Welder: 037998
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 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 13AW + 13BW
PCMK: KP3015-001
Weld No: 005
Welder: 067876
WPS-B-T-2232-ESAB

Components; OBG 13AW + 13BW
PCMK: KP3017-001
Weld No: 003
Welder: 067876
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 Xie Ming Feng.
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: SEG3009AH

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

Weld No: 149
Welder: 047864
Repair No. B-WR20966
WPS-345-SMAW-4G(4F)-FMC-Repair-1

Components; OBG 13CE
PCMK: SEG3009G
Weld No: 087
Welder: 066674
Repair No. B-WR20604
WPS-345-SMAW-3G(3F)-FMC-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
