

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024533**Date Inspected:** 18-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

Blast Inspection

OBG Blast Shop 2

This QA Inspector randomly observed the following work in progress:

OBG CB18

This Quality Assurance (QA) Inspector performed random visual inspection (VT) of OBG CB18 external deck panel, bottom panel and side plates surfaces after grit blasting. Areas marked up for weld repair were recorded on a weld map for future repair and repair locations have been taped. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

OBG Blast Shop 4

This QA Inspector randomly observed the following work in progress:

OBG Segment 13AW+13BW

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This Quality Assurance (QA) Inspector performed random visual inspection (VT) of OBG segment 13AW and 13BW internal deck plates, U-rib, edge plates and floor beam surfaces after grit blasting in between panel point PP119 to PP122. Areas marked up for weld repair were recorded on a weld map for future repair and repair locations have been taped. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

WELDING

Bay 14

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020W-189 located on the OBG Segment 14W. The welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020N-169 located on the OBG Segment 14W. The welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joints identified as SEG3020AJ-043 located on the OBG Segment 14W. The welder is identified as 068494. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

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-15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Singh, Vikram

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer