

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024627**Date Inspected:** 28-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wei**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.

WELDING

OBG 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 joint identified as DP3020M-190 located on Bottom Plate of the OBG Segment 14W. The welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020W-116 located on Floor Beam of the OBG Segment 14W. The welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020W-179 located on Floor Beam of the OBG Segment 14W. The welder is identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. 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 joint identified as Seg3020W-182 located on Floor Beam of the OBG Segment 14W. The welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AY-045 located on Floor Beam to Side Plate I-Rib of the OBG Segment 14W. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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 joint identified as Seg3020AY-033 located on Floor Beam to Side Plate I-Rib of the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020M-187 located on Edge Beam to Floor Beam of the OBG Segment 14W. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020M-186 located on Edge Beam to Bottom Plate of the OBG Segment 14W. The welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020T-202 located on Floor Beam to Longitudinal Diaphragm of the OBG Segment 14W. The welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AZ--368 located on Side Plate to Edge Plate of the OBG Segment 14W. The welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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

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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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
