

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024628**Date Inspected:** 29-Jan-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:** 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 DP3009K-157 located on Deck Panel Diaphragm of the OBG Segment 13BE. The welder is identified as 066258. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-CWR2778.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007AD-016 located on Floor Beam of the OBG Segment 13AE. The welder is identified as 066326. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20210.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019L-1-085 located on Floor Beam of the OBG Segment 14E. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-CWR2645.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019K-1-011 located on Longitudinal Diaphragm of the OBG Segment 14E. The welder is identified as 050969. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-CWR2726.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019U-003 located on Anchor Plate of the OBG Segment 14E. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-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 Seg3020AZ-005 located on Edge Beam to Floor Beam 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-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020AZ-414 located on Floor Beam to Side 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-2133-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3007AT-045 located on the OBG Segment 13AE. The welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. 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 DP3167-001-256/257 located on Deck Plate U-Rib of the OBG Segment 14E. The welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhong Yang Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB. See Photo below

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
