

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-024638**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**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.

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3007AV-066 located on Floor Beam I-Stiffener of the OBG Segment 13AE. The welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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 Seg3007AV-066 located on Floor Beam I-Stiffener of the OBG Segment 13AE. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3007U-271 located on Floor Beam I-Stiffener of the OBG Segment 13AE. The welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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 Seg3007AT-104 located on Floor Beam to Stiffener of the OBG Segment 13AE. The welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007X-487 located on SA to Floor Beam stiffener of the OBG Segment 13AE. The welder is identified as 037723. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007X-479 located on SA to Floor Beam stiffener of the OBG Segment 13AE. The welder is identified as 044722. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. 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 Seg3019BB-081 located on SA to Bottom Plate of the OBG Segment 14E. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Xieming Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR2737.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019AA-002 located on Floor Beam to longitudinal Diaphragm of the OBG Segment 14E. The welder is identified as 066422. ZPMC Quality Control (QC) is identified as Mr. Xieming Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR2774.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019L-1-090 located on FB to Longitudinal Diaphragm of the OBG Segment 14E. The welder is identified as 066418. ZPMC Quality Control (QC) is identified as Mr. Xieming Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-CWR2646.

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

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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
