

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024772**Date Inspected:** 03-Jun-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 observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Hal Fang.

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 (see photos)

PCMK: SEG3007AH

Weld No: 062

Welder: 066476, 068859

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13BE

PCMK: SA3013

Weld No: 075

Welder: 215553

WPS-B-P-2214-TC-U4b-FCM-1

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Components; OBG 13CE
PCMK: SEG3019G
Weld No: 009,011
Welder: 216086
WPS-B-P-2113FCM-1

Components; OBG 13CE
PCMK: SEG3019G
Weld No: 096,098
Welder: 216086
WPS-B-P-2114FCM-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 Zhan Hal Fang.
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 13BE
PCMK: SEG3009V
Weld No: 034
Welder: 055564
WPS-B-T-2231-ESAB

Components; OBG 13BE
PCMK: SEG3009V
Weld No: 034
Welder: 052696
WPS-B-T-2231-ESAB

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 13CW + 14W
PCMK: SA3152A-(003~005)
Weld No: 001,002
Welder: 037705
WPS-B-T-2231-ESAB

Components; OBG 13CW + 14W

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PCMK: SA3152B-(003~005)

Weld No: 003,004

Welder: 037705

WPS-B-T-2231-ESAB

Components; OBG 13CW + 14W

PCMK: SA3155C-(001~006)

Weld No: 005,006

Welder: 069409

WPS-B-T-2232-ESAB

Components; OBG 13CW + 14W

PCMK: SA3155D-(001~006)

Weld No: 007,008

Welder: 069409

WPS-B-T-2232-ESAB

Components; OBG 13AW

PCMK: SA6004A-(001~004)

Weld No: 001,002

Welder: 215676

WPS-B-T-2231-ESAB

Components; OBG 13AW

PCMK: SA6004B-(001~004)

Weld No: 003,004

Welder: 215676

WPS-B-T-2231-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 14W

PCMK: SEG3020*

Weld No: 012

Welder: 068917

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14W

PCMK: SEG3015

Weld No: 009

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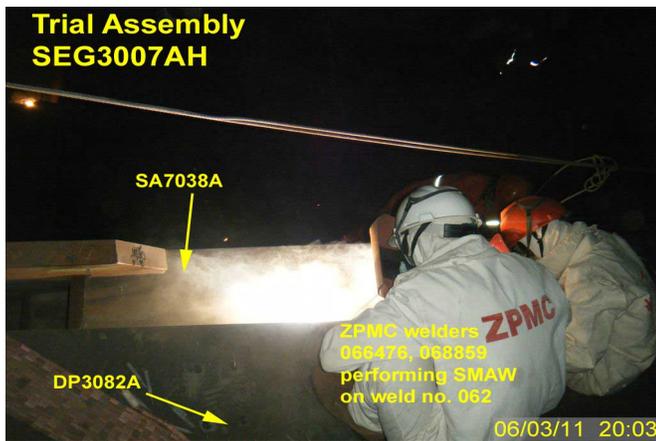
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Welder: 068917
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW + 14W
PCMK: SA7521C-001
Weld No: 005,006
Welder: 066881
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW + 14W
PCMK: SA7521D-001
Weld No: 007,008
Welder: 066881
WPS-B-P-2214-TC-U4b-FCM-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