

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-024868**Date Inspected:** 28-Feb-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.

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 DP3013-001-253 located on Deck Plate of the OBG Segment 13CE. The welder is identified as 044790. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. 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 Seg3011J-002 located at PP123 of the OBG Segment 13CE. The welder is identified as 201423. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. 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 SEG3007A-003 located on FL4 Plate Stiffener of the OBG Segment 14E. The welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. 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 SA3066-001-026 located on FL4 Plate of the OBG Segment 14E. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3163-001-025 located on Deck Panel Diaphragm of the OBG Segment 14E. The welder is identified as 215553. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair & B-WR20222.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3167-001-037 located on Deck Panel Diaphragm of the OBG Segment 14E. The welder is identified as 050969. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair & B-WR20271.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3160-001-004 located on Longitudinal Diaphragm Connection Plate of the OBG Segment 14E. The welder is identified as 044631. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair & B-WR2249.

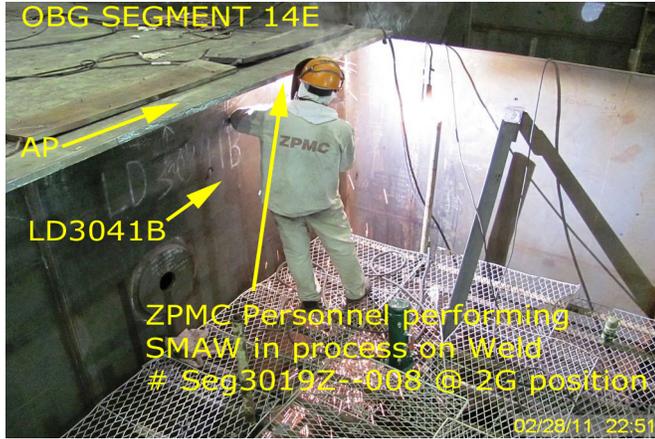
This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3162-001-401 located on U-Rib to Deck Panel Diaphragm of the OBG Segment 14E. The welder is identified as 049861. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3019Z-008 located on Longitudinal Diaphragm to AP of the OBG Segment 14E. The welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1. See attached photo for details:

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
