

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-025043**Date Inspected:** 05-Jun-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:** Mr. Li Yan Hua**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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

OBG-Trial assembly Yard

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 014 as per WRR no. B-WR-21158, Located on Vertical plate I rib in Segment 13CE, VP3008-001. Welder is identified as 037723. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) - Repair.

Repair welding of Weld joint- 007 as per WRR no. B-WR-21158, Located on Vertical plate I rib in Segment 14AE, VP3017-001. Welder is identified as 067183. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) - Repair.

Weld joint- 003, Located on Cross beam CB19, Bottom plate to Side plate CB003A-019. Welder is identified as 057795. ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212- TC-U4B-F-1.

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Weld joint- 001, Located on Cross beam CB19, Bottom plate to Side plate CB003A-019. Welder is identified as 049709. ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214- TC-U4B-F-1.

Repair welding of Weld joint- 106 as per WRR no. B-WR-21154, Located on Segment 14W, SEG3020A2. Welder is identified as 066239. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) - Repair.

Repair welding of Weld joint- 004 as per CWR no. B-CWR-2998, Located on Segment 14W, Side plate to Edge plate. Welder is identified as 066156. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) – FCM –Repair -1.

Weld joint- 001, Located on Floor beam to Side plate, PP 127, SEG 3020L. Welder is identified as 066326. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213- TC-U4B-FCM-1.

Flux cored Arc Welding (FCAW)

Weld joint- 034, Located on Deck plate splice to Architectural housing at PP 125, SEG 3020V. Welder is identified as 066421. ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T- 2232 –ESAB.

For further information's, see the pictures 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 relevent 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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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