

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025098**Date Inspected:** 22-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.

Bay 14

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Segment 14E at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates X3668H, X3689H and X3669H.

This Caltrans QA Inspector during random observation at ZPMC noted that back gouging was being performed using the Carbon Arc Cutting (CAC) process on splice plates. Also noted at this location was ZPMC grinding these back gouge areas to a bright metal finish in preparation for the welding process as outlined in the contract documents. Splice plates were marked with piece numbers SA3042-007-002, SA3042-007-001, SA3042-001-003, SA3042-003-003, SA3042-005-003, SA3042-006-003, SA3042-001-001, SA3042-009-007, SA3042-008-007, SA3042-007-007, SA3042-002,007.

This Caltrans QA Inspector performed a pre-blast visual inspection of the interior surface and internal components of Lift 13W from PP119 + 1500 to PP120. Inspection request number is reported as 7037 and OBG 13W was located in Port bay 4. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the

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coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

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 Li Pin.

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 14E

PCMK: Lift Lugs

Weld No: 001,002

Welder: 067184, 067183

WPS-B-P-2114-TC-U4b

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
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Reviewed By:	Riley,Ken	QA Reviewer
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