

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025703**Date Inspected:** 23-Jul-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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joint SEG3014S-090 located on PCMK OBG 13AW. Welder was identified as 045246. QC was identified as ZPMC CWI Li Ping (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2211-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints SEG3014D-139, 141; SEG3014D-165, 213 located on PCMK OBG 13AW. Welder was identified as 045196. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 and WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

Vessel Zhenhua #19

This QA Inspector randomly observed the following work in progress in the Vessel Zhenhua #19:

SMAW welding of weld joints CB3002A-018-007, 008, 010, 012, 033, 034, 037, 038, 039, 040 located on PCMK CB18. Welders were identified as 054467, 220068, 069769. QC was identified as ZPMC CWI An Qing Xiang (QC2). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data

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was ZPMC QC Wang Xiang Pin (QCA1), who was not a CWI. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 and per Notification for Engineer's Review and Approval B-JC153R0, approved by E.T. on 7/9/11 as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
