

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026337**Date Inspected:** 26-Apr-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:** Li Ying**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**TA-Yard**

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 SEG3007E-173 located on side plate I-Rib of the OBG Segment 13AE. The welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-ESAB-Repair and B-WR20797.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as OBW13K-004 located on corner assembly stiffeners of the OBG Segment 13AE and 13BE. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded

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by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as OBW13K-007 located on corner assembly stiffeners of the OBG Segment 13AE and 13BE. The welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as CA3004-005 located on edge plate to side plate of the OBG Segment 12CE. The welder is identified as 044504. ZPMC Quality Control (QC) is identified as Mr. Wang Li Ying. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SP3103-001-184 located on side plate of the OBG Segment 13AW. The welder is identified as 037779. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20812.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3013H-055 located on the OBG Segment 13AW. The welder is identified as 066019. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20577.

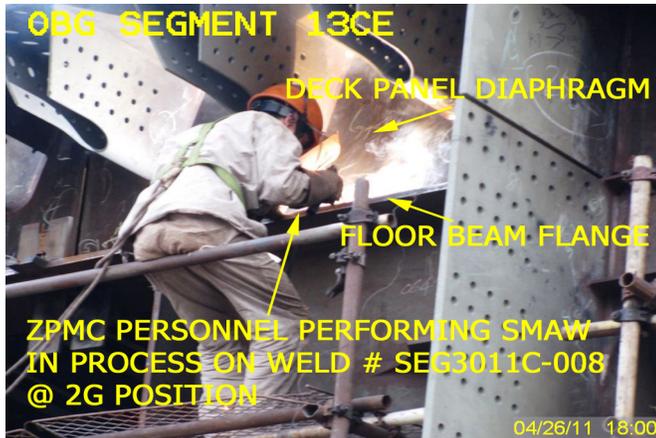
This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3013AA-114 located on the OBG Segment 13AW. The welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20579.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3011C-008 located on floor beam flange to deck panel diaphragm of the OBG Segment 13CE. The welder is identified as 044760. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1. For more details please see attached photo 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 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 James Devey, 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
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Reviewed By:	Patterson, Rodney	QA Reviewer
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