

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-026362**Date Inspected:** 27-Mar-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:** Lv Li Qing**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:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020U-591 located on anchor plate of the OBG Segment 14W. The welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020AG-004 located on the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FM-Repair and B-WR20428.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3015H-207 located on vertical plate of the OBG Segment 13CW. The welder is identified as 215217. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3015H-215 located on vertical plate of the OBG Segment 13CW. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3015K-129 located on the OBG Segment 13CW. The welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. 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 Seg3014S-055 located on the OBG Segment 13BW. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3020L-011 located on the OBG Segment 14W. The welder is identified as 045198. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair and B-WR20506.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3015TR1-001 located on traveler rail. The welder is identified as 047866. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3015TR1-002 located on traveler rail. The welders are identified as 201215 and 066734. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. 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 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
