

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-017648**Date Inspected:** 19-Sep-2010**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:** Liu fa Wen**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:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 126~141,022,023,053 and 054 located on PCMK

E2-SB1-004 Welder is identified as 216872 ZPMC QC is identified as Tian Lei

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 001~012, and 063~076 located on PCMK E2-SB2-003

Welder is identified as 216575 ZPMC QC is identified as Tian Lei

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Flux Cored Arc Welding (FCAW) welding of weld joint 126~141 located on PCMK E2-SB2-003 Welder is identified as 059450 ZPMC QC is identified as Tian Lei

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) repair welding of weld joint 009 located on 20TR2-032 with repair report No B-WR14303 rejected by ZPMC UT, Welder is identified as 215397 ZPMC QC is identified as Tian Lei

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-repair-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Flux Cored Arc Welding (FCAW) repair welding of weld joint 011 located on 20TR2-032 with repair report No B-WR14307 rejected by ZPMC UT, Welder is identified as 203710 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-repair-1.

Bay 2

Flux Cored Arc Welding (FCAW) welding of weld joint 022,023,053 and 054 located on PCMK
E5-SB1-005 Welder is identified as 062708 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 022,023,053 and 054 located on PCMK
E5-SB1-014 Welder is identified as 045203 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 087 and 088 located on PCMK
FB 3321-001 Welder is identified as 058245 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 084 and 085 located on PCMK
FB 3317-001 Welder is identified as 045209 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 002 located on PCMK
LD3048-001 Welder is identified as 250050 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Flux Cored Arc Welding (FCAW) welding of weld joint 002 located on PCMK
LD3051-001 Welder is identified as 207237 ZPMC QC is identified as Tian Lei
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Bay 3

Flux Cored Arc Welding (FCAW) welding of weld joint 030 and 031 located on PCMK
FB 3261-001 Welder is identified as 217805 ZPMC QC is identified as Zhu Lin
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) repair welding of weld joint 002 located on FB3286-001 with repair report No B-WR15035 rejected by ZPMC UT, Welder is identified as 206623 ZPMC QC is identified as Zhu Lin
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-repair-1.

Bay 6

Flux Cored Arc Welding (FCAW) welding of weld joint 040 located on PCMK

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

FB 4107-001 Welder is identified as 204342 ZPMC QC is identified as Zhang Zhi Wei
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 065 located on PCMK
FB 4100-001 Welder is identified as 204342 ZPMC QC is identified as Zhang Zhi Wei
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 046 located on PCMK
FB 4101-001 Welder is identified as 204342 ZPMC QC is identified as Zhang Zhi Wei
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-TC-U4b-F.

Heat straightening repair on weld joint 004 of PCMK CB3003B-019. In process temperature was around 250°C.
ZPMC QC is identified as Shu Yang Hua. The heat straightening temperature recorded by QC appeared to comply with HSR1 (B)-9392 procedures state that
Maximum temperature 600°C, number of application 1-3 and out of tolerance is maximum 5mm.

Bay 7

Flux Cored Arc Welding (FCAW) welding of weld joint 019 and 020 located on PCMK
FB 3148-001 Welding operator is identified as 062447 ZPMC QC is identified as Ciu Jun Jie
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 007, 008, 009, 016, 017 and 018 located on PCMK
FB 3242-001 Welder is identified as 204342 ZPMC QC is identified as Ciu Jun Jie
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-TC-U2-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 44~47 and 51~56 located on PCMK
W2-SB1A-007 Welder is identified as 205386 ZPMC QC is identified as Ciu Jun Jie
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 126~131 located on PCMK
W2-SB1H-003 Welder is identified as 053609 ZPMC QC is identified as Ciu Jun Jie
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Flux Cored Arc Welding (FCAW) welding of weld joint 126~131 located on PCMK
W2-SB1G-011 Welder is identified as 048625 ZPMC QC is identified as Feng Ya Jun
The welding variables recorded by QC appeared to comply with WPS-B-T-2132

Bay 8

Flux Cored Arc Welding (FCAW) repair welding of weld joint 090 located on PCMK BK004A1-056 weld
rejected by ZPMC UT, Welder is identified as 045148 ZPMC QC is identified as Liu Fa Wen
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-repair.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Flux Cored Arc Welding (FCAW) welding of weld joint 029, 030, 041 and 042 located on PCMK BK004A6-053
Welder is identified as 040671 ZPMC QC is identified as Liu Fa Wen
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Shin,DJ

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer
