

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-017939**Date Inspected:** 18-Oct-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:** Chen Xi**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

Heat straightening of PCMK, 20TR2-048 under approved Heat Straightening procedure, HSR 1(B)-8658, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhen Hai feng. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhen Hai Feng.

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: Floor Beam

PCMK: FB3327-001-056

Welder: 045221

WPS-B-T-2232-TC-U4b-F

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PCMK: FB3315-001-023
Welder: 045203
WPS-B-T-2232-TC-U4b-F

PCMK: SA3409-001-012
Welder: 201583
WPS-B-T-2232-TC-U4b-F

PCMK: VP3014-001-045
Welder: 045240
Report: B-WR154226
WPS-345-FCAW-2G (2F)-repair-1

Bay 3

Heat straightening of PCMK, EB3501-001 under approved Heat Straightening procedure, HSR 1(B)-9582, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 6

This QA Inspector observed the following work in progress for Bay 6.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Liu Chuan gang.
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: Cross Beam
PCMK: CB3002K-004-249
Welder: 053742
WPS-B-T-2134

PCMK: CB3002K-003-244/250
Welder: 053609
WPS-B-T-2134

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Liu Chuan gang.
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: Floor Beam
PCMK: DP-3165-001-157

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Welder: 062447
WPS-B-T-2232-TC-U4b-F

PCMK: W2-SB9-007-95~99
Welder: 048625
WPS-B-T-2332-TC-P4-F

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Liu Chuan Gang.
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.

PCMK: X4253E-001-001
Welder: 057795
Report: B-CWR-2025
WPS-345-SMAW-1G (1F)-FCM-Repair

PCMK: X4253B-001-001
Welder: 053753
Report: B-CWR-1996
WPS-345-SMAW-1G (1F)-FCM-Repair

Bay 8

This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Liu Chuan gang.
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: Bike Path
PCMK: BK004A8-053-061/065
Welder: 500405
WPS-B-T-2232-TC-P4-F

PCMK: BK004A6-053-061/065
Welder: 054459
WPS-B-T-2232-TC-P4-F

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

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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
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Reviewed By:	Carreon,Albert	QA Reviewer
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