

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-018651**Date Inspected:** 22-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:** Tian Lei**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 for Bay 1.

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

ZPMC QC is identified as Ai Wei.

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: Barrier Rail

PCMK: E2-SB1D-020-026~028

Welder: 216575

WPS-B-T-2132-3

Heat straightening of PCMK, 20TR2-046, 049, under approved Heat Straightening procedure, HSR (B)-362, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 2

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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 Zhu Lin.

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: FB3320-001-035,044

Welder: 201583

WPS-B-T-2132-3

Heat straightening of PCMK, FB3321-001, under approved Heat Straightening procedure, HSR (B)-428, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 25mm.

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

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

ZPMC QC is identified as Ai Wei.

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: Longitudinal Diaphragm

PCMK: LD3041-001-345,386

Welder: 217805

WPS-B-T-2132-3

Heat straightening of PCMK, FB3271-001, under approved Heat Straightening procedure, HSR 1 (B)-9543, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 11mm.

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 Zhang Zhi Wei.

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: CB3002L-018-092

Welder: 205386

WPS-B-T-2333-P5-F

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PCMK: CB3002L-018-163

Welder: 051246

WPS-B-T-2333-P5-F

PCMK: CB3002L-018-046

Welder: 053609

WPS-B-T-2333-P5-F

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 Zhang Zhi Wei.

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: DP3168-001-123

Welder: 204342

WPS-B-T-2232-TC-U4b-F-2

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 Feng Ya Jun.

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: BK004A6-054-082,086

Welder: 054459

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

Bay 10

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; BK004A6-026-045~050, 104~109, for item number 1 on NWIT tracker document # 07067.

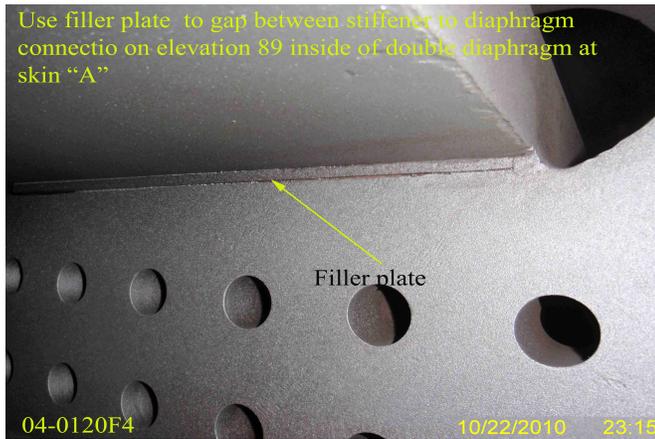
Blasting Shop # 2

QA inspector has performed visual inspection on interior of elevation 83 meter to 99 meter of Tower Lift 3 East side, QA inspector has find out 1 weld repair area and 2 places to use filler Plate for filled gap between stiffener plate to diaphragm connection.

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

Reviewed By: Carreon,Albert

QA Reviewer