

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017816**Date Inspected:** 04-Nov-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, 20TR2-040, 20TR2-044 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 Chen Xi. 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 Chen Xi.

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: LD3409-001-123,124

Welder: 207465

WPS-B-T-2132-3

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

PCMK: LD3409-001-103,104

Welder: 045240

WPS-B-T-2132-3

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

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Chen Xi.

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: Vertical Shear Plate

PCMK: SA3445-001-001

Welder: 250050

WPS-B-T-2221-B-L2C-S-2

PCMK: SA3446-001-001

Welder: 045265

WPS-B-T-2221-B-L2C-S-2

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and

accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The

member(s) is/are identified as follows; SA3410-001,

SA3328-001, FB3343-001, VP3015A-001, SA3409-001 for item number 2~6 of NWIT tracker document # 07236

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 Chen Xi.

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: FB3286-001-249, 395

Welder: 066439

WPS-B-T-2232-TC-U4C-F/ WPS-B-T-2233-TC-U4C-F

PCMK: FB3286-001-233,349

Welder: 066041

WPS-B-T-2232-TC-U4C-F/ WPS-B-T-2233-TC-U4C-F

PCMK: FB3286-001-387, 274

Welder: 377705

WPS-B-T-2232-TC-U4C-F/ WPS-B-T-2233-TC-U4C-F

---

---

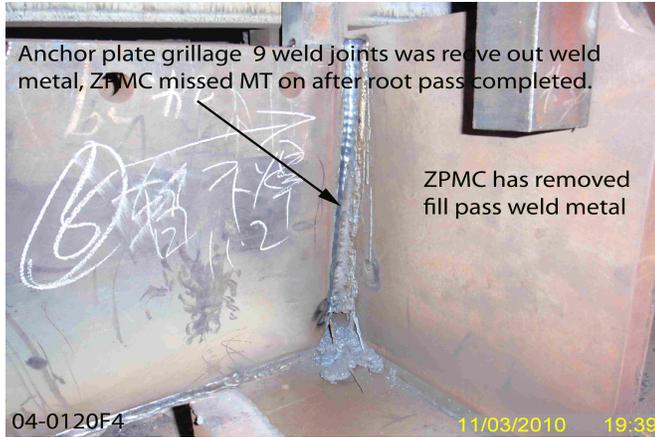
# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

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

---