

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-018667**Date Inspected:** 26-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:** 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

Heat straightening of PCMK, E2-SB1C-007, under approved Heat Straightening procedure, HSR 1(B)-9389, 20TR2-032, 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 Xiang Feng 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 8mm and 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 Xiang Feng Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3343-001-350,346

Welder: 068445

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WPS-B-T-2233-TC-U4b-F

Components: Grillage Assembly

PCMK: SA7512-001-035

Welder: 068445

Report: 17779

WPS-345-FCAW-3G (3F)-Repair

PCMK: SA7512-001-044

Welder: 066236

Report: 17789

WPS-345-FCAW-3G (3F)-Repair

PCMK: SA7512-001-063

Welder: 067520

Report: 17795

WPS-345-FCAW-3G (3F)-Repair

Components: Longitudinal Diaphragm

PCMK: LD3051-001-017,033

Welder: 058245

Report: 17816, 17817

WPS-345-FCAW-2G (2F)-Repair

Heat straightening of PCMK, SA3442-001, under approved Heat Straightening procedure, HSR 1(B)-9881, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Xiang Feng Feng. 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 9mm.

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; FB3343-001, on Item number 1 of NWIT tracker document # 07509,

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 Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Floor beam

PCMK: FB3286-001-053,057

Welder: 055564

WPS-B-T-2233-TC-P4-F

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PCMK: FB3286-001-067,071

Welder: 044830

WPS-B-T-2233-TC-P4-F

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 Li Jia.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Cross beam

PCMK: CB3000K-004-325,328

Welder: 054467

WPS-B-P-2113

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 Li Jia.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Cross beam

PCMK: CB3003K-001-043,044

Welder: 07601,217185

WPS-B-T-2132

Components: Deck Plate

PCMK: DP3178-2-001-09

Welder: 062447

WPS-B-P-2233-TC-U4b-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 Li Jia.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Cross beam

PCMK: CB3003A-019-002

Welder: 049769,048659

WPS-B-P-2214-TC-U4b-FCM

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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 Shen Jian Guo.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path

PCMK: BK004A1-057

Welder: 040673

Report: B CWR-2262

WPS-345-SMAW-1G (1F)-Repair

Bay 11

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; BK005A6-003, on item number 1 of NWIT tracker document # 07508

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.

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Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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