

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-019560**Date Inspected:** 11-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Yu Zhi Lai.

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.

Component; Bike Path

PCMK: BK004A1-031

Weld No. 043,044

Welder: 053869

WPS-B-T-2232-TC-U4c-F

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Yu Zhi Lai.

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.

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Component; Bike Path

PCMK: BK004A5

Weld No. 112,115,118,121,122,125,128,131

Welder: 040268, 520363

WPS-B-T-2113-B-U2a1

Bay 11

Heat Straightening

Heat straightening of PCMK, BK004A1-029 under approved Heat Straightening procedure, HSR1(T)-11593. The in process temperature was observed as 230°C. The ZPMC QC was identified as Mao Bin Bin. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 10mm.

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Bin, CWI Wang Chuany Xin.

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.

Component; Tower Lift 5, suspender bracket

PCMK: SD1-BRSA5-1-6B

Weld No. 6B

Welder: 045560, 044541

WPS-B-T-3212-TC-U5b

Component; Tower Lift 5, suspender bracket

PCMK: ND1-BRSA5-2-17A

Weld No. 15A

Welder: 040724

WPS-B-T-3213-TC-U5b

PCMK: BK004A2-020

Weld No. 014

Plug Welder: 066155

WPS-B-T-2112-Plug

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Liu Huajie.

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.

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Component: OBG 11CW, transverse splice

PCMK: OBW11C

Weld No. 003

Excavated and ground prior to welding

WPS-345-SMAW-4G(4F)-FM-Repair-1

Repair No. B-WR16828

NDT Report No. UT-11W-061

Component: OBG 11CW, transverse splice

PCMK: SEG071A

Weld No. 045

Excavated and ground prior to welding

WPS-345-SMAW-4G(4F)-FM-Repair-1

Repair No. B-CWR2139

NDT Report No. UT-11W-061

This QA Inspector performed MT on approximately 15% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 VT and MT requirements. The members are identified as OBE11-005, CA-OBE11-005 and SP-OBE11B-005.

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

Summary of Conversations:

No significant 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:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
