

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-019563**Date Inspected:** 08-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 Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li ping fei, CWI Yu Dong Ping.

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, gussets

PCMK: BK004A6-026

Weld No. 003,005,152,153,

Welder: 500363

WPS-B-T-2113

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 Li ping fei, CWI Yu Dong Ping.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Component; Bike Path

PCMK: BK004A1-030

Weld No. 043

Welder: 060634

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

B-WR-15760

Component; Tower Lift 6, skin E

PCMK: SSD1-FESA6-3

Weld No. 1,2

Welders: 040302, 053869

WPS-B-T-2132

Heat straightening of PCMK, ND1-SFSA4-42 under approved Heat Straightening procedure, HSR1(T)-11553. The in process temperature was observed as 320°C. The ZPMC QC was identified as Li ping fei. 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 6mm.

Heat straightening of PCMK, ND-SFSA4-17 under approved Heat Straightening procedure, HSR1(T)-11552. The in process temperature was observed as 412°C. The ZPMC QC was identified as Li ping fei. 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 6mm.

Bay 11

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

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

ZPMC QC is identified as Yu Dong Ping, CWI Yu Dong Ping.

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: BK004A1-030

Weld No. 030,031,032,033

Welder: 025649

WPS-B-T-2332-TC-P4-F

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 Yu Dong Ping, CWI Yu Dong Ping.

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. See picture below.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Component; Tower Lift 5, suspender bracket

PCMK: ND1-BRSA5-2

Weld No. 15

Welder: 040724

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