

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-020990**Date Inspected:** 23-Feb-2011**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:** Sha Zhi**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 Zhu Jun.

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: Traveler Rail

PCMK: 20TR2-038-009

Welder: 204342

WPS-B-T-2231-ESAB

PCMK: 20TR2-038-011

Welder: 217685

WPS-B-T-2231-ESAB

PCMK: 20TR2-038-015

Welder: 053609

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WPS-B-T-2231-ESAB

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 Sun Zi Wang.

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: BK009A5-001-053

Welder: 040302

WPS-B-T-2132-ESAB

PCMK: BK009A5-001-054

Welder: 052075

WPS-B-T-2132-ESAB

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

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

ZPMC QC is identified as Sun Zi Wang.

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: Bike Path

PCMK: BK008A6-001-072,073

Welder: 040453

WPS-B-P-2112

PCMK: BK008A6-001-027,028

Welder: 057186

WPS-B-P-2112

Heat straightening of PCMK, 3005TR3, under approved Heat Straightening procedure, HSR (B)-10101, The in process temperature was at the time of this observation witnessed at less than 650°C. The ZPMC QC was identified as Sun Zi Wang. 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 6mm.

Trial Assembly Yard

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

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

ZPMC QC is identified as Zhou Peng.

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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Components: OBG 12E
PCMK: OBE-12E-002
Welder: 044504
Report: B-CWR2805
WPS-345-SMAW-4G (4F)-FCM-repair-1

PCMK: OBE-12E-003
Welder: 044504
Report: B-CWR2805
WPS-345-SMAW-4G (4F)-FCM-repair-1

PCMK: SP3026-017-131,132
Welder: 040403
WPS-B-P-2114-FCM-1

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

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

ZPMC QC is identified as Zhou Peng.

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: OBG 12E
PCMK: BP3017-017-034,035
Welder: 040367
WPS-B-T-2132-ESAB

Heat straightening of PCMK, BP3020-038, under approved Heat Straightening procedure, HSR 1 (B)-9961, The in process temperature was at the time of this observation witnessed at less than 650°C. The ZPMC QC was identified as Zhou Peng. 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 6mm.

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: Riley,Ken

QA Reviewer