

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-021940**Date Inspected:** 02-Mar-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.

03-02-2011

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

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

ZPMC QC is identified as Tian Lei.

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: Traveler Rail

PCMK: 20TR2-038-011

Welder: 057795, 054467, 049769

WPS-B-P-2211-TC-U4b

Bay 10

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 Yun Chun Feng.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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: BK15-001-013
Welder: 040882
WPS-B-P-2213-TC-U4c

PCMK: BK15B-001-001
Welder: 057220
WPS-B-P-2213-TC-U4c

PCMK: BK15A-001-013
Welder: 040365
WPS-B-P-2212-TC-U4b

Heat straightening of PCMK, BK9A-001-A3~A7, under approved Heat Straightening procedure, HSR 1 (B)-10129, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Yun Chun 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 25mm.

Bay 11

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

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

ZPMC QC is identified as Wyu 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

Components: Traveler Rail
PCMK: 20TR2-035-009
Welder: 044541, 202338
WPS-B-P-2211-TC-U4b

PCMK: 20TR2-035-013
Welder: 046769
WPS-B-P-2211-TC-U4b

PCMK: 20TR2-035-017
Welder: 066155
WPS-B-P-2211-TC-U4b

Trial Assembly

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

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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

Components: OBG 12E

PCMK: DP3054-001-021

Welder: 046709

WPS-B-P-2211-TC-U4b-FCM-1

PCMK: OBE-12C-001

Welder: 044504

Report: B-CWR-2811

WPS-345-SMAW-1G (1F)-FCM-repair

PCMK: LD3022A-001-084,085

Welder: 054217

Report: B-WR-19623

WPS-345-SMAW-2G (2F)-FCM-repair

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; DP3022-001-023,024, EP3005-001-013,014, SP3020-001-031~035 on item number 1, 2, 3 of NWIT tracker document # 08432,

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



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
