

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-024125**Date Inspected:** 25-May-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:** Shi Yu**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 perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

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 Liu Fa Wen.

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: U-Rib splice channel

PCMK: SA2310-051-001,002

Welder: 219414

WPS-B-T-2232-ESAB

Bay 9

This QA Inspector observed the following work in progress for Bay 9.

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

ZPMC QC is identified as Chen Shi Gang.

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: U-Rib splice channel

PCMK: SA2310-044-001,002

Welder: 201840

WPS-B-T-2232-ESAB

PCMK: SA2310-043-001,002

Welder: 059421

WPS-B-T-2232-ESAB

PCMK: SA2310-027-001,002

Welder: 059378

WPS-B-T-2232-ESAB

PCMK: SA2310-036-001,002

Welder: 059418

WPS-B-T-2231-ESAB

Bay 11

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

ZPMC perform fit up and grind work on bike path BK011A.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhu Lin.

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: TR3001TR1

Welder: 67752

Report: B-WR20843

WPS-345-SMAW-2G(2F)-Repair-1

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhu Lin.

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.

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Components: U-Rib splice channel
PCMK: SA 2232-X4205D1
Welder: 066421
WPS-B-T-2233-ESAB

Heat straightening of PCMK, X3305K-067, under approved Heat Straightening procedure, HSR 1 (B)-10319, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. 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.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC perform SMAW VT repair welding and grind work on hand rails.

Bay 19

This QA Inspector observed the following work in progress for Bay 16.
ZPMC perform fit up and grind work on BK24A.

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; BK24A3, on item number 1, of NWIT tracker document # 09256,

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



Summary of Conversations:

No relevant conversations

Comments

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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
