

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-025742**Date Inspected:** 07-Jun-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

Heat straightening of PCMK, BKR-NS-3-PP22, under approved Heat Straightening procedure, HSR 1 (B)-10400, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Li Wei Lin. The approved HSR procedure stated that a maximum temperature of 650°C with 1 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 9

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

ZPMC was performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting, weld spatters, smooth to final weld pass and removing the burr's caused by drilling on hand rails, traveler rails, and bike path.

Bay 11

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

ZPMC was performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting, weld spatters, smooth to final weld pass and removing the burr's caused by drilling on bike path.

Bay 14

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

ZPMC was performing match drilling on splice plate angles for lifts 13 and 14. ZPMC was also noted performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting and removing the burr's caused by drilling.

Heat straightening of PCMK, TR3001TR1, under approved Heat Straightening procedure, HSR 1 (B)-10294, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Shen Jian Bo. 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 8mm.

Trial Assembly Yard

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; OBG 14E, on item number 1, of NWIT tracker document # 09388,

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



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