

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-025872**Date Inspected:** 16-Jul-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 Zi	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 14

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.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

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

ZPMC QC is identified as Guo Xing Hai.

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: Steel Barrier

PCMK: W2-SAS-001-007

Welder: 201704

WPS-B-T-2233-ESAB

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

PCMK: E2-SAS-001-001

Welder: 222396

WPS-B-T-2233-ESAB

Heat straightening of PCMK, BKR-G-005, under approved Heat Straightening procedure, HSR 1 (B)-10418, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Guo Xing Hai. 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.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Guo Xing Hai.

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: BK23A2-001-023, 028

Welder: 062806

WPS-B-T-2132-ESAB

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Guo Xing Hai.

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: BK23A2-001-018

Welder: 059906

WPS-B-P-2112-PLUG

Trial Assembly Yard

This QA inspector performed Bolt Tension Verification Test of Minimum 10 % of the area previously tightened and accepted by ZPMC Quality Control personnel. This QA Inspector performed minimum 10% of each connection or minimum 2 bolts each connection, The member(s) is/are identified as follows; Triangle plate of 13CE, on item number 1, of NWIT tracker document #00691,

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
---------------------	-----------	-------------