

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017276**Date Inspected:** 28-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 053748 perform Submerged Arc Welding (SAW) Process on weld joint CB3003C-019-013. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng zhi wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 062447 perform Flux Cored Arc Welding (FCAW) Process on weld joint SP3151-001-052,054,055. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint X4253B-005-001. ZPMC Quality Control Personnel (QC) identified as Mr. Wang

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Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U4b-F-2.

During this Caltrans Quality Assurance Inspectors' in-process observations of the fabrication of the Steel Barriers, this Quality Assurance Inspector (QA) discovered the following issue. ZPMC personnel has fit and welded the uni-struts to the diaphragms prior to blast cleaning and painting behind the areas where the uni-struts are located. This condition exists on all the Steel barriers that have been fabricated to date. This QA notified ZPMC QA identified as Mr. Zhang Wei of these issues and that an incident report would be generated. See for further details please see the attached pictures.

OBG # BAY 8

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Bike Path BK004A-61. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Liu fa wen was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B) number 8963.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer