

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-017683**Date Inspected:** 17-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:** Huang Min**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:

Heat straightening of PCMK, 20TR-029 under approved Heat Straightening procedure, HSR (B)-362 dated 5/28/2010. The in process temperature was at the time of this observation was witnessed as 400°C. The ZPMC QC was identified as Zheng Zhi Wei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was between 30mm~80mm.

Bay 2

This QA Inspector during a random observation in Bay 2 observed Submerged Arc Welding (SAW) in progress.

ZPMC QC is identified as Ai Wei who was documenting the welding which appeared to comply with the WPS-B-T-2221-B-L2C-2. Listed below are the locations that were identified by this QA inspector.

LD3048-001-006 and 007

Welder - 250050

This QA Inspector during a random observation in Bay 2 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Ai Wei who was documenting the welding in process, which appeared to comply with the WPS-B-T-2231-B-U2-F. Listed below are the locations that were identified by this QA inspector.

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FB 3325-001-027

Welder - 062708

LD3014-001-002

Welder-045203

FB 3325-001

Welder-045276

VP3014-001

Welder-207465

E5-SB1-17 and 018

Welder-045209

WPS-B-T-2133

Bay 6

This QA Inspector observed the following work in progress for Bay 6. Submerged Arc Welding (SAW) welding of weld joint 004 located on PCMK CB-3003B-019. Welder was identified as 053748. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-2.

Bay 7

This QA Inspector observed the following work in progress for Bay 7. Flux Cored Arc Welding (FCAW) welding of weld joint 084 and 085 located on PCMK W2-SB1-016. Welder was identified as 500405. ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3 and WPS-B-T-2133. Also noted in Bay 7 was FCAW welding of weld joint 097 located on PCMK W2-SB1G-012 with the Welder identified as 501246. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Bay 8

This QA Inspector observed the following work in progress for Bay 8. FCAW welding of weld joint 022,023,062 and 063 located on PCMK- BK004A5-054. Welder was identified as 040671 and 500405. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3 and WPS-B-T-2133.

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

Summary of Conversations:

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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:	Carreon,Albert	QA Reviewer
