

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-017815**Date Inspected:** 05-Nov-2010**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:** Chen Xi**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, 20TR2-044 under approved Heat Straightening procedure, HSR (B)-362, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Chen Xi. 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 80mm.

Bay 2

Heat straightening of PCMK, FB3327-001, under approved Heat Straightening procedure, HSR 1(B)-9638 and FB3328-001, under approved Heat Straightening procedure, HSR(B)-429, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Chen Xi. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 10mm and 45mm.

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Chen Xi.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Components: Vertical Shear Plate

PCMK: SA3445-001-001

Welder: 250050

WPS-B-T-2221-B-L2C-S-2

PCMK: SA3451-001-001

Welder: 045265

WPS-B-T-2221-B-L2C-S-2

This QA Inspector observed the following work in progress for Bay 2.

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

ZPMC QC is identified as Chen Xi.

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: Longitudinal Diaphragm

PCMK: LD3409-001-147

Welder: 045203

WPS-B-T-2132-3

PCMK: LD3409-001-098

Welder: 045240

WPS-B-T-2233-TC-U4b-F

PCMK: LD3408-001-005

Welder: 045240

Report: B- WR16611

WPS-345-FCAW-1G (1F)-Repair-1

Components: Side Plate

PCMK: SP3144-001-026

Welder: 048696

WPS-B-T-2132-3

PCMK: SP3144-001-077

Welder: 201583

WPS-B-T-2132-3

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; SA3409-001,

FB3343-001, for item number 1,2 of NWIT tracker document # 07251

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

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

ZPMC QC is identified as Chen Xi.

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: Floor Beam

PCMK: FB3286-001-222

Welder: 066437

WPS-B-T-2233-TC-U4b-F

PCMK: FB3286-001-232

Welder: 066041

WPS-B-T-2233-TC-U4b-F

PCMK: FB3286-001-274

Welder: 037705

WPS-B-T-2233-TC-U4b-F

PCMK: FB3286-001-288

Welder: 044830

Report: B-CWR2155

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

PCMK: FB3273-001-043

Welder: 206623

Report: B-WR16558

WPS-345-FCAW-2G (2F)-FCM-Repair-1

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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:	Carreon,Albert	QA Reviewer
