

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-017820**Date Inspected:** 01-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 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: Anchor Plate

PCMK: AP3032-001-424,425,501,502,756,757

Welder: 201583, 045280,048696

WPS-B-T-2333-TC-P4-F/ WPS-B-T-2333-TC-U4b-F

Components: Floor Beam

PCMK: FB3343-001-271

Welder: 045209

Report: 16442

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

PCMK: FB3343-001-236
Welder: 067877
Report: 16437
WPS-345-FCAW-2G (2F)-Repair-1

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.

Components: Bearing Stiffener Sub-Assembly
PCMK: SA3450-001-001
Welder: 045263
WPS-B-T-2221-B-L2C-S-2

Heat straightening of PCMK, FB3321-001-011/012, under approved Heat Straightening procedure, HSR(B)-428,
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 25mm.

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: Bulk Head Sub-Assembly
PCMK: SA3325-001-056
Welder: 206623
WPS-B-T-2232-TC-U4b-F

PCMK: SA3325-001-033
Welder: 052296
WPS-B-T-2232-TC-U4b-F

PCMK: SA3325-001-003,004
Welder: 044830
WPS-B-T-2232-TC-U4b-F

PCMK: SA3325-001-054
Welder: 050242
WPS-B-T-2233-TC-U4b-F

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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: Carreon,Albert

QA Reviewer