

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-017821**Date Inspected:** 24-Sep-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:	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:	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 during a random observation in Bay 1 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Jun who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: E2-SB10-017-126~131

Welder: 216872

WPS-B-T-2132-3

PCMK: E2-SB10-016-022,023,053 and 054

Welder: 215082

WPS-B-T-2132-3

Heat straightening of PCMK, E20TR2-031 under approved Heat Straightening procedure, HSR1 (B)-362. The in process temperature at the time of this observation was witnessed as 450°C. The ZPMC QC was identified as Zhu Jun. 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 Maximum 80mm.

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Bay 2

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

PCMK: E5-SB1-018-084~085

Welder: 202122

WPS-B-T-2132-3

PCMK: E5-SB1-028-023,024

Welder: 201583

WPS-B-T-2132-3

PCMK: E5-SB1-037-095-115

Welder: 062708

WPS-B-T-2133

PCMK: FB3321-001-003

Welder: 045203

WPS-B-T-2232-TC-U4b-F

PCMK: E5-SB1-018-084~085

Welder: 202122

WPS-B-T-2132-3

This QA Inspector observed the following work in progress for Bay 2. Submerged Arc Welding (SAW) welding of weld joint 003 located on PCMK LD3050-001. Welder was identified as 250050. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Heat straightening of PCMK, E5-SB1C-002 under approved Heat Straightening procedure, HSR1 (B)-9440. The in process temperature at the time of this observation was witnessed as less than 600°C. The ZPMC QC was identified as Zhu Jun. 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 Maximum 5mm.

Heat straightening of PCMK, E5-SB1C-007 under approved Heat Straightening procedure, HSR1 (B)-9412. The in process temperature at the time of this observation was witnessed as less than 600°C. The ZPMC QC was identified as Zhu Jun. 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 Maximum 6mm.

Bay 3

This QA Inspector observed the following work in progress for Bay 3. Submerged Arc Welding (SAW) welding

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of weld joint 005 located on PCMK LD3040-001. Welder was identified as 250050. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

This QA Inspector during a random observation in Bay 3 observed Flux Cored Arc Welding (FCAW) repair welding of weld joint 053 located on LD3030-001 with repair report No B-CWR1925 rejected by ZPMC UT, Welder is identified as 044815 ZPMC QC is identified as Wang Liang

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-repair-1.

Bay 6

This QA Inspector during a random observation in Bay 6 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Jun who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: WJF-0-055

Welder: 66422

WPS-B-T-3311-TC-P4

PCMK: WJF-0-064

Welder: 68764

WPS-B-T-3311-TC-P4

PCMK: WJF-0-050

Welder: 62092

WPS-B-T-3311-TC-P4

PCMK: WJF-0-046

Welder: 215083

WPS-B-T-3311-TC-P4

This QA Inspector observed the following work in progress for Bay 6. Submerged Arc Welding (SAW) welding of weld joint 002 and 004 located on PCMK CB33002C-018. Welder was identified as 053748(002) and 054748(004). ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

Bay 7

This QA Inspector during a random observation in Bay 7 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Wang Liang who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB1-030-126~131

Welder: 051246

WPS-B-T-2132-3

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PCMK: W2-SB1-031-126~131

Welder: 205386

WPS-B-T-2132-3

PCMK: W2-SB1-032-126~131

Welder: 215689

WPS-B-T-2132-3

PCMK: W2-SB4-001-126~131

Welder: 048625

WPS-B-T-2132-3

PCMK: SA3078-004-001

Welder: 053609

WPS-B-T-2331-C-P2-F2

Bay 8

This QA inspector performed Ultrasonic Testing (UT) and Visual Inspection (VT) 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;

BK004A5-056-090 for item number 1 on NWIT tracker document # 06758

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



Summary of Conversations:

No relevant conversations

Comments

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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
