

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-017823**Date Inspected:** 29-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:** 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

This QA Inspector observed the following work in progress for Bay 1.

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

ZPMC QC is identified as Tian Lei.

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; Barrier Rail

PCMK: E2-SB2A-001

Welder: 059450

WPS-B-T-2132-3

PCMK: E2-SB1D-011

Welder: 057450

WPS-B-T-2132-3

PCMK: E2-SB1-015

Welder: 203710

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WPS-B-T-2132-3

PCMK: E2-SB1C-001

Welder: 216872

WPS-B-T-2132-3

Component; Traveler Rail

PCMK: 20TR2-048-013

Welder: 215082

Report No: B-WR15151

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

Bay 2

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

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

ZPMC QC is identified as Tian Lei.

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; Barrier Rail

PCMK: E5-SB3AA-002-001~012

Welder: 062708

WPS-B-T-2132-3

PCMK: E5-SB10-003-001~012

Welder: 045203

WPS-B-T-2132-3

PCMK: E5-SB1-053-001~012

Welder: 207465

WPS-B-T-2132-3

Components; Vertical Plate

PCMK: VP3015-001-019

Welder: 045240

Report No: B-WR15151

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

This QA Inspector observed the following work in progress for Bay 2. Submerged Arc Welding (SAW) of weld joint 023 located on PCMK SA3409-001. Welder was identified as 045265. ZPMC QC was identified as Tian Lei. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Heat straightening of PCMK, E20TR2-038 under approved Heat Straightening procedure, HSR (B)-362. The in process temperature was at the time of this observation witnessed at 450°C. The ZPMC QC was identified as Zhu

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Jun. 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 3

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

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

ZPMC QC is identified as Zhang Ya Xu.

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: FB3265-001-025,026

Welder: 055491

WPS-B-T-2132-3

PCMK: FB3263-001-058,059

Welder: 214945

WPS-B-T-2132-3

PCMK: FB3279-001-076,077,007

Welder: 055564

WPS-B-T-2132-3

Component; Corner Assembly

PCMK: CA3014-057-061,041,045

Welder: 050242

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

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

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

ZPMC QC is identified as Feng Ya Jun.

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; Cross Beam Tie-down seat

PCMK: SA3077-006-002

Welder: 051246

WPS-B-T-2331-C-P2-F-2

PCMK: X4253F-001-001

Welder: 217815

WPS-B-T-2331-TC-U4b-F-2

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PCMK: X4253E-001-001
Welder: 053609
WPS-B-T-2331-TC-U4b-F-2

PCMK: X4253C-001-001
Welder: 053742
WPS-B-T-2331-TC-U4b-F-2

Component; Side Plate
PCMK: SP3146-001-009,010,011,012
Welder: 062447
WPS-B-T-2132-3

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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