DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-017824
Date Inspected: 30-Sep-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
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 Zhu Lin.
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-SB5-002-088~090, 057~059,
Welder: 059450
WPS-B-T-2232-3

Components; Traveler Rail
PCMK: 20TR1-051-003,
Welder: 215082
Report: B-WR 15297
WPS-345-FCAW-2G (1G)-Repair-1

Heat straightening of PCMK, E2-SB1-003 under approved Heat Straightening procedure, HSR 1(B)-9389. The in process temperature was at the time of this observation witnessed at370°C. The ZPMC QC was identified as Zhu 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 8mm.

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 Zhu Lin.
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-SB1-017-001~012
Welder: 207465
WPS-B-T-2233

PCMK: E5-SB1-051-126~131
Welder: 062708
WPS-B-T-2232-3

PCMK: E5-SB1-042-020,021
Welder: 045203
WPS-B-T-2233

PCMK: E2-SB1-037-019,050
Welder: 045227
WPS-B-T-2231-B-U2-F

PCMK: VP-3014-001-052
Welder: 045240
Report: B-WR-15430
WPS-345-FCAW-2G (2F)-Repair-1

Heat straightening of PCMK, LD3048-001-011~019,214 under approved Heat Straightening procedure, HSR 1(B)-9389. The in process temperature was at the time of this observation witnessed at370°C. The ZPMC QC was identified as Zhu Lin. 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 20mm.

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 Zhu Lin.
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: FB3271-001-027
Welder: 044830
WPS-B-T-2132-3

PCMK: FB3053-001-012
Welder: 050242
WPS-B-T-2132-3

PCMK: FB3279-001-059
Welder: 05564
WPS-B-T-2132-3

PCMK: FB3265-001-012
Welder: 206623
WPS-B-T-2231-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 Li Zhi Jiang.
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: SA3077-008-001
Welder: 053609
WPS-B-T-2331-C-P2-F-2

PCMK: SA3077-001-002
Welder: 217185
WPS-B-T-2331-C-P2-F-2

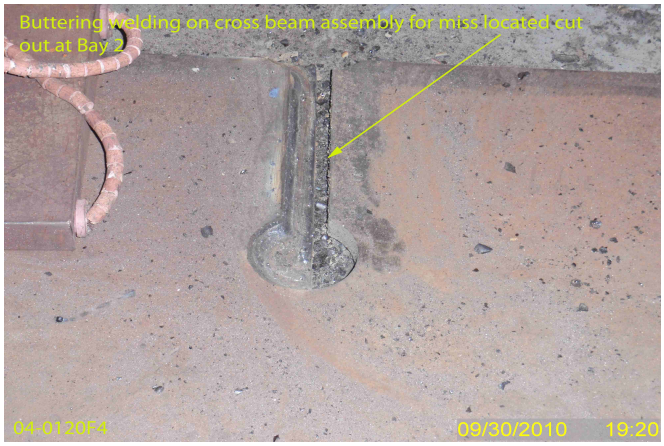
Components; Floor Beam
PCMK: FB3241A-001-7,8
Welder: 051246
WPS-B-T-2132-3

PCMK: X4253A-003-001
Welder: 053742
WPS-B-T-2231-TC-U4b-F-2

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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