

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-017825**Date Inspected:** 27-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 Chen X1.

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-SB10-019-126~131

Welder: 216872

WPS-B-T-2133

PCMK: E2-SB10-017-015,016

Welder: 215082

WPS-B-T-2132-3

Bay 2

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

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ZPMC was using the Flux Cored 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; Barrier Rail

PCMK: E5-SB1-021-019,050,081

Welder: 204730

WPS-B-T-2132-3

PCMK: E5-SB3AA-002-126~131

Welder: 062708

WPS-B-T-2132-3

PCMK: E5-SB1-032-001,002,032~043

Welder: 207465

WPS-B-T-2132-3

PCMK: E5-SB1-055-001,002 032~043

Welder: 045175

WPS-B-T-2132-3

PCMK: E5-SB10-001-126~131

Welder: 045203

WPS-B-T-2132-3

Components: "K" Plate Subassembly

PCMK: KP-3012-001-001

Welder: 045240

Repair report No: B-WR-4991

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

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: Corner Assembly

PCMK: CA3013-013,014

Welder: 050242

WPS-B-T-2132-3

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Components: Floor Beam
PCMK: FB3265-001-084,085
Welder: 055491
WPS-B-T-2132-3

PCMK: FB3265-001-101,102
Welder: 214945
WPS-B-T-2132-3

PCMK: FB3265-001-101,102
Welder: 206623
WPS-B-T-2132-3

Heat straightening of PCMK, LD3040-001-001~009 under approved Heat Straightening procedure, HSR1 (B)-9465. The in process temperature was at the time of this observation 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 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 4

This QA Inspector observed the following work in progress for Bay 4.

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: Bottom Plate
PCMK: BP3084-001-049,050
Welder: 217805,055564
WPS-B-T-2132-3

PCMK: BP3085-001-057,058
Welder: 044830
WPS-B-T-2132-3

Bay 6

Heat straightening of PCMK, FB3242A under approved Heat Straightening procedure, HSR1 (B)-9443. The in process temperature was at the time of this observation witnessed as less than 600°C. The ZPMC QC was identified as Shu yang Hua. 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 8mm.

Bay 7

This QA Inspector observed the following work in progress for Bay 4.

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

ZPMC QC is identified as Zhang Ya Xu.

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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-SB1-026-126~131

Welder: 205386

WPS-B-T-2132-3

PCMK: W2-SB1-034-48, 49, 32~43

Welder: 048625

WPS-B-T-2133

PCMK: W2-SB1G-018-112~114

Welder: 053742

WPS-B-T-2132-3

Component; Cross Beam Tie-down seat

PCMK: SA3077-006-001

Welder: 051246

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

PCMK: SA3078-002-002

Welder: 062-092

Repair report No: B-CWR-1943

WPS-345-SMAW-1G (1F)-repair

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



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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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