

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-017827**Date Inspected:** 03-Oct-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:** Tian Lei**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 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; Barrier Rail

PCMK: E2-SB10-012

Welder: 216872

WPS-B-T-2133

Heat straightening of PCMK, E2-SB1D-021 under approved Heat Straightening procedure, HSR 1(B)-9389. The in process temperature was at the time of this observation witnessed at 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 2

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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 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; Floor Beam

PCMK: FB3321-001-011,012

Welder: 045209

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

Components; Barrier Rail

PCMK: E5-SB1-027-106~122

Welder: 062708

WPS-B-T-2132-3

PCMK: E5-SB10-004-048,049

Welder: 045227

WPS-B-T-2133

PCMK: E5-SB1-043-001~012

Welder: 045203

WPS-B-T-2132-3

Components; Vertical Plate

PCMK: VP-3014-001-028

Welder: 045240

Report: B-WR15422

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

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; SA8503-001-001 for item number 1 on NWIT tracker document # 06847.

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 Zhan Hai Feng.

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: FB3271-001-094

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Welder: 214945
WPS-B-T-2132-3

PCMK: FB3290-001-021,022
Welder: 206623
WPS-B-T-2132-3

PCMK: FB3291-001-005,006
Welder: 214945055564
WPS-B-T-2132-3

Heat straightening of PCMK, LD3043-001-001,002,083 under approved Heat Straightening procedure, HSR 1(B)-9476. The in process temperature was at the time of this observation witnessed at 450°C. The ZPMC QC was identified as Xu Hai Yang. 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 9mm.

Bay 6

This QA Inspector observed the following work in progress for Bay 6.

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

ZPMC QC is identified as Xu Hai yang.

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
PCMK: CB3002J-001-25, 26
Welder: 217815
WPS-B-T-2232-TC-U5-F (2)

PCMK: CB3002K-003-25, 26
Welder: 053609
WPS-B-T-2232-TC-U5-F (2)

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 Xu Hai yang.

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-SB1G-015-1~12
Welder: 205386
WPS-B-T-2133

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PCMK: E2-SB1A-01-1~12

Welder: 215689

WPS-B-T-2133

PCMK: E2-SB1H-004-20~25

Welder: 048625

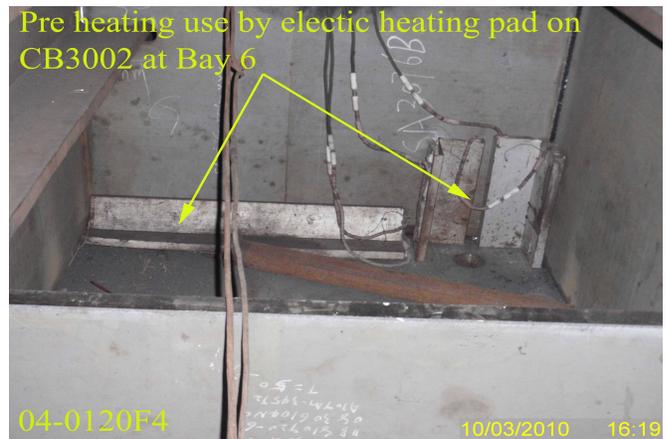
WPS-B-T-2132-3

PCMK: SA3077-006-001

Welder: 053742

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

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
