

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-018646**Date Inspected:** 11-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:** 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

Heat straightening of PCMK, 20TR-031,045, E2-SB3-001, PP-104 under approved Heat Straightening procedure, HSR (B)-362, HSR1 (B)-9262, HSR1 (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 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 80mm.

Bay 2

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

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

ZPMC QC is identified as Xiang Feng 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: Vertical Plate

PCMK: VP3014-001-019

Welder: 045276

Report: B-WR15418

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WPS-345-FCAW-2G (2F)-repair-1

Bay 3

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

ZPMC was using the Flux Core 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: Bulk Head

PCMK: SA3324-001-016

Welder: 055564

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

Components: Floor Beam

PCMK: FB3265-001-012

Welder: 050242

Report: B-WR15809

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

Bay 4

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

ZPMC was using the Submerged Arc Welding (SAW) 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: Bulk Head

PCMK: SA3066-001-001

Welder: 207288

WPS-B-T-2221-B-L2C-S-2

Bay 6

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

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

ZPMC QC is identified as Zheng Zhi Wei.

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: CB3003F-019-002

Welder: 062447

WPS-B-T-2231-B-U2-F

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Components: Side Plate
PCMK: SP-3102B-048
Welder: 048625
Report: B-CWR-1940
WPS-B-T-2232-TC-U5-F-1

Components: Floor Beam
PCMK: FB3169-003-043
Welder: 053742
Report: B-WR14783
WPS-345-FCAW-2G (2F)-Repair

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Shu Yang Hua.
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: CB3003-019-006
Welder: 215689
WPS-B-T-2231-B-U2-F

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Shu Yang Hua.
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: X4253A-001-001
Welder: 053753
Report: B-CWR-2028
WPS-345-SMAW-1G (1F)-FCM-Repair

PCMK: X4253C-001-001
Welder: 048659
Report: B-CWR-2022
WPS-345-SMAW-1G (1F)-FCM-Repair

PCMK: X4253D-001-001
Welder: 057795
Report: B-CWR-2023

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WPS-345-SMAW-1G (1F)-FCM-Repair

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

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

ZPMC QC is identified as Zheng Zhi Wei.

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: Bike Path

PCMK: BK004A2-055-018

Welder: 040671

WPS-B-T-2231-B-L1b-F-1

PCMK: BK004A2-160,007

Welder: 054459, 500405

WPS-B-T-2132

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.

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Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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