

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-018648**Date Inspected:** 12-Nov-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 Core 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-SB10-024-050,081

Welder: 216872

WPS-B-T-2132-3

PCMK: E2-SB10-029-063~074

Welder: 215082

WPS-B-T-2132-3

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

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

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: Traveler Rail

PCMK: 20TR2-031

Welder: 216575

Report: B-CWR1568

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

PCMK: 20TR2-044

Welder: 215248

Report: B-CWR1568

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

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 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: Anchor Plate

PCMK: AP3032-001-356,337

Welder: 045227

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-579,580

Welder: 207465

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-587,588

Welder: 045276

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-610,611

Welder: 062708

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

Components: Floor Beam

PCMK: FB3343-001-236

Welder: 066733

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

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

PCMK: FB3343-001-249
Welder: 067520
WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-278
Welder: 070006
WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-267
Welder: 066763
WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-294
Welder: 066674
WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-310
Welder: 067947
WPS-B-T-2233-TC-U4b-F

Components: Grillage Plate
PCMK: SA7512-001-031
Welder: 066239
WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-036
Welder: 068859
WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-029
Welder: 067877
WPS-B-T-2233-TC-U5-F

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; FB3317-001 for item number 1 of NWIT tracker document # 07331

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 Zhen 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.

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

Components: Floor Beam
PCMK: FB3286-001-315
Welder: 050242
WPS-B-T-2232-TC-U4b-F

PCMK: FB3286-001-213
Welder: 055564
WPS-B-T-2232-TC-U4b-F

PCMK: FB3286-001-327
Welder: 052696
WPS-B-T-2232-TC-U4b-F

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 Huang Min.

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: W2-SB9-075-113~115
Welder: 215689
WPS-B-T-2332-TC-P4-F

PCMK: W2-SB9-076-095~096
Welder: 205386
WPS-B-T-2332-TC-P4-F

PCMK: W2-SB9-077-126~131
Welder: 051246
WPS-B-T-2132-3

PCMK: W2-SB9-064-019
Welder: 062447
WPS-B-T-2231-B-U2-F

Components: Deck Plate
PCMK: DP3179-001-19,20
Welder: 217185
WPS-B-T-2132

PCMK: DP3181-001-58

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

Welder: 204342

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

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