

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-018671**Date Inspected:** 02-Dec-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 Core Arc Welding (FCAW) process.

ZPMC QC is identified as Ai Wei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail

PCMK: E2-SB1D-039-019

Welder: 216872

Report: B-WR 17803

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

Heat straightening of PCMK, 20TR2-052, under approved Heat Straightening procedure, HSR (B)-362, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. 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.

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Bay 2

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

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

ZPMC QC is identified as Tian Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3343-001-114

Welder: 067904

Report: B-CWR 2333

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

PCMK: FB3343-001-326

Welder: 066038

Report: B-CWR 2340

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

PCMK: FB3343-001-212

Welder: 067707

Report: B-CWR 2337

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

PCMK: FB3343-001-389

Welder: 037997

Report: B-CWR 2332

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

PCMK: FB3343-001-342

Welder: 066258

Report: B-CWR 2339

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

PCMK: FB3343-001-290

Welder: 068097

Report: B-CWR 2338

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

PCMK: FB3343-001-385

Welder: 066261

Report: B-CWR 2330

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

Heat straightening of PCMK, LD3049-001, under approved Heat Straightening procedure, HSR 1 (B)-9795, The

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in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. 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 10mm.

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 100 % 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; SEG3019K, on item number 4 of NWIT tracker document # 07591,

Bay 3

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

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

ZPMC QC is identified as Tian Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Segment Assembly

PCMK: SEG3019K-127/128

Welder: 058102

Report: B-WR 16805

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

Bay 6

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

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 Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Deck Plate

PCMK: DP3165-001-157

Welder: 048659

Report: B-CWR 12243

WPS-345-SMAW-2G (2F)-FCM-Repair

Bay 7

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 Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3243-002-061

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Welder: 057795

WPS-B-P-2212-B-U2-FCM

Components: Cross Beam

PCMK: CB3003F-001-032,046

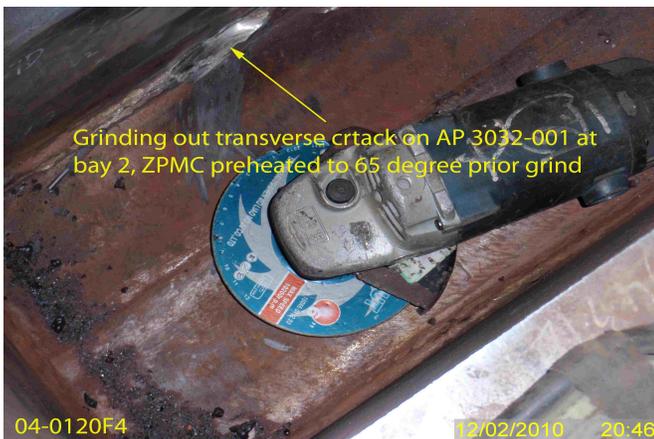
Welder: 275083

WPS-B-P-2212-B-U2-FCM

Bay 19

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 100 % 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; BK005A2, on item number 13, 14, 15, 16, 22 of NWIT tracker document # 07590,

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