

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-019282**Date Inspected:** 06-Jan-2011**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:** Sha Zhi**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 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 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 Base Metal

Welder: 207464

Report: B-CWR2710

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

Bay 3

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

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

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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: 20TR2-032

Welder: 058102

Report: B-CWR1568

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

Heat straightening of PCMK, SP3071-001-165, under approved Heat Straightening procedure, HSR 1 (B)-10029, 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 8

This QA inspector performed Ultrasonic Testing (UT) 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; BK04A1, BK4ASD1, BK04A5 on item number 1, of NWIT tracker document # 08068,

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; BK4A5-064-, on item number 1 of NWIT tracker document # 08072,

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhang Lin.

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: Segment 13CW

PCMK: SEG3015K-195

Welder: 045204

Report: B-WR18965

WPS-345-SMAW-3G (3F)-FCM-Repair

PCMK: SEG3015D-255

Welder: 201583

Report: B-WR18948

WPS-345-SMAW-3G (3F)-FCM-Repair

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Components: Segment 14W
PCMK: SEG3020M-003,004
Welder: 067611
Report: B-WR19826
WPS-345-SMAW-3G (3F)-FCM-Repair

PCMK: SEG3020K-021
Welder: 037780
Report: B-WR19831
WPS-345-SMAW-3G (3F)-FCM-Repair

PCMK: SEG3020R-033
Welder: 066421
Report: B-WR19826
WPS-345-SMAW-3G (3F)-FCM-Repair

PCMK: SEG3020AB-092~095
Welder: 067610
WPS-B-P-2114-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Zhang Lin.

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 14W
PCMK: SEG3020X-012
Welder: 066239
Report: B-CWR2661
WPS-345-FCAW-2G (2F)-FCM-ESAB-Repair

PCMK: SEG3020BB-019
Welder: 067103
WPS-B-T-2232-ESAB

PCMK: SEG3020BB-010
Welder: 068206
WPS-B-T-2232-ESAB

PCMK: SEG3020BB-037
Welder: 068445
WPS-B-T-2232-ESAB

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PCMK: SEG3020K-025

Welder: 067765

WPS-B-T-2232-ESAB

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:	Riley,Ken	QA Reviewer
