

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-019556**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

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

ZPMC QC is identified as Shao Hai Lang.

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.

Component; Bike Path

PCMK: BK004A2-028

Weld No. 015, 017

Welder: 040434

WPS-B-T-2132-2-plug

Component; Bike Path

PCMK: BK004A6-030

Weld No. 023, 035

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Welder: 040302
WPS-B-T-2132

Component; Tower Lift 5, suspender bracket
PCMK: SD1-BRSA5-1
Weld No. 19B
Welder: 054460
WPS-B-T-3213-TC-U4b

Heat straightening of PCMK, BK004A6-025 under approved Heat Straightening procedure, HSR1(B)-9015. The in process temperature was observed as 230°C. The ZPMC QC was identified as Shao Hai Lang. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 15mm.

Bay 14

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 Yu Jiao.

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.

Component; OBG Anchor Plate Assembly

PCMK: AP3031-001

Weld No. 284, 285, 332, 333, 380, 381, 428,429, 476, 477, 524, 525, 572, 573, 620, 621,
668, 669, 716, 717, 764, 765, 810, 811, 856, 857, 902, 903, 948, 949, 994, 995

Welders: 070254, 069841, 070046

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

Component; OBG 13AE

PCMK: SEG3007U

Weld No. 104

Welder: 070101

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

Component; OBG 13AE

PCMK: SEG3007T

Weld No. 102

Welder: 066155

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

Component; OBG 13AE

PCMK: SEG3007T

Weld No. 105

Welder: 068994

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

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 Li Ming 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.

Component; OBG 13AW

PCMK: SEG3013X

Weld No. 379, 382

Welders 066398

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

Component; OBG 13AW

PCMK: SEG3013C

Weld No. 006, 024

Welders: 066733, 069683

WPS-B-T-2233-TC-U4b

Component; OBG 13AW

PCMK: SEG3013Y

Weld No. 112, 067

Welder: 066763

WPS-B-T-2232-TC-U4b

Component; OBG 13AW

PCMK: SEG3013D

Weld No. 151, 156

Welder: 066439

WPS-B-T-2232-TC-U4b

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant 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: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer