

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-019889**Date Inspected:** 28-Dec-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 3

This Caltrans QA Inspector during random observation at ZPMC noted that the Carbon Arc Cutting (CAC) process on 13AE, piece number SP3083A, was used to completely remove, approximately 900cm, a plate to plate splice weld. Also noted at this location was ZPMC grinding this area to a smooth metal finish in preparation for the welding process as outlined in the contract documents. It looked to this QA inspector to be an improper fit up and weld. (see photo below)

Bay 8

This QA inspector performed VT of 100% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector documented this inspection on his Daily Summary report, Notification of Inspection Tracker (NDT) report, and this Welding Inspection report for this date. The member was identified as OBG Bike Path, BK004A-057. The weld reviewed are internal welds prior to bottom plate placement: NDT Tracker number is 07968.

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path, BK004A-059 and 064 at various locations due to contour grinding and visual indications as identified by

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ZPMC QC Inspectors.

Bay 10

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

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

ZPMC QC is identified as Li 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.

Component; Bike Path,

PCMK: BK004A1-033

Weld No: temporary lifting attachments

Welders: 052930, 053869, 040434,

WPS-B-T-2213

Heat straightening of PCMK, BK004A-031 under approved Heat Straightening procedure, HSR1 (B)-9865. The in process temperature was observed as 250°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 20mm.

Bay 11

This Caltrans QA Inspector observed ZPMC performing match drilling in Suspender Bracket, ND1-BR5A5-2-6.

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) 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: BK004A16-024

Weld No: fit up

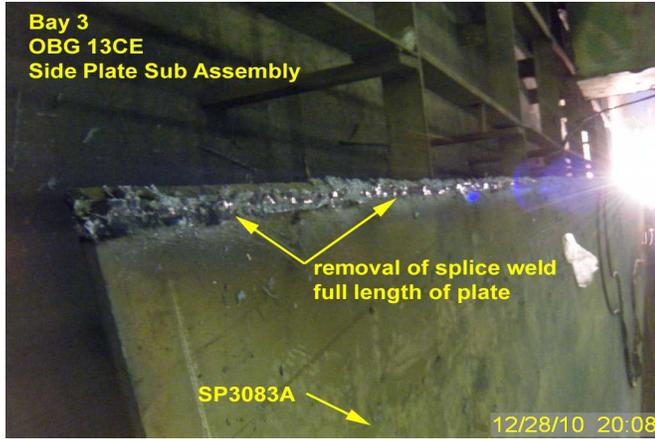
Welder: 052641

WPS-B-T-2113

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

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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.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer