

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-020671**Date Inspected:** 21-Jan-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 & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 6CE / Trial Assembly

This Caltrans QA inspector observed ZPMC welder performing weld repair (weld excavation) back gouging in accordance with critical weld repair, B-CWR-1139. The weld location being back gouged is identified as DP to EP-E2, CA030-002, 004 and 006. ZPMC Quality Control (QC) inspectors are identified as Mr. Zhang Qing and certified welding inspector (CWI); Mr. Li Yang.

Segment Name: Lift 4 South Tower / Bay 11

This Caltrans QA inspector observed the fit-up and Flux Cored Arc Welding (FCAW). Welder is identified as #053869 welding partial joint penetration (PJP) weld in the 3G position using WPS-B-T-4333-TC-P4-F. The weld is identified as SSSL4-1K/L-96 @ 143M top diaphragm. ZPMC QC/CWI inspector is identified as Mr. Du Zhiqun. Welding variables recorded by QC appeared to comply with the WPS.

Segment Name: Lift 4 South Tower / Bay 11

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #040581 welding complete joint penetration (CJP) weld in the 3G position using WPS-B-T-3213-B-U2a-1. The weld is identified as SSSL4-1I/L-96 @ 143M bottom diaphragm. ZPMC QC/CWI inspector is identified as Mr. Du Zhiqun. Welding variables recorded by QC appeared to comply with the WPS.

WELDING INSPECTION REPORT

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OBG Segment Name: 7CE / Trial Assembly

This Caltrans QA Inspector observed two (2) ZPMC workers performing heat straightening on T-stiffeners to side plate that were distorted during welding. The T-stiffeners and locations are identified as SP533-001-015~028 and SP573-001-013~024. ZPMC Quality Control inspector presented the Heat Straightening Repair Procedure for review. The Heat Straightening Repair Procedure is identified as HSR1-(B)-8105. The procedure calls-out a maximum temperature 650° Celsius for oxy-fuel flame method and that the heat shall be applied in a V-pattern. ZPMC Quality Control (QC) inspectors are identified as Mr. Hong Hui and certified welding inspector (CWI); Mr. Gu Rong Jian. The heat straightening in progress was found to be in compliance with the approved heat straightening procedure. The following digital picture illustrates heat straightening in progress. Photo please see; Z:\Inspector Reports\B293 Hasler.

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

Summary of Conversations:

“As noted within the contents of this report.”

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
