

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021934**Date Inspected:** 12-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:** Zhu Jun**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, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, Traveler Rail 20TR2-041, under approved Heat Straightening procedure, HSR 1 (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 Xiang Feng Feng. 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 2

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

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

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

Component: Anchor Plate

PCMK: AP3032-001

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Weld Number: 547, 605
Welder: 066236
WPS-345-SMAW-3G-FCM-Repair

Bay 6

This QA Inspector observed the following work in progress for Bay 6.
ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.
ZPMC QC is identified as Xu Xian Ping
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: Deck Plate
PCMK: DP3168-001
Weld Number: 127
Welder: 048659, 054467
WPS-345-SMAW-2G-FCM-Repair
B-CWR2303

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.
ZPMC QC is identified as Li Jia
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: Floor Beam
PCMK: FB3246-001
Weld Number: 028
Welder: 053753
WPS-345-SMAW-3G-FCM-Repair
B-WR18032

Component: Cross Beam
PCMK: CB3003A-019
Weld Number: 017
Welder: 049769
WPS-345-SMAW-4G-FCM-Repair
B-WR18720

Bay 14

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07751 from ZPMC

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for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3007C-170

SEG3009L-071, 069

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07754 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3013B-175

SEG3013T-079~082, 107, 108

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
