

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-021956**Date Inspected:** 19-Mar-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 1

Heat straightening of PCMK, 20TR2-044, under approved Heat Straightening procedure, HSR (B)-461, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Tian Lei. 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 80mm.

Bay 10

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

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

ZPMC QC is identified as Shi Yu.

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: Bike Path

PCMK: BK15-001-016,017

Welder: 050295

WPS-B-T-2221-TC-U4A-S

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

PCMK: BK16-004-016
Welder: 040581
WPS-B-T-2213-TC-U4A

Components: Traveler Rail
PCMK: 29TR1-16
Welder: 050038
WPS-B-T-2212-TC-U5b

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 Shi Yu.
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: Bike Path
PCMK: BK010A7-001-080
Welder: 040302
WPS-B-T-2232-ESAB

Heat straightening of PCMK, BK3003B, under approved Heat Straightening procedure, HSR 1 (B)-10167, 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 3mm.

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; Bike Path on item number 4 and 5, of NWIT tracker document # 08580,

Bay 11

This QA Inspector observed the following work in progress for Bay 11.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Mao Bin Bin.
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: Bike Path
PCMK: BK012-A4-001-040,041
Welder: 046769, 053316
WPS-B-T-2132-ESAB

This QA Inspector observed the following work in progress for Bay 11.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Mao Bin Bin.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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

PCMK: BK012A-001-044

Welder: 041271

WPS-B-P-2211-B-U2b

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; Tower Lift 6 on item number 2 and 3, of NWIT tracker document # 08580,

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

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

ZPMC QC is identified as Li 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

Components: 13AW

PCMK: SEG3032-205

Welder: 067588

WPS-B-P-2213-TC-U4b-FCM

PCMK: SEG3013A-016

Welder: 067572

WPS-B-P-2214-B-U2-FCM-1

PCMK: SEG3013AD-012

Welder: 069683

WPS-B-P-2214-B-U2-FCM-1

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

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

ZPMC QC is identified as Li Yang.

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: 13AE

PCMK: SEG3007C-095

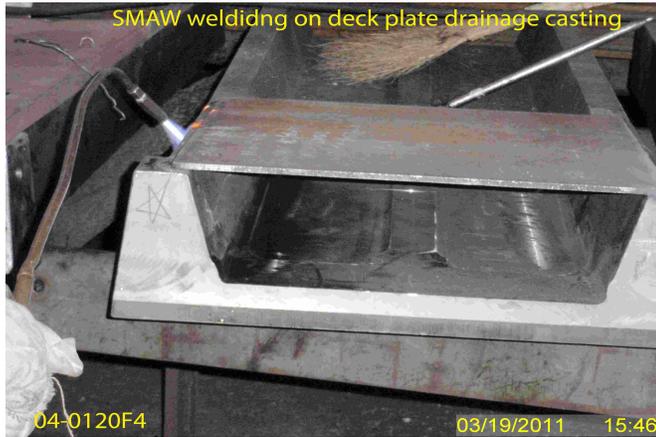
Welder: 050242

WPS-B-T-2232-ESAB

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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