

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

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-022330**Date Inspected:** 03-Apr-2011**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 random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

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

ZPMC QC is identified as Wong Xiang Pin, CWI Wang 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.

Components; OBG 14 W

PCMK: SEG3020AQ

Weld No: 025

Welder: 066398, 267611

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 038

Welder: 037932

WPS-B-P-2214-TC-U4b-FCM-1

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 047
Welder: 067829, 067765
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3014M
Weld No: 001
Welder: 045196
Weld Repair No. B-CWR2914
WPS-345-SMAW-2G(2f)-FCM-Repair-1

Components; OBG Traveler Rails
PCMK: TR3007TR1-001
Weld No: 016
Welder: 065246
Weld Repair No. B-WR20561
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG Traveler Rails
PCMK: TR3001TR1-001
Weld No: 015
Welder: 065246
Weld Repair No. B-WR20561
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG Traveler Rails
PCMK: TR3001TR2-001
Weld No: 042
Welder: 065246
Weld Repair No. B-WR20561
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13CW
PCMK: SEG3015A
Weld No: 0124
Welder: 065246
Weld Repair No. B-CWR2915
WPS-345-SMAW-1G(1F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

ZPMC QC is identified as Wong Xiang Pin, CWI Wang 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.

Components; OBG Traveler Rails

PCMK: TR3008D

Weld No: 021

Welder: 045240

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SEG3014B

Weld No: 012

Welder: 201583

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang 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.

Components; OBG

PCMK: SEG3020*

Weld No: 001

Welder: 045240

WPS-B-T-223(2)1-T-ESAB-1

Heat straightening of PCMK, SEG3020BB-029,038 under approved Heat Straightening procedure, HSR 1 (B)-10256. The in process temperature was observed as 420°C. The ZPMC QC was identified as Wong Xiang Pin.

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 4mm.

Heat straightening of PCMK, SEG3020BB-029,038 under approved Heat Straightening procedure, HSR 1 (B)-10245. The in process temperature was observed as 420°C. The ZPMC QC was identified as Wong Xiang Pin.

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 5mm.

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

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer