

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-022716**Date Inspected:** 11-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: SEG3020U

Weld No: 591

Welder: 066022, 067572

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

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

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

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Components; OBG 14W
PCMK: SEG3020P
Weld No: 007,011
Welder: 066673, 067876
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: DP3174-001
Weld No: 023
Welder: 048433
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: SEG3020R
Weld No: 007,010,013
Welder: 062708, 201215
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020T
Weld No: 319,321
Welder: 048433
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020T
Weld No: 298
Welder: 066398
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: SEG3020T
Weld No: 284,288,291,293
Welder: 066695
WPS-B-T-2232-ESAB

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 Xie Ming Feng, QA Zhang Qi Li .
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 E

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PCMK: DP3161-001
Weld No: 217
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: DP3161-001
Weld No: 177
Welder: 051359
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: DP3160-001
Weld No: 211
Welder: 058102
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019V
Weld No: 004
Welder: 044772
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Xie Ming Feng, QA Zhang Qi Li.
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 E
PCMK: SEG3019L
Weld No: 061
Welder: 055564
WPS-B-T-2232-ESAB

Components; OBG 14 E
PCMK: SEG3019F
Weld No: 019
Welder: 055491
WPS-B-T-2232-ESAB

Components; OBG 14 E
PCMK: SEG3019H
Weld No: 282

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Welder: 051356

WPS-B-T-2232-ESAB

Heat straightening of PCMK TR3002TR1-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 350°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 6mm.

Heat straightening of PCMK TR3002TR2-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 390°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 6mm.

Heat straightening of PCMK TR3008TR1-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 470°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 6mm.

Heat straightening of PCMK TR3008TR2-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. 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 6mm.

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 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
