

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-022759**Date Inspected:** 21-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, 20TR2-036,038, 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 8

This QA Inspector observed the following work in progress for Bay 8.

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

ZPMC QC is identified as Liu Chun Gang.

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: BK004A-060-015

Welder: 037840

WPS-B-P-2112-Plug

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This QA Inspector observed the following work in progress for Bay 8.

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

ZPMC QC is identified as Liu Chun Gang.

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: BK004A2-062-002,008

Welder: 219414

WPS-B-T-2132-ESAB

Heat straightening of PCMK, 7047-005,006, under approved Heat Straightening procedure, HSR 1(B)-10201, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Liu Chun Gang. 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 10mm.

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 Sun Zi Wang.

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: BK15A-001-034

Welder: 500363

WPS-B-P-2213-TC-U4c

PCMK: BK17-001-014

Welder: 040365

WPS-B-P-2213-TC-U4c

PCMK: BK17B-001-014

Welder: 040581

WPS-B-P-2213-TC-U4c

PCMK: BK3001-002

Welder: 040365

Report: B-WR20477

WPS-345-SMAW-2G (2F)-repair

Components: Traveler Rail

PCMK: 29TR1-16

Welder: 050038, 057220

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WPS-B-P-2212-TC-U5b

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

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

ZPMC QC is identified as Sun Zi Wang.

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: BK16-001-016,017

Welder: 209051

WPS-B-T-2221-TC-U4a-S

Heat straightening of PCMK, BK14A-003,004, under approved Heat Straightening procedure, HSR 1 (B)-10132,

The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was

identified as Sun Zi Wang. 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 15mm.

Bay 11

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 Yu Dong 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

Components: Sub Assembly

PCMK: SA6024A-001-003,004

Welder: 202354

WPS-B-T-2311-C-P2

PCMK: SA6022A-001-001,002

Welder: 202354

WPS-B-T-2112

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 Yu Dong Ping.

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: 12A6-001-021,158

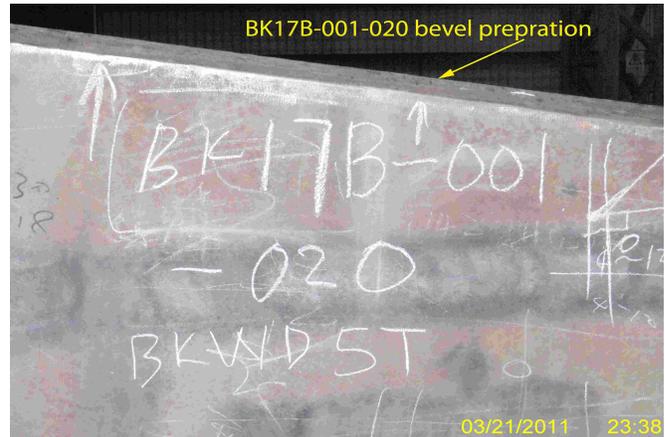
Welder: 053316

WPS-B-T-2133-ESAB

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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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Shin,DJ

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer