

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-022791**Date Inspected:** 23-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

This QA Inspector observed the following work in progress for Bay 1.

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

ZPMC QC is identified as Zhang Ya Xu.

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: Traveler Rail

PCMK: 20TR2-036-011

Welder: 054467

Report: B-WR20481

WPS-345-SMAW-1G (1F)-Repair

PCMK: 20TR2-037-009

Welder: 049769

Report: B-WR20481

WPS-345-SMAW-1G (1F)-Repair

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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: BK16B-001-004,005

Welder: 040581

WPS-B-P-2211-TC-U4C

PCMK: BK15A-001-003

Welder: 500363

WPS-B-P-2213-TC-U4C

PCMK: BK16A-001-015

Welder: 040581

WPS-B-P-2212-TC-U4C

PCMK: BK010A1-001-043

Welder: 052493

Report: B-WR20490

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

Components: Traveler Rail

PCMK: 31TR1-Base Metal repair

Welder: 050038

Report: 16931

WPS-345-SMAW-1G (1F)-Repair

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: BK16B-001-004

Welder: 209051

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

PCMK: BK16-001-016,017

Welder: 209051

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

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

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

ZPMC QC is identified as Sun Zi Wang.

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: BK15-X38E Base Metal Repair

Welder: 057258

Report: B-WR 16932

WPS-345-FCAW-3G (3F)-ESAB-Repair

Heat straightening of PCMK, BK15B-001-004,005, under approved Heat Straightening procedure, HSR 1 (B)-10219, 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 32mm.

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 Shas Hao Lang.

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: SA6020-001-005

Welder: 202354

WPS-B-P-2212-TC-U4C

PCMK: SA6019B-001-005

Welder: 041271

WPS-B-P-2212-TC-U4C

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

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

ZPMC QC is identified as Shas Hao Lang..

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: BK110A4-001-066

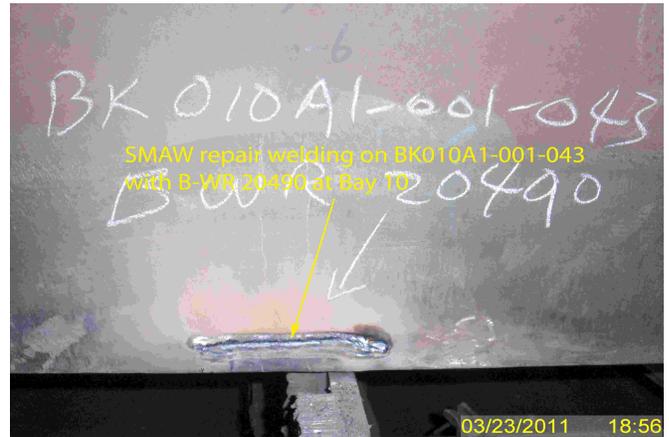
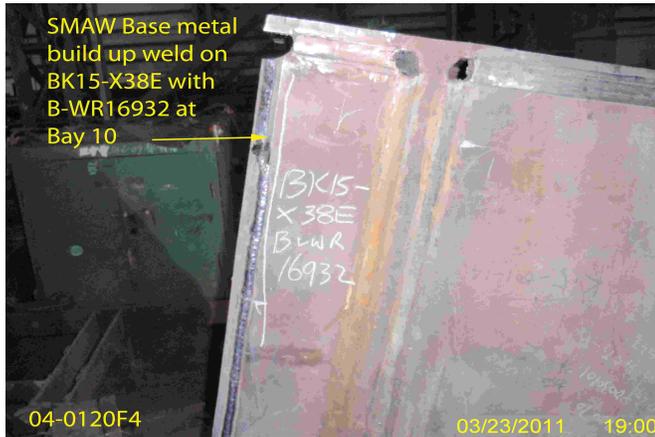
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Welder: 053316

WPS-B-T-2132-ESAB

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