

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-022792**Date Inspected:** 24-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: 20TR2-038-011

Welder: 062810, 049769

Report: B-WR20481

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

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 Zhu Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector

Components: Traveler Rail

PCMK: 37TR2-009,014

Welder: 040365

Report: B-WR20475

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

Components: Bike Path

PCMK: BK16-XBK43E (Base metal)

Welder: 057258

Report: B-WR16925

WPS-345-SMAW-3G (3F)-Repair

PCMK: BK15-001-017

Welder: 500363

Report: B-WR20497

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

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 Zhu Feng.

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: BK16A-001-013,016

Welder: 057266

WPS-B-T-2233-ESAB

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 Zhu Fen. 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.

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Bike Path, on item number 1&2 of NWIT tracker document # 08613,

Bay 11

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an

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MT report for this date. The member(s) is/are identified as follows; Bike Path, on item number 3 of NWIT tracker document # 08613,

Bay 14

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; OBG 13BE, on item number 1 of NWIT tracker document # 08616,

Trial Assembly Yard

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 Hai Feng.

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: SEG 3007B-086,093

Welder: 055564

WPS-B-T-2231-ESAB

PCMK: SEG 3007D-133,154,158,159

Welder: 050242

WPS-B-T-2231-ESAB

PCMK: SEG 3007B-017,023

Welder: 055564

WPS-B-T-2233-ESAB

PCMK: SEG 3007C-199,206,047,053

Welder: 050242

WPS-B-T-2233-ESAB

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 Hai Feng.

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: 13AE

PCMK: SEG 3007L-077,089,090

Welder: 068924

WPS-345-SMAW-3G (3F)-FCM-Repair

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

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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
