

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-022869**Date Inspected:** 26-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 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).

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

Components: Traveler Rail

PCMK: 29TR1-001-16

Welder: 057220

WPS-B-P-2212-TC-U5b

PCMK: 37TR2-009,014

Welder: 040582

Report: B-WR20475

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

Components: Bike Path

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

PCMK: BK17-BKX38D Base metal
Welder: 040581
Report: B-WR16932
WPS-345-SMAW-1G (1F)-Repair

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; BK 17B and BK 17C on item number 1& 2 of NWIT tracker document # 08637,

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 Hai 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: Tower Lift 6
PCMK: SSD1-TL6-1C/D-20,21
Welder: 052930
WPS-B-P-2313-TC-P4

PCMK: NSD1-FESA6-3-9, 10
Welder: 057258
WPS-B-P-2312-TC-P4

PCMK: ESD1-TL6-2C/D-6.7
Welder: 044541
WPS-B-P-2313-TC-P4

PCMK: WSD1-TL6-4C/D-21, 22
Welder: 040690
WPS-B-P-2313-TC-P4

Heat straightening of PCMK, NSD1-FESA6-3 and SSD1FFSA6-1, under approved Heat Straightening procedure, HSR 1 (B)-11665, 11666, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Shas Hai lang. 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 7mm.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; SA6020 on item number 1-6, of NWIT tracker document # 08639,

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Trial Assembly Yard

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 Li Yang.

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: 12BW

PCMK: OBW12C-022

Welder: 046709

Report: B-WR20512

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

PCMK: OBW12C-025

Welder: 046709

Report: B-WR20512

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

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

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

ZPMC QC is identified as Li Yang.

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: 13AW

PCMK: SEG3013Q-178,185,191

Welder: 048433

WPS-B-T-2233-ESAB

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; SP-EP-W1 on item number 1, of NWIT tracker document # 03262011-1,

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 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
