

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-022873**Date Inspected:** 31-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 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 Li 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: Traveler Rail

PCMK: 34TR1-001-009

Welder: 040614

WPS-B-P-2211-TC-U5b

PCMK: 34TR1-001-009

Welder: 044551

WPS-B-P-2211-TC-U5b

PCMK: 34TR1-001-009

Welder: 046204

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WPS-B-P-2211-TC-U5b

PCMK: 33TR1-001-011

Welder: 040723

WPS-B-P-2212-TC-U5b

PCMK: 35TR1-001-020

Welder: 044541

WPS-B-P-2211-B-U2b

PCMK: 28TR1-002-007

Welder:046769

WPS-B-P-2112

Heat straightening of PCMK, ESD1-FFSA6-2 & SSD1-FFSA6-1, under approved Heat Straightening procedure, HSR 1 (B)-11685 & 11666, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Wang Chuang Xin. 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 16 mm& 7mm.

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 Zhan 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: DP3076-001-026

Welder: 200113

Report: B-WR 20471

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

PCMK: SEG3007S-003

Welder: 068924

WPS-B-P-2213-TC-U4b-FCM-1

Components: 13AW

PCMK: SEG3013AA-118

Welder: 069683

Report: B-WR 20525

WPS-345-SMAW-4G (4F)-FCM-Repair

PCMK: SEG3013AD-063,061

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Welder: 047864
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG3013AA-063
Welder: 070432
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG3013AA-040
Welder: 037779
WPS-B-P-2213-TC-U4b-FCM-1

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 Zhan 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: RS3106-003,004
Welder: 050242
WPS-B-T-2231-ESAB

PCMK: RS3106-001
Welder: 055564
WPS-B-T-2231-ESAB

PCMK: RS3097-002
Welder: 055564
WPS-B-T-2231-ESAB

Components: 13AW
PCMK: SEG-3013C-065
Welder: 048433
WPS-B-T-2233ESAB

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

Inspected By:	Shin,DJ	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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