

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-023129**Date Inspected:** 27-Apr-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:** Shi Yu**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 Li Wei Lin.

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: Hand Rail

PCMK: BKR-NS-2

Welder: 215083

WPS-B-P-2112

Heat straightening of PCMK, BKR-NS-2, under approved Heat Straightening procedure, HSR 1 (B)-10267, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Li Wei Lin. 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 5

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Heat straightening of PCMK, 3026TR1, under approved Heat Straightening procedure, HSR 1 (B)-10291, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Li Wei Lin. 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 4mm.

Bay 9

Heat straightening of PCMK, SA7502C, 3024TR1 under approved Heat Straightening procedure, HSR 1 (B)-10314, 10282 The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Chen Shi 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 and 15mm.

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 Shi Yu.

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: Lateral Bracket

PCMK: X3305K-018-002

Welder: 053829

Report: B-WR 20842

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

PCMK: X3305K-033-001,002

Welder: 040581

Report: B-WR 20842

WPS-345-SMAW-3G (3F)-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 Shi Yu.

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: Lateral Bracket

PCMK: X3305K-038-001, 002

Welder: 054069

Report: B-WR 20842

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

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

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

ZPMC QC is identified as Mao Bin Bin.

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: WSD1-TL6-4C/D-20

Welder: 041271

WPS-B-P-2112

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
