

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-024123**Date Inspected:** 26-May-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 perform FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

Bay 7

Heat straightening of PCMK, BK018A-001, under approved Heat Straightening procedure, HSR 1 (B)-10366, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Jiang Xian Bo. 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 8mm.

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

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

ZPMC QC is identified as Jiang Xian Bo.

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: U-Rib splice channel

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PCMK: SA2310-1-1

Welder: 219414

WPS-B-P-2231-TC-U4b-FCM-1

Bay 9

Heat straightening of PCMK, TR3004A, under approved Heat Straightening procedure, HSR 1 (B)-10336, 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 3mm.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.
ZPMC perform fit up and grind work on bike path BK011A.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Shen Jian Bo.

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: TR3002TR2

Welder: 067752

Report: BWR-21056

WPS-345-SMAW-2G (2F)-repair-1

Heat straightening of PCMK, TR3008TR2, TR3021TR2, TR3001TR2 under approved Heat Straightening procedure, HSR 1 (B)-10227, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Shen Jian Bo. 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 8mm.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC perform SMAW VT repair welding and grind work on hand rails.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Peng Wen Jun.

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.

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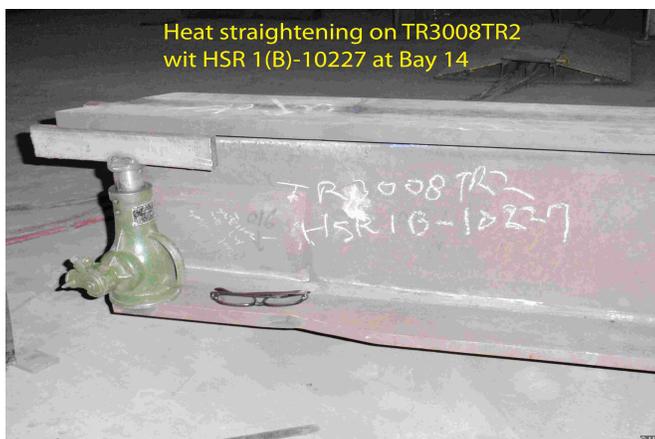
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Components: Bike Path
PCMK: BK24A8-001-011,082
Welder: 062806
WPS-B-T-2134-ESAB

PCMK: BK24A6-001-023
Welder: 062755
WPS-B-T-2134-ESAB

PCMK: BK24A6-001-002,008,019
Welder: 062757
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
