

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-024235**Date Inspected:** 02-Jun-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 6

This QA Inspector observed the following work in progress for Bay 6.

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

ZPMC QC is identified as Jiang Xiao 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: Bike Path

PCMK: BK3004-001-006

Welder: 215397

WPS-B-P-2233-ESAB

PCMK: BK3003-001-008

Welder: 205386

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

WPS-B-P-2233-ESAB

Bay 9

This QA Inspector observed the following work in progress for Bay 9.

ZPMC perform grinding work on the hand rail, Traveler rail and fit up on traveler rail support.

Bay 11

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

ZPMC perform grinding work on the BK012A.

Bay 14

Heat straightening of PCMK, TR3027TR1-001, 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 Jang 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 6mm.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

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

ZPMC QC is identified as Guo Qiming.

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: Steel Barrier

PCMK: E5-SB36-001

Welder: 201861

WPS-B-P-2112

Heat straightening of PCMK, BKR-FS-2, under approved Heat Straightening procedure, HSR 1 (B)-10398, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Guo Qiming. 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 19

This QA Inspector observed the following work in progress for Bay 19.

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

ZPMC QC is identified as Guo Xing Hui.

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: Bike Path

PCMK: BK24A-001

Welder: 259906

WPS-B-P-2212-TC-U4b

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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 Guo Xiang Hui.

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: BK23A6-001-015

Welder: 062904

WPS-B-T-2231-ESAB

PCMK: BK23A8-001-011

Welder: 062757

WPS-B-T-2231-ESAB

PCMK: BK23A8-001-008~010

Welder: 062806

WPS-B-T-2232-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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Shin,DJ	Quality Assurance Inspector
----------------------	---------	-----------------------------

Reviewed By:	Riley,Ken	QA Reviewer
---------------------	-----------	-------------