

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025533**Date Inspected:** 30-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This QA inspector performed MT 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. All components were as listed on NWIT notification no. 07989. The member(s) is/are identified as OBG Traveler rail as component 20TR2-048. The weld designations reviewed are as follows:

1. 20TR2-048 repair area, reference B-CWR-2552.

Bay Number 2

SMAW welding of fillet welds located on Anchorage Plate component identified as AP3032-001 as identified on weld repair data sheet B-CWR-2617 for repaired crack fillet welds identified as weld no.(s): 644, 740, 553, 885, 835, & 836. Welder is identified as welder no. 066002. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-FCM-repair.

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Bay Number 3

FCAW welding of complete joint penetration welds located on Sub Assembly component identified as SA7015-002 for weld no. 001, 002, 003, & 004. Welder is identified as welder no. 053116. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding of complete joint penetration welds located on Sub Assembly component identified as SA7013-001 for weld no. 001, 002, 004, & 005. Welder is identified as welder no. 054069. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

SMAW welding of fillet welds located on Architectural Housing component identified as AH3151 for weld no. 001. Welder is identified as welder no. 058087. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2212-B-U2.

FCAW welding of complete joint penetration welds located on Architectural Housing component identified as AH3151 for weld no. 002, 038, & 039. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB & WPS-B-T-2133.

FCAW welding of fillet welds located on Architectural Housing component identified as AH3151 for weld no. 038, 036, 034, 039, 030, 059, & 060. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail components identified as 20TR2-041 & 20TR2-042. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSRB-362.

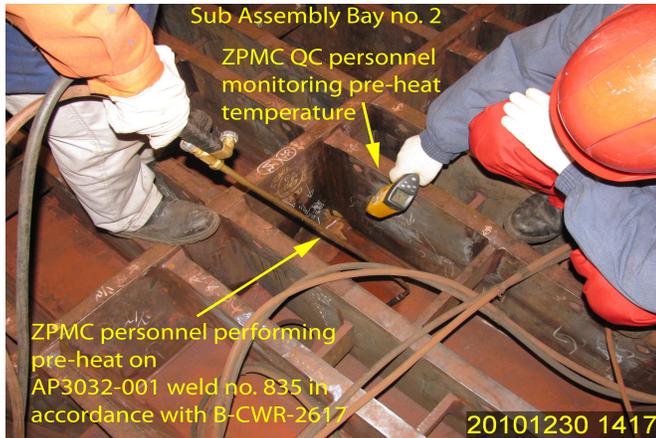
Bay Number 4

This QA inspector did not observe any welding or contract work being conducted in this bay.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents.

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Summary of 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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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