

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-025874**Date Inspected:** 21-Jul-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 Zi			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 6

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; BK018A-001-005, on item number 1, of NWIT tracker document # 09787,

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) 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. The member(s) is/are identified as follows; BK018A-001-005 on item number 1 of NWIT tracker document # 09787,

Bay 9

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

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

ZPMC QC is identified as Chen Xi Gang.

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: Traveler Rail

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

PCMK: TR3018TR2-001-004,005

Welder: 059418

WPS-B-T-2131-ESAB

PCMK: TR3017TR1-001-006, 017

Welder: 059443

WPS-B-T-2131-ESAB

PCMK: TR3017TR2-008, 009

Welder: 059416

WPS-B-T-2231-ESAB

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was performing match drilling on splice plate angles for lifts 13 and 14. ZPMC was also noted performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting and removing the burr's caused by drilling.

Bay 16

Heat straightening of PCMK, BKR-G-005, under approved Heat Straightening procedure, HSR 1 (B)-10418, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ma Chun Li. 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 Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Shen Jian 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: BK9003-001-039

Welder: 062808

WPS-B-T-2132-ESAB

PCMK: BK9003-001-061

Welder: 062806

WPS-B-T-2132-ESAB

PCMK: BK9003-001-056

Welder: 062794

WPS-B-T-2132-ESAB

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
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Reviewed By:	Riley,Ken	QA Reviewer
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