

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-025877**Date Inspected:** 25-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 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

PCMK: TR3018TR2-001-037

Welder: 059418

WPS-B-T-2132-ESAB

PCMK: TR3018TR2-001-031

Welder: 059421

WPS-B-T-2132-ESAB

PCMK: TR3017TR1-001-031

Welder: 059443

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WPS-B-T-2132-ESAB

PCMK: TR3017TR2-037

Welder: 059416

WPS-B-T-2132-ESAB

PCMK: TR3018TR1-001-010,003

Welder: 201788

WPS-B-T-2232-ESAB

Heat straightening of PCMK, TR3010, under approved Heat Straightening procedure, HSR 1 (B)-10415, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Chen Xi 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 8mm.

Bay 14

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

ZPMC was performing match drilling on splice plate angles and shim plates 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

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

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

ZPMC QC is identified as Ma Chun Li.

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

PCMK: TR3004TR1-001-008

Welder: 201074

WPS-B-T-2232-ESAB

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 Guo Xing Hai.

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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Components: Bike Path
PCMK: BK9003-001-001, 002
Welder: 062794
WPS-B-T-2132-ESAB

ON this date QA Inspector was issued incidental reports as follow:

Description of Incident: During the Quality Assurance (QA) random visual inspection of splice plate and connecting angle in Bay 14, this QA Inspector discovered the following issues:

- ZPMC has completed plug weld on connection angle SA-3341A,B,C,D
- ZPMC has completed plug weld on splice plate 59D, total 8 bolt holes were completed plug weld out of 18 holes
- There are total No of 4 splice plates (59D), and 4 pieces of SA3341(A~D)
- The plug welding was not approved by the Engineer.
- The plug welding was not followed by approved procedure.
- splice plate and connection angle is located in inside BAY 14.

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