

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-023580**Date Inspected:** 05-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:** See Below**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, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail. ZPMC QC inspector Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10291

3020TR1-001

Bay 7

This QA inspector observed ZPMC in process of SAW welding on cantilever box beam assembly. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder operator and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BKSA015-001-013, 014, 015, 016

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2221-TC-U4a-S-2

Welder- 044771

1G/SAW/CJP

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on OBG sub-assemblies. ZPMC CWI Liu Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- LB3001A-001-002~005, 007~010

WPS-B-T-2132-ESAB

Welder- 219414

2F/FCAW

Weld- SB3001A-001-002~005, 007~010

WPS-B-T-2132-ESAB

Welder- 054459

2F/FCAW

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09036 Item 1 for Trial Assembly OBG 14E. This QA Inspector performed verification Ultrasonic Testing (UT) inspection after ZPMC had performed their UT inspection of the following locations;

SEG3019P-159, 164, 169, 174, 219, 179, 184, 189, 194, 199, 204, 209, 214, 147, 153, 159, 165

See Caltrans Ultrasonic Test Report (TL6027), dated 05-05-2011 for additional information. However, ZPMC inspector Zhan Hai Feng canceled QAUT inspection on welds 147, 153, 159, 165

The following digital picture illustrates QAUT inspection of typical welds.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

“As noted within the contents of this report.”

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 James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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