

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-024018**Date Inspected:** 02-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: Mr. Li Yan Hua
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 001, 002 as per WRR no. B-WR-20855, Located on U Rib splice plate X3305K-066.

Welder is identified as 067611. ZPMC Quality Control Inspector (QC) is identified as Wang Jun. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair.

Flux Cored arc welding (FCAW)

Repair welding of Weld joint- 009 as per WRR no. B-WR-20892, Located on Container Box Bracket BK 015-001.

Welder is identified as 044473. ZPMC Quality Control Inspector (QC) is identified as Wang Jun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

Bay #19

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This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 008 Located on Bike path panel BK-23A1-001. Welder is identified as 062783. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 009 Located on Bike path panel BK-23A7-001. Welder is identified as 065739. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW)

Repair weld of Weld joint- X64A, as per CWR no. B-CWR-2877, Located on Suspender Bracket SB22-106W. Welder is identified as 259566. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)- Repair.

Heat Straightening:

Heat Straightening being performed on Cable Bracket identified as SA 6031-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10329.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 003, Located on Bike path Hand rails, FS56. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 002, Located on Bike path Hand rails, FS3. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer