

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-024221**Date Inspected:** 19-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.

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding segment weld. ZPMC CWI Li Yang 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 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

14E/13CE

Weld- BP3045-001-049-060

WPS-B-P-2112-FCM-1

Welder- 070007

2F/SMAW

The following digital picture illustrates welding in progress.

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding segment weld. ZPMC QC inspector Xie Ming Feng was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Yang as the CWI.

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It was stated that ZPMC had 3 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;

13BE (WR20888)

Weld- SEG3009G-225

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Welder- 070007

3G/SMAW/CJP

13BE

Weld- SEG3009B-067, 071, 075, 079, 083, 087

WPS-B-T-2233-ESAB

Welder- 055491

3G/FCAW/CJP

13AE

Weld- SEG3007C-216

WPS-B-T-2231-ESAB

Welder- 050242

1G/FCAW/CJP

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



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.

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