

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-024815**Date Inspected:** 26-Jun-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 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on bike path assemblies. ZPMC CWI inspector Yu Dong Ping 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;

Weld- BK011A3-001-073

WPS-B-P-2112

Welder- 067184

2F/SMAW

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening on cantilever truss assembly. ZPMC CWI inspector Chen Shi Gang 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 welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

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Bike Path Handrail Sub-assembly

Tack Welding

Welder- 059418

1F/FCAW (ESAB)

Heat Straightening

HSR1 (B) 10413

BK13-002

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening bike path handrail assembly. ZPMC CWI inspector Liu Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10400

BKR-NS-3

Bay 16

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ABF QC inspector Gao Zhen Kun 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 4 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;

BK21A

UT Repair

Welder- 201074

3G/FCAW

MT Inspection/ Tracking

This Caltrans QA inspector witness and performed Visual Testing (VT) of an area that have been previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. This QA Inspector generated a MT tracking report for this date and indicated ABF accept or reject of the welds. The OBG segment is identified as 14W in Bay 14. The weld designation as follows:

SEG3020K-291, 292, 295, 296, 299, 300, 303, 304, 307, 308, 311, 312, 315, 316, 318, 319, 320, 323, 324, 327, 334, 338, 342, 355, 356, 357, 358, 359, 360

This Caltrans QA inspector performed MT of approximately 15% of an area that have been previously tested and accepted by ABF personnel. This QA inspector generated a Caltrans Magnetic Particle Test Report (TL6028), dated 06-26-2011 for the following welds:

SEG3020K-299, 300, 303, 304, 307, 308, 334, 338, 342, 355

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At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 06-26-2011 for additional information.

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.

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