

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-024912**Date Inspected:** 15-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 11

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 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;

Weld- BK012A2-001-017

WPS-B-T-2112-Plug

Welder- 066326

2F/SMAW/Plug

Weld- BKSA011A3-001-144 & 146

WPS-B-P-2212-TC-U4b

Welder- 202354

2G/SMAW/CJP

Bay 19

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on bike path assemblies. ZPMC CWI inspector Guo Xing Hui 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;

Weld- BK25A8-001-001 ~ 004
WPS-B-P-2211-TC-U4c-FCM-1
Welder- 059906
1F/SMAW/CJP

Weld- BK24A10-001-001 ~ 004
WPS-B-T-2231-ESAB
Welder- 062806
1F/FCAW/CJP

Heat Straightening
HSR1 (B) 10356
BK25A2-001-001, 002

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09478 Item 1 for Bike Path Assembly BK23A, Bay 19. This QA Inspector performed Visual Testing (VT) and verification Magnetic Particle Testing (MT) inspection after ZPMC had performed their MT inspection of the following locations;

Item 1; BK23A7-001-006, 007, 013, 014, 015, 023, 024, 025; BK23A3-001-092~097, 099, 100, 102~105, 107, 108, 110~113, 115, 116, 118~121; BK23A4-001-181, 182, 188, 189, 196, 197, 204, 205, 183, 184, 193, 194, 199, 200, 209, 210, 185, 186, 191, 192, 201, 202, 207, 208

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 06-15-2011 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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