

**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-026090**Date Inspected:** 24-Jul-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 9**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that in Bay 9 ZPMC was in the process of heat straightening. CWI Chen Shi Gang was present at the time of this observation and informed this QA inspector of the work in process. It was stated that ZPMC is performing Heat Straightening in accordance with HSR1-(B) 10415 on bike path traveler rail 3010TR1.

This QA inspector observed ZPMC flux cored arc welding (FCAW). During the observation performed it was noted that in Bay 9 ZPMC was in the process of welding bike path traveler rails and cantilever box beam. CWI Chen Shi Gang informed this QA inspector of the work 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- 3017TR1-001-031

WPS- B-T-3132-ESAB

Welder- #059443

2F/FCAW

Weld- 3017TR2-001-037

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WPS- B-T-3132-ESAB

Welder- #059416

2F/FCAW

Weld- BKSA13-001-009

WPS- B-T-3133-ESAB

Welder- #059378

3G/FCAW/CJP

Bay 16

This QA inspector observed ZPMC FCAW and heat straightening. During the observation performed it was noted that in Bay 16 ZPMC was in the process of welding bike path traveler rails and heat straightening handrails. CWI Li Yan Hua was present at the time of this observation and informed this QA inspector of the work in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC and 2 workers heat straightening. This QA inspector verified this information for the following location;

Weld- TR3004-001-010~015

WPS- B-T-2232-ESAB

Welder- #201074

2G/FCAW/CJP

Weld- TR3004-001-002~007

WPS- B-T-2232-ESAB

Welder- #222396

2G/FCAW/CJP

Heat Straightening

HSR1 (B) 10418

BKR-FS2~BKR-FS-40

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 Eric Tsang 15000422372, 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