

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-019429**Date Inspected:** 18-Jan-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:** Wang Liang**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 Orthotropic Bridge Girders (OBG) located at ZPMC Shanghai, China. During the observation performed it was noted that at Bay 10, ZPMC was in process of welding bike path assembly weld repairs. ZPMC QC inspector Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 2 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-BK008A1-001-043

WPS-345-FCAW-2G(2F)-Repair

Welder-040434

2G/ CJP/ ESAB

Weld-BK008A1-001-043

WPS-345-SMAW-2G(2F)-Repair

Welder-500363

2G/ CJP/ SMAW

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WR number for weld repair procedure has not been received for implementation.

Bay 14 (west line)

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08218 from ZPMC for Bay 14. This QA inspector performed ultrasonic test (UT) verification for Item 1 & 2, after ZPMC had performed their UT inspection of the following locations.

Item 1

SEG3013AV-092

Item 2

SEG3013AV-089

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 01-18-2011 for additional information.

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted, ZPMC was in process of welding traveler rail weld repair. ZPMC Certified Welding Inspector Wang Liang 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 them by ZPMC. This QA inspector verified this information for the following locations;

(WR20050)

Weld-20TR2-032-011

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

Welder-058102

1G/ CJP/ SMAW

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 , who represents the Office of Structural Materials for your project.

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