

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-019776**Date Inspected:** 24-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:** 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 13

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 13, ZPMC was in process of welding Grillage Saddle. ZPMC QC inspector Zhan Hai Feng was present at this time of this observation and informed this QA inspector of the work that is in process, and identified ABF inspector Yu Jiao as the CWI. 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-SEG7038C-002

WPS-B-T-2231-ESAB

Welder-037723

1G/FCAW/ PJP

Weld-SEG7038C-007

WPS-B-T-2231-ESAB

Welder-066733

3G/FCAW/ PJP

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Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8, ZPMC was in process of welding on bike path assembly welds. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process, and identified Liu Fa Wen as the CWI. 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-BK004A2-063-002

WPS-B-T-2132-ESAB

Welder-054459

2G/ PJP /FCAW

Weld-BKASD1-059, 001, 002, 003, 004

WPS-B-P-2211-TC-U4c

Welder-040673

1G/ CJP / SMAW

Weld-BK004A2-063-017, 019, 020

WPS-B-P-2112-Plug

Welder-066155

Flat/ CJP / SMAW

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3, ZPMC was in process of heat straightening traveler rail. Heat straightening procedure identified as HSR1 (B) 362 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 worker performing this heat straightening.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of welding traveler rail weld repair (WR14320). ZPMC QC inspector Yu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process, and identified Fu Guo Gang as the CWI. It was stated that ZPMC had 7 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;

WR14320

Weld-20TR2-039-011

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

Welder-040365, 056200, 056364, 042336, 057220, 500363

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

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Welder-040434

2G/ SMAW

The following digital picture illustrates welding weld repair (WR14320).

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



Summary of Conversations:

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

Reviewed By: Riley, Ken

QA Reviewer
