

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-019777**Date Inspected:** 23-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 14 (east line)

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 14, ZPMC was in process of welding. 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 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;

14E

Weld-SEG3019BB-103

WPS-B-P-2212-TC-U4b-FCM

Welder-215553

2G/SMAW/ CJP

Weld-SEG3019AG-001

WPS-B-T-2233-ESAB

Welder-066763

3G/FCAW

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Bay 13

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 13, ZPMC was in process of welding on 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 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-SEG7038C-004
WPS-B-T-2231-ESAB
Welder-066733
3G/FCAW

The following digital picture illustrates welder #066733 welding SEG3038C-004.

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 critical weld repair (CWR1868), bike path BKX52A panel weld build-up (butter-up) on plate edge. ZPMC QC inspector Jiang Xian Bo 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 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;

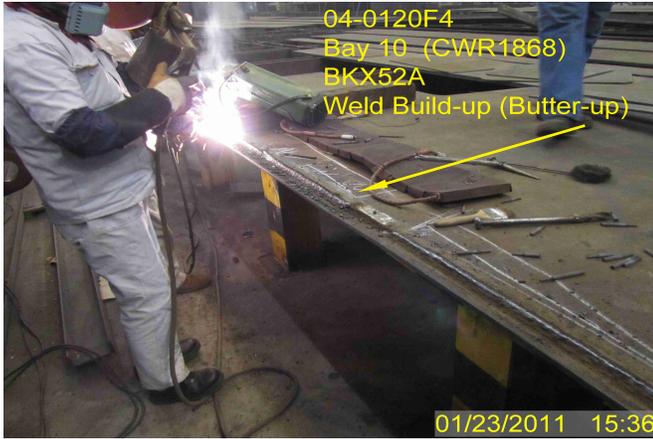
CWR1868
Weld-BKX52A
WPS-345-SMAW-2G(2F)-Repair
Welder-040582, 040581, 050038
2G/ SMAW

The following digital picture illustrates welding plate edge weld build-up per CWR1868.

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

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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
