

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020539**Date Inspected:** 05-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu dao feng**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:** Splice Plates, Handrails**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Traveler Rail, (OBG) member identified as 20TR2-040. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Yin Chun feng was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HRS 1 (B)-8658-20TR2-(017-052).

SMAW welding of Hand Rail identified SB5, welder is identified as 067752, ZPMC Quality Control (QC) is identified as Mr. Mai quin li. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint SA3321A-028-001, located on Splice Plate, identified as SA3321A-028, welder is

WELDING INSPECTION REPORT

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identified as 059578, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3321B-019-003, located on Splice Plate, identified as SA3321B-019, welder is identified as 203805, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
Reviewed By:	Hall, Steven	QA Reviewer
