

**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-021673**Date Inspected:** 08-Mar-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 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding weld repairs on Re-Built traveler rail assembly. ZPMC CWI Tian Lei 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 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;

WR20368

Weld- 20TR2-036-017

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

Welder-217185

1G/CJP/FCAW

WR20368

Weld- 20TR2-037-011, 013

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

Welder-054467

1G/CJP/SMAW

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WR20368

Weld- 20TR2-037-015

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

Welder-057795

1G/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 FCAW (ESAB) welding on Architectural Housing subassembly AH3151-001. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- AH3151-001

WPS-B-T-2231-ESAB

Welder-067601

1G/CJP/FCAW

Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of welding on bike path assembly. ZPMC CWI Zhao Chen Sun 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 then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK011A6-001-112, 113

WPS-B-T-2131-ESAB

Welder-040785

2G/SMAW/CJP

Bay 10

This QA inspector observed ZPMC in process of FCAW welding on traveler rail assembly. ZPMC OC inspector Yin Chun Fang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK15B-001-017

WPS-B-P-2211-TC-U4c

Welder- 040582

1G/SMAW/CJP

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This QA inspector observed during the observation that at Bay 10 ZPMC was in process of performing fit-up and SMAW tack welding interior components on bike path assembly BK014A-001. ZPMC QC identified welder 056567 welding in the 1F position.

### Trial Assembly

This QA inspector observed ZPMC in process of SMAW welding on Lift 12 segment assemblies. ZPMC OC inspector Wang Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Zhong Hai as the CWI. It was stated that ZPMC had 4 welder and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

12AE

Weld- CA6501D-013

WPS-B-P-2114-FCM-1

Welder- 040270

4F/SMAW

12AE

Weld- CA6501C-061

WPS-B-P-2113-FCM-1

Welder- 040378

3F/SMAW

12BW + 12CW

Welder- 202316/ SMAW

VT repair/ T-rib holdback

12BW + 12CW

Welder- 053697/ SMAW

Fit-up/ TW/ LD splice plate

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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer