

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-022230**Date Inspected:** 31-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 & Tower**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 observed ZPMC in process of SMAW fit-up tack welding sub-assemblies. 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- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 054456

2F/SMAW

Bay 4

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding Bike Path Sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei 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;

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Weld- 29BK2-001-013, 014, 023, 024

WPS-B-T-2132-ESAB

Welder- 066683

2F/FCAW

Weld- 28BK1-001-003, 004

WPS-B-T-2132-ESAB

Welder- 219414

2F/FCAW

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 215169

2F/SMAW

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Saddle Housing assembly. 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 Fu Wen as the CWI. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to them by ZPMC. This QA inspector verified this information for the following location;

Weld- SH3009-001 ~ 006

WPS-B-T-2132-ESAB

Welder- 054459

2F/FCAW

Weld- SH3009-021, 022

WPS-B-T-2132-ESAB

Welder- 500479

2F/FCAW

Weld- SH3001 (VT Repairs)

WPS-B-P-2112

Welder- 066459

2F/SMAW

Weld- LB3001-001-051, 061

WPS-B-T-2232-ESAB

Welder- 219414

2G/FCAW/CJP

Weld- SH3010-001-027, 028

WPS-B-T-2132-ESAB

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Welder- 500405
2F/FCAW

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Bike Path Traveler Rails and Hand rail sub-assemblies. ZPMC QC inspector Zhu Zhong Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Che Shi 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;

Weld- 3016TR4-002-008
WPS-B-T-2231-ESAB
Welder- 203805
1G/FCAW/CJP

Weld- 3016TR4-001-007
WPS-B-T-2231-ESAB
Welder- 062265
1G/FCAW/CJP

Weld- 3013TR1-001-002
WPS-B-T-2231-ESAB
Welder- 059421
1G/FCAW/CJP

Weld- 3012TR1-001-001
WPS-B-T-2231-ESAB
Welder- 059403
1G/FCAW/CJP

Weld- 3014TR2-001-003
WPS-B-T-2231-ESAB
Welder- 059416
1G/FCAW/CJP

Weld- 3016TR1-002-001
WPS-B-T-2231-ESAB
Welder- 059418
1G/FCAW/CJP

Weld- Bike Path Hand Rails
WPS-B-P-2112
Welder- 0201840

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2F/SMAW

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening. ZPMC QC inspector Shi Yu 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 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- 31TR2-001-031, 032

WPS-B-P-2211-B-U2

Welder- 040582

1G/SMAW/CJP

Weld- BK17B-001-021

WPS-B-T-2221-TC-U4a-S

Welder- 207745

1G/SAW/CJP

Heat Straightening

HSR1 (B) 10186

29TR

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.

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