

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-022232**Date Inspected:** 29-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 welding weld repair on Re-Built traveler rail 20TR2 assembly and heat straightening (HSR (B) 461) traveler rail 20TR2-038-011. 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;

WR20481

Weld- 20TR2-044-011

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

Welder- 049769

1G/SMAW/CJP

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

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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- SA7047-005, 006
WPS-B-T-2231-ESAB
Welder- 054459
1G/FCAW/CJP

Weld- SA7047-003, 004
WPS-B-T-2231-ESAB
Welder- 500479
1G/FCAW/CJP

Weld- SA7535-007, 008
WPS-B-T-2231-ESAB
Welder- 500405
1G/FCAW/CJP

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. ZPMC CWI Chen Shi Gang 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 6 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- 3012TR2-001-004
WPS-B-T-2231-ESAB
Welder- 059443
1G/FCAW/CJP

Weld- 3012TR3-001-005
WPS-B-T-2231-ESAB
Welder- 059378
1G/FCAW/CJP

Weld- 3012TR5-001-010
WPS-B-T-2231-ESAB
Welder- 203805
1G/FCAW/CJP

Weld- 3014TR1-001-001
WPS-B-T-2231-ESAB
Welder- 062265
1G/FCAW/CJP

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Weld- Bike Path Hand Rails

WPS-B-P-2112

Welder- 059464

2F/SMAW

Weld- Traveler Rail

WPS-B-P-2112

Welder- 201840

2F/SMAW

Tack Welding Web to Flange

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 CWI Li Jun 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 6 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;

WR20513

Weld- 28TR1-001-013

WPS-345-SMAW-2G(2F)-Repair

Welder- 040582

2G/SMAW/CJP

Weld- BK008A-001-MEP-087

WPS-B-P-2114

Welder- 040581

4F/SMAW

Weld- BK014A1-001-044

WPS-B-P-2214-B-U2

Welder- 044511, 056364

4G/SMAW/CJP

Weld- BK008A1-001-MEP-004, 007

WPS-B-P-2113

Welder- 500363

3F/SMAW

Heat Straightening

HSR1 (B) 10186

37TR

The following digital picture illustrates welding BK014A1-001-044 CJP weld.

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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
Reviewed By:	Riley, Ken	QA Reviewer
