

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-022234**Date Inspected:** 27-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 observed ZPMC in process of SMAW welding on Re-Built traveler rail 20TR2 assemblies, Bike Path Handrail sub-assemblies and oxy-flame cutting plate bevels for Lift 13 & 14 Frame Beam. ZPMC QC inspector Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Tian Shu 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;

WR20481

Weld- 20TR2-036-011

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

Welder- 054467

1G/SMAW/CJP

Weld- Bike Path Handrail sub-assemblies

WPS-B-P-2112

Welder- 215248

2F/SMAW

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Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8 ZPMC was in process of welding on Saddle Housing. 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 Lin Za Wen. 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- SH3001-052, 053

WPS-B-T-2132-ESAB

Welder- 219414

2F/FCAW

Weld- SH3002-060, 061, 068, 069

WPS-B-T-2132-ESAB

Welder- 054459

2F/FCAW

Weld- SH3008-041, 042, 049, 050

WPS-B-T-2132-ESAB

Welder- 500405

2F/FCAW

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 and heat straightening traveler rail. ZPMC CWI inspector 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 8 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;

WR16933

Weld- Build-up Weld

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

Welder- 052493

2G/SMAW

Plate BK27L, LA, BK26M, MA

Weld- BK14A1-001-044

WPS-B-P-2211-B-U2

Welder- 044511, 056364

1G/SMAW/CJP

Weld- BK14A1-001-043

WPS-B-P-2232-ESAB

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Welder- 053869
1G/FCAW/CJP
WR20514

Weld- BK16-001-013, 016
WPS-345-SMAW-3G(3F)-Repair
Welder- 040582
3G/SMAW/CJP

WR20515
Weld- BK16B-001-001
WPS-345-SMAW-2G(2F)-Repair
Welder- 500363
2G/SMAW/CJP

WR20515
Weld- BK16B-001-002
WPS-345-SMAW-3G(3F)-Repair
Welder- 057220
3G/SMAW/CJP

WR20515
Weld- BK16B-001-004
WPS-345-SMAW-2G(2F)-Repair
Welder- 040365
2G/SMAW/CJP

Heat Straightening
HSR1 (B) 10186
27TR

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