

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-022235**Date Inspected:** 28-Feb-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 11

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 rail assembly and heat straightening. ZPMC CWI Yu Dong Peng 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- 20TR2-035-009

WPS-B-P-2211-TC-U5b

Welder-044541

1G/SMAW/CJP

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding traveler rail assembly and cable tray sub-assemblies. 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 5 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- 20TR2-036-009, 013, 015, 017
WPS-B-P-2211-TC-U4b
Welder-057795, 054467, 049769
1G/CJP/SMAW

Weld- Cable Tray Support Sub-assembly
WPS-B-P-2112
Welder-215083, 217185
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 CWI Shao Hai Lang 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-BK010-076, 077, 082, 083
WPS-B-T-2132-ESAB
Welder-052075, 053869, 040304, 040533
2F/FCAW

Weld-BK004A1-009
WPS-B-T-2211-B-U2
Welder-061938
1G/SMAW/CJP

Heat Straightening
HSR1 (B) 10129
BK009A/ Deck Plate

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Lift 12. ZPMC CWI Li Yang 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;

CWR2813 (Rev. 1)
12BE+12CE
Weld-OB12A-003
WPS-345-SMAW-4G(4F)-FCM-Repair-1
Welder-067752

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4G/SMAW/CJP

CWR2811 (Rev. 1)

12BE+12CE

Weld-OBE12C-001

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Welder-067752

4G/SMAW/CJP

WR19624

12BW+12CW

Weld-SEG3006-011

WPS-345-SMAW-4G(4F)-FCM-Repair-1

Welder-046709

4G/SMAW/CJP

CWR2829

12BW+12CW

Weld-OBW12E-001

WPS-345-SMAW-4G(4)-FCM-Repair-1

Welder-040611

4G/SMAW/CJP

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
