

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-022238**Date Inspected:** 13-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 inspector 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 them by ZPMC. This QA inspector verified this information for the following location;

WR20366

Weld- 20TR2-038-009

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

Welder-053609

1G/CJP/SMAW

WR20366

Weld- 20TR2-038-011

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

Welder-049769

1G/CJP/SMAW

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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 heat straightening traveler rail 20TR2-034 and 20TR2-035 in accordance with HSR1 (B) 10131. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI.

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. 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 and identified Xu Le Feng as the CWI. 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;

WR20395

Weld- BK15B-001-016, 17, 019, 020

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

Welder- 057220, 040582

1G/SMAW/CJP

WR8946

Weld- BK15B-001-013

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

Welder- 040365

1G/SMAW/CJP

Weld- BK17-001-013

WPS-B-P-2213-TC-U4c

Welder- 040533

3G/SMAW/CJP

Weld- BK17B-001-014

WPS-B-T-2233-ESAB

Welder- 040581

3G/FCAW/CJP

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08536 from ZPMC for Bay 10. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1 after ZPMC had performed their MT inspection of the following locations;

Item 1

20TR2-003-009, 013, 015, 017, 011

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At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 03-13-2011 for additional information.

Trial Assembly

This QA inspector observed ZPMC in process of SMAW welding on Lift 12 segment assemblies. ZPMC QC inspector Zhou Peng was present at this time of this observation and informed this QA inspector of the work that is in process and identified Le Yang 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;

12CW (PP117)

Weld- CA3010E-285 ~ 288

WPS-B-P-2112-FCM-1

Welder- 057333

2F/SMAW

12CW (PP116.5)

Weld- CA3010E-103 ~ 106

WPS-B-P-2112-FCM-1

Welder- 041713

2F/SMAW

WR20338

12BW

Weld- SEG3005M-090

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Welder- 046709

2G/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
