

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-022240**Date Inspected:** 24-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:**

Bay 1

This QA inspector observed ZPMC in process of SMAW weld repair welding on Re-Built traveler rail 20TR2 assemblies. 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. It was stated that ZPMC had 2 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;

WR20488

Weld- 20TR2-038-013

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

Welder- 049769

1G/SMAW/CJP

WR20391

Weld- 20TR2-044-011

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

Welder- 054467

1G/SMAW/CJP

Bay 14

This QA inspector assisted QA inspector Dennis Combs perform QA/MT per ZPMC non-destructive test (NDT)

WELDING INSPECTION REPORT

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Inspection Notification, Doc. #08614 Item 1 ~ 17 anchor plate bearing blocks. QA Magnetic Particle Test (MT) verification inspection was performed after ZPMC had performed their MT inspection of the following anchor plate bearing blocks;

Item 1 ~ 17

065-6, 064-9, 094-6, 100-14, 065-9, 050-14, 108-7, 065-13, 087-3, 082-13, 099-8, 088-8, 082-2, 121-11, 121-3, 087-5, 083-15

See Dennis Combs Caltrans Magnetic Particle Test Report (TL6028) and Caltrans Welding Inspection Report (TL6031), dated 03-24-2011 for additional information.

The following digital picture illustrates anchor plate bearing block MT verification.

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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