

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022280**Date Inspected:** 21-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei, Liu Fa Wen**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:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress

Bay Number 1

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 20TR2-040 for weld(s) 009, 011, 013, 015, & 017. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-461.

Bay Number 8

SMAW welding of plug welds located on Bike Path component identified as BK004A2-060 weld no.(s) 014, 015, 017, 019, & 020. Welder is identified as welder no. 037840. The welding variables recorded by ZPMC QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2112-plug.

FCAW welding fillet welds located on Saddle Housing component identified as SH3000 weld no.(s) 001~006. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

FCAW welding complete joint penetration welds located on Bike Path component identified as BK004A2-062 weld no.(s) 002, 008, 013, & 021. Welder is identified as welder no. 219414. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

FCAW welding complete joint penetration welds located on Bike Path component identified as BK004A6-062 weld no.(s) 001, 002, 007, & 165. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding complete joint penetration welds located on Bike Path component identified as BK004A8-062 weld no.(s) 001, 002, 007, & 130. Welder is identified as welder no. 046706. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

FCAW welding fillet welds located on Saddle House component identified as SH3012 weld no.(s) 002, 003, 004, 005, & 006. Welder is identified as welder no. 500479. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

This inspector observed ZPMC QC personnel conducting MT testing and inspection on Bike Path components identified as BK004A6-062 & BK004A8-062.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the report.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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