

**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-022329**Date Inspected:** 02-Apr-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 8**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding FCAW (ESAB) welding. ZPMC CWI Huang Min 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- LB3001-061

WPS-B-T-2232-ESAB

Welder- 219414

2G/FCAW/CJP

Weld- SB3001-061

WPS-B-T-2232-ESAB

Welder- 054459

2G/FCAW/PJP

The following digital picture illustrates welding LB30010- and SB3001- assemblies.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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## Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding traveler rails and bike path handrail assemblies. ZPMC QC inspector Wang Zhen was present at this time of this observation and informed this QA inspector of the work that is in process and identified Chen Shi Gang as the CWI. 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;

Weld- 3012TR7-001-014

WPS-B-T-2231-ESAB

Welder- 059403

1G/FCAW/CJP

Weld- 3012TR6-001-011

WPS-B-T-2231-ESAB

Welder- 059421

1G/FCAW/CJP

Weld- BK Handrail

WPS-B-T-2132

Welder- 201840

1F/FCAW (ESAB)

The following digital picture illustrates welding traveler rail 3012TR7- and 3012TR6- assemblies.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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“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.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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