

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-022396**Date Inspected:** 05-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 1

This QA inspector observed ZPMC in process of SMAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. 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- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 054456

2F/SMAW

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. ZPMC CWI Lui Fa Wen 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;

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Weld- LB3001-051
WPS-B-T-2233-ESAB
Welder- 219414
3G/FCAW/CJP

Weld- SB3001-061
WPS-B-T-2233-ESAB
Welder- 054459
3G/FCAW/CJP

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail 3016TR3-001 and 3012TR5-001. This QA inspector verified this information for the following location;

HSR1 (B) 10249
Traveler Rail
3016TR3-001-005, 006

HRS1 (B) 10251
Traveler Rail
3012TR5-001-009, 010

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 on Cantilever Box. 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 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;

WR20590
Weld- BK17-001-068
WPS-345-SMAW-1G(1F)-Repair
Welder- 500363
1G/SMAW/CJP

HRS1 (B) 10264
Cantilever Box
BK17-001

Bay 11
MT Inspection

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This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08742 from ZPMC for Bay 11 weld repairs. This QA inspector performed visual and magnetic particle test (MT) verification for Item 5, 6 after ZPMC had performed their MT inspection of the following locations;

Item 5

30TR2-001-017~020

Item 6

35TR1-001-017~020

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 04-05-2011 for additional information.

The following digital pictures illustrate MT inspected subassemblies.

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