

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-022398**Date Inspected:** 03-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 CWI 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 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- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 049769, 062810

2F/SMAW

Bay 4

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding traveler rail assembly. 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 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- 3025TR1-003-011, 004
WPS-B-T-2231-ESAB
Welder- 066439
1G/FCAW/CJP

Weld- 3026TR1-001-019, 018
WPS-B-T-2231-ESAB
Welder- 050977
1G/FCAW/CJP

Bay 7

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of performing fit-up/ tack welding on cantilever box beam. The tack welder was identified by ZPMC welder identification number. This QA inspector verified this information for the following location;

Weld- Cantilever Box
WPS-B-P-2112
Welder- 216687
2F/SMAW

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. ZPMC QC inspector Zhu Zhong Jie 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 4 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- 294TR1-002-002
WPS-B-T-2231-ESAB
Welder- 062265
1G/FCAW/CJP

Weld- 3016TR4-002-007
WPS-B-T-2231-ESAB
Welder- 203805
1G/FCAW/CJP

Weld- 3012TR3-001-005
WPS-B-T-2231-ESAB
Welder- 059378
1G/FCAW/CJP

Weld- 3012TR4-001-008
WPS-B-T-2231-ESAB

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Welder- 058443
1G/FCAW/CJP

Bay 14
UT Inspection

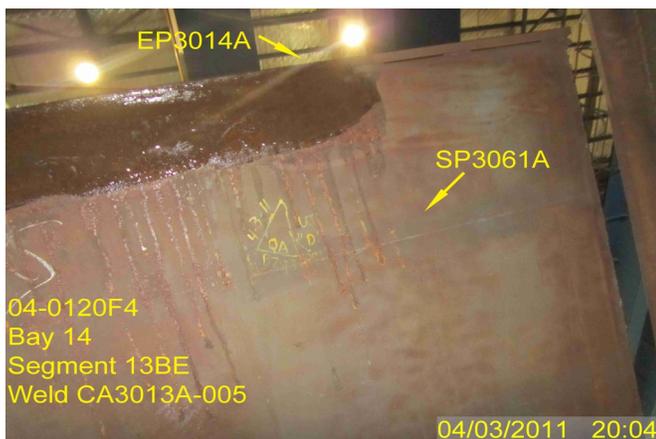
This Caltrans QA inspector received ABF UT inspection report UT-13E-015R1, dated 4-3-11 for QA verification. The segment assembly is identified as 13BE. This QA inspector performed ultrasonic test (UT) "D" scan method, after ZPMC had performed their UT inspection of the following locations.

SP to EP
CA3013A-005
Y=500 to 9300

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 04-03-2011 for additional information.

The following digital picture illustrates weld CA3013A-005.

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