

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-022699**Date Inspected:** 17-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 Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Tian Shu 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- 048659

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 performing heat straightening. 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 and identified Zhu Tian Shu as the CWI. This QA inspector verified this information for the following location;

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Heat Straightening

HSR1 (B) 10725

3007TR2-001-023

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08851 from ZPMC for QAUT verification for Bay 4. This QA inspector performed ultrasonic test (UT) verification for Item 4, after ZPMC had performed their UT inspection of the following locations.

Item 4

TB3001-009-001, TB3001-010-001, TB3001-011-001, TB3001-012-001

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 04-17-2011 for additional information.

The following digital picture illustrates bracket assemblies QAUT verification for TB3001-.

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 and heat straightening. 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 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;

WR20659

Weld- LB3001A-001-001

WPS-345-SMAW-2G(2G)-Repair

Welder- 040673

2G/SMAW/CJP

Heat Straightening

HSR1 (B) 10202

SA7535-001 ~ 011

Heat Straightening

HSR1 (B) 10201

SA7047-001 ~ 011

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. ZPMC QC 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 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;

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WR20689

Weld- 3012TR6-001-011, 012

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

Welder- 059421, 062265

1G/FCAW(ESAB)/CJP

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. ZPMC CWI Li Jun 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 7 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- X3305K-006-001, 002

WPS-B-T-2211-TC-U4b

Welder- 040586

1G/SMAW/CJP

Weld- X3305K-007-001, 002

WPS-B-T-2211-TC-U4b

Welder- 056364

1G/SMAW/CJP

Weld- X3305K-010-001, 002

WPS-B-T-2211-TC-U4b

Welder- 044511

3G/FCAW/CJP

Weld- BK010A5-001-014, 015, 024, 025

WPS-B-T-2132-ESAB

Welder- 040533

2F/FCAW

Weld- BK010A6-001-002, 007, 001, 165

WPS-B-T-2312-TC-P4

Welder- 057220, 040581, 053829

2G/FCAW/PJP

Heat Straightening

HSR1 (B) 10292

31TR3-001

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

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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
