

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-022702**Date Inspected:** 13-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 Li Zi Jiang 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;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 056281, 049769

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 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 Li Zi Jiang as the CWI. This QA inspector verified this information for the following location;

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Heat Straightening  
HSR1 (B) 10291  
3010TR1-001 ~ 016

### 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 and heat straightening. ZPMC CWI Chen Shi Gang 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 3 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;

WR20652  
Weld- 3014TR1-001-001, 002  
WPS-345-FCAW-1G-ESAB-Repair  
Welder- 059421  
1G/FCAW/CJP

Weld- X5001A-002-001  
WPS-B-T-2232-ESAB  
Welder- 059403  
2G/FCAW/CJP  
Bracket Assembly

Weld- TB-3001A-021-001  
WPS-B-T-2232-ESAB  
Welder- 059416  
2G/FCAW/CJP  
Bracket Assembly

Heat Straightening  
HSR1 (B) 10292  
3024TR

The following digital picture illustrates heat straightening of traveler rail 3024TR.

### Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening. ZPMC QC inspector Sun Zi Wang 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. This QA inspector verified this information for the following location;

Heat Straightening  
HSR1 (B) 10292  
31TR2-001-018, 020, 022, 027, 029, 030

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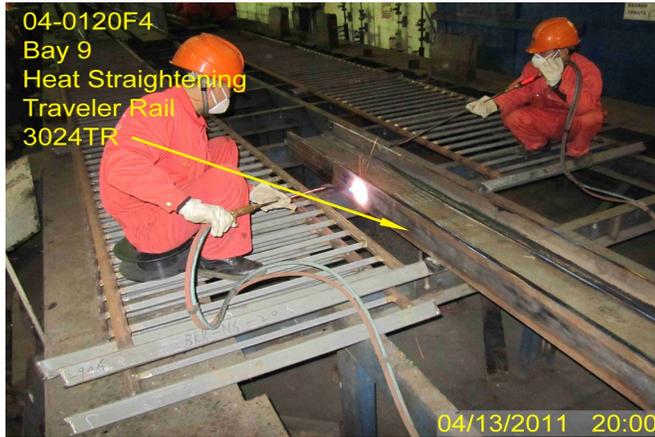
# WELDING INSPECTION REPORT

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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.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer