

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-022705**Date Inspected:** 10-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:**

Bay 1

This QA inspector observed ZPMC in process of SMAW welding Bike Path Handrail sub-assemblies. ZPMC QC Zhang Ya Xu 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 4

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on traveler rails. ZPMC QC Zhang Ya Xu 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- 3023TR1-001-006

WPS-B-T-2132-ESAB

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Welder- 068206
2F/FCAW

Bay 7

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on cantilever beam sub-assembly. ZPMC CWI Zhang Ya Xu 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;

Weld- BK79A
WPS-B-P-2113
Welder- 216687
3F/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 on 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 5 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;

WR20628
Weld- 3012TR2-001-003
WPS-345-FCAW-1G(1F)-Repair-1
Welder- 059421
1G/FCAW/CJP

Weld- 3015TR2-001-003
WPS-B-T-2231-ESAB
Welder- 059418
1G/FCAW/CJP

Weld- 3015TR2-001-004
WPS-B-T-2231-ESAB
Welder- 059416
1G/FCAW/CJP

Weld- 3013TR1-002-001
WPS-B-T-2231-ESAB
Welder- 059443
1G/FCAW/CJP

Weld- 3013TR2-002-004

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

WPS-B-T-2231-ESAB

Welder- 059378

1G/FCAW/CJP

The following digital picture illustrates preheating in progress on traveler rail 3013TR2-002-004 and 3013TR1-002-001 assemblies.

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. 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 Lu Le Feng as the CWI. It was stated that ZPMC had 6 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- 31TR3-001-041

WPS-B-P-2212-TC-U5b

Welder- 500363, 057220, 040581, 040582

2G/SMAW/CJP

Weld- BK010A8-001-003, 005, 122, 124

WPS-B-P-2114

Welder- 040365

4F/SMAW

Weld- BK010A3-001-103, 105, 104

WPS-B-P-2114

Welder- 054069

4F/SMAW

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



WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
