

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-022707**Date Inspected:** 08-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 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- 221607

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 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 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;

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Weld- 3007TR2-001-040
WPS-B-T-2231-ESAB
Welder- 066683
1G/FCAW/CJP

Weld- 3025TR1-002-011
WPS-B-T-2231-ESAB
Welder- 066683
1G/FCAW/CJP

Weld- 3023TR1-003-007
WPS-B-T-2231-ESAB
Welder- 066283
1G/FCAW/CJP

Weld- 3026TR1-001-019
WPS-B-T-2231-ESAB
Welder- 066283
1G/FCAW/CJP

Weld- 3025TR1-003-011
WPS-B-T-2231-ESAB
Welder- 066763
1G/FCAW/CJP

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 on traveler rails. 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 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- SA7535-004
WPS-B-T-2231-ESAB
Welder- 500459
1G/FCAW/CJP

Weld- SA7535-007
WPS-B-T-2231-ESAB
Welder- 054459
1G/FCAW/CJP

Weld- SA7047-005

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WPS-B-T-2231-ESAB

Welder- 054459

1G/FCAW/CJP

Weld- SB3001-001

WPS-B-T-2212-TC-U4b

Welder- 067610

2G/SMAW/CJP

Weld- LB3001-056, 061

WPS-B-T-2212-TC-U4b

Welder- 066459

2G/SMAW/CJP

The follow digital picture illustrates typical weld locations for LB3001 assembly.

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 on traveler rails. 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 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- 3012TR6-001-012

WPS-B-T-2231-ESAB

Welder- 059421

1G/FCAW/CJP

Weld- 3012TR1-001-002

WPS-B-T-2231-ESAB

Welder- 059403

1G/FCAW/CJP

Weld- 3016TR4-002-007

WPS-B-T-2231-ESAB

Welder- 059443

1G/FCAW/CJP

Weld- 3014TR1-002-002

WPS-B-T-2231-ESAB

Welder- 059378

1G/FCAW/CJP

HSR1 (B) 10260

Traveler Rail

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3013TR2-001

HSR1 (B) 10267

Traveler Rail

3012TR3-001

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 Yu Zhi Lai 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 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- 31TR-001-016

WPS-B-T-2212-TC-U5b

Welder- 500363, 040581, 040582

2G/SMAW/CJP

Weld- BK014A4-001, 004, 005, 008, 009

WPS-B-T-2132-ESAB

Welder- 054069

2FG/FCAW

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

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your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer