

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022913**Date Inspected:** 12-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

CWI Name:	Tian Lei, Liu Fa Wen, Chen Shigang			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:

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 215248. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 062810. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

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This inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

Bay Number 4

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3023TR1-001 weld no.(s) 011. Welder is identified as welder no. 066683. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3009TR1-001 weld no.(s) 009. Welder is identified as welder no. 066284. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rails component identified as 3023TR1-003 weld no.(s) 011. Welder is identified as welder no. 066763. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Bay Number 7

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08805. The member(s) is/are identified as OBG Bike Path components as identified below with the following identifying weld no.(s):

1. BK3004-001-018~023, 026~037, 040~051, 058~063, 012, 013, 016, 017.

Bay Number 8

FCAW welding of fillet welds located on Bike Path component identified as BK004A2-062 weld no.(s) 020. Welder is identified as welder no. 037840. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-P-2112-PLUG.

FCAW welding of complete joint penetration welds located on Light Pole Base component identified as SB3001A-001 as identified on weld repair data sheet B-WR-20657 for repaired complete joint penetration welds identified as weld no.(s): 001. Welder is identified as welder no. 219414. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-FCAW-3G(3F)-repair-ESAB.

Bay Number 9

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3012TR2-001 for weld(s) 003 & 004. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10261.

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FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 3014TR1-002 weld no.(s) 001. Welder is identified as welder no. 059421. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the 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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
