

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-022939**Date Inspected:** 18-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 (post to base plate) 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 Huang Min as the CWI. It was stated that ZPMC had 2 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- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 048659, 057795

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 Huang Min as the CWI. This QA inspector verified this information for the following location;

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Heat Straightening

HSR1 (B) 10291

3010TR1-001-001~016

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08864 from ZPMC for QAUT verification for Bay 4. This QA inspector performed ultrasonic test (UT) verification for Item 1, after ZPMC had performed their UT inspection of the following locations.

Item 1

30BK1-001-009, 010

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 04-18-2011 for additional information.

The following digital picture illustrates traveler rail QAUT verification.

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 on SA7047 assembly. 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 040673 appointed by ZPMC. This QA inspector observed fit-up and welding of temporary reinforcement plate to side plate SH3006A per ZPMC CX/GY-102-ZP06-787-2272 requirements.

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 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 3 welders and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20732

Weld- 3016TR1-001-001, 002

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

Welder- 062265

1G/FCAW(ESAB)/CJP

WR20733

Weld- 3014TR2-001-003, 004

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

Welder- 059421

1G/FCAW(ESAB)/CJP

Heat Straightening

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

HSR1 (B) 10281
3012TR7-001-013, 014

Heat Straightening
HSR1 (B) 10285
3014TR1-002-003, 004

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08860 from ZPMC for Bay 9. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1, 2, 3, 4 after ZPMC had performed their MT inspection of the following locations;
Item 1 TB3001A-021-001, Item 2, TB3001A-022-001, Item 3 TB3001A-023-002,
Item 4 TB3001A-024-003

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 04-18-2011 for additional information.

The following digital pictures illustrate MT inspected subassemblies.

Bay 10

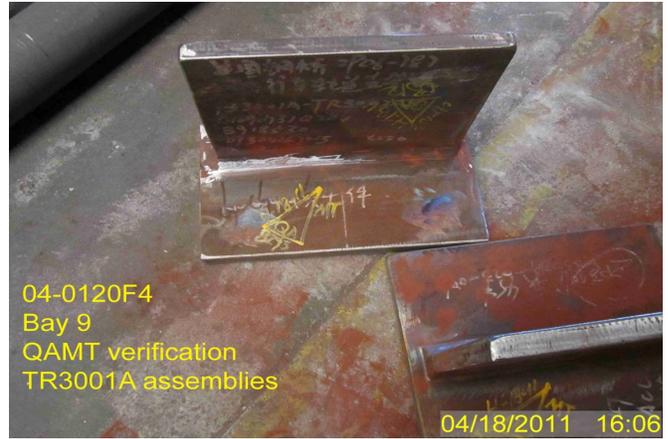
This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening. ZPMC CWI Zhu Feng was present at this time of this observation and informed this QA inspector of the work that is in process and identified Shi You as the CWI. This QA inspector verified this information for the following location;

Heat Straightening
HSR1 (B) 10292
31TR3-001

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 15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer