

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-022941**Date Inspected:** 21-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 FCAW welding Bike Path Handrail sub-assemblies. 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 3 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-T-2232-ESAB

Welder- 201840

2F/FCAW

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 054456, 215248

2F/SMAW

Post to Base Plate

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 on traveler rail assemblies to correct distortion after welding. ZPMC

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QC inspector 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 Zhu Tian Shu. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10291

3022TR1-001-001~016

3025TR1-001-001~016

Bay 8

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 Liu Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10201

SA7047 Assembly

Heat Straightening

HSR1 (B) 10202

SA7535 Assembly

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

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer