

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-023052**Date Inspected:** 02-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, China**CWI Name:** Xu Le Feng**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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #003 located on Bike Path BK17B-001. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-Tc-U4c.

Submerged Arc Welding (SAW):

Weld joint #017 located on Bike path BK17-001. Welder is identified as 050295. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-Tc-U4a-S.

Flux Cored Arc Welding (FCAW):

Weld joint #045 located on Bike path BK15A-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2132-ESAB.

Weld joint #041 located on Bike path BK16A-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #002 located on Bike path BK16C-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #048 located on Bike path BK15A-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #001 located on Bike path BK16C-001. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Heat Straightening:

Heat Straightening being performed on Traveler rail identified as 29TR1 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Jing Xiao Bo present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10186.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #013 located on Traveler Rail 33TR1-001. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U5b.

Weld joint #013 located on Traveler Rail 33TR1-001. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U5b.

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

Summary of Conversations:

No Relevant Conversations.

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 Thomas Ho - 15002048250, who represents the Office of Structural Materials for

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your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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