

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-024019**Date Inspected:** 03-May-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:** Mr. Li Yan Hua**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,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 001, 002 as per WRR no. B-WR-20855, Located on U Rib splice plate X3305K-040.

Welder is identified as 067611. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair.

Flux Cored arc welding (FCAW)

Repair welding of Weld joint- 003 as per WRR no. B-WR-20894, Located on Container Box Bracket BK 016-001.

Welder is identified as 044473. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-Repair.

Repair welding of Weld joint- 022 as per WRR no. B-WR-20894, Located on Container Box Bracket BK 016-001.

Welder is identified as 052493. ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The

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welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored arc welding (FCAW)

Weld joint- 015/016 Located on Bike path panel BK-25A6-001. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 094/ 095 Located on Bike path panel BK-25A8-001. Welder is identified as 062739. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 061/ 062 Located on Bike path panel BK-25A8-001. Welder is identified as 062739. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Heat Straightening:

Heat Straightening being performed on Cable Bracket identified as SA 6030-001 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10329.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint- 001, Located on Bike path Hand rails, FS02. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint- 003, Located on Bike path Hand rails, FS17. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

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For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer