

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-024050**Date Inspected:** 10-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:** 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 performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening bike path handrail. ZPMC CWI Huang Min 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) 10267

BKR-NS-3 Assembly

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail. ZPMC QC inspector Li Wei Lin 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;

Heat Straightening

HSR1 (B) 10291

3023TR1-001,

Heat Straightening

HSR1 (B) 10291

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3025TR1-003-001~011

Bay 7

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on bike path cantilever box beam. ZPMC QC Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder operator by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BKSA015-001-016
WPS-B-T-2221-TC-U4a-S-2
Welder- 044771
1G/SAW/CJP

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 on bike path 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 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 3009TR2-001-018, 019, 024, 029, 030
WPS-B-T-2231-ESAB
Welder- 059416
1G/FCAW/CJP

Weld- 3009TR2-001-025
WPS-B-T-2231-ESAB
Welder- 059421
1G/FCAW/CJP

Heat Straightening
HSR1 (B) 10262
3014TR2-002

Heat Straightening
HSR1 (B) 10250
3014TR1-001

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

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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
