

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-024573**Date Inspected:** 05-Jun-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 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. 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- BK012A5-001-002 (WR21205)

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

Welder- 044541

1G/SMAW/CJP

Weld- BK012A5-001-008 (WR21205)

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

Welder- 044541

1G/SMAW/CJP

Weld- BK012A5-001-121

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WPS-B-T-2233-ESAB

Welder- 205649

3F/FCAW

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of fit-up tack welding on cantilever truss sub-assemblies. 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 4 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- Cantilever Truss Assembly

WPS-B-T-2232-ESAB

Welder- 201840, 059416, 059403, 059378

2F/FCAW

Bay 16

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on steel barriers. ZPMC QC inspector Guo Xing Hui was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Yan Hua as the CWI. It was stated that ZPMC had 2 welders performing VT repairs and identified the welders by ZPMC welder identification (#201861, 201905) number appointed to then by ZPMC.

Bay 14

This QA inspector observed ZPMC in process of heat straightening on Bike Path traveler rails. ZPMC CWI Li Yan Hua 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) 10295

3003TR1

Heat Straightening

HSR1 (B) 10294

3007TR1

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

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your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer