

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-026084**Date Inspected:** 31-Jul-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 9

This QA inspector observed ZPMC flux cored arc welding (FCAW). During the observation performed it was noted that in Bay 9 ZPMC was in the process of welding and heat straightening bike path traveler rails. CWI Chen Shi Gang informed this QA inspector of the work in process. It was stated that ZPMC had 3 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- 3018TR1-018

WPS- B-T-2231-ESAB

Welder- #059421, 059416, 059418

1G/FCAW/CJP

Heat Straightening

HSR1 (B) 10415

3017TR1-001 & 3017TR2-001

The following digital picture illustrates traveler rail 3018TR1-018.

Bay 16

This QA inspector observed ZPMC heat straightening. During the observation performed it was noted that ZPMC was in the process of heat straightening handrails. ZPMC QC inspector Guo Xing Hui was present at the time of

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this observation and informed this QA inspector of the work in process. It was stated that ZPMC had 1 worker heat straightening bike path handrails. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10418

BKR-FS1

Bay 19

This QA inspector observed ZPMC FCAW welding. During the observation performed it was noted that in Bay 19 ZPMC was in the process of welding bike path assembly. ZPMC QC inspector Guo Xing Hui informed this QA inspector of the work in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK9003A7-001

WPS- B-T-2232-ESAB

Welder- #062849

2G/FCAW/PJP

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer