DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016606
Date Inspected: 31-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name:	Wang Jie/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, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

In process Inspection

OUT SIDE YARD

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the OBG Segment 12AE Lifting Lug at Panel point111, weld No: SEG3001H-224. The welder is identified as #216086. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2213-TC-U4B-FCM-1. Please see the attached picture.

This QA Inspector observed the following work in progress:
SMAW in the 2G position for the OBG Segment 12AE Lifting Lug at Panel point111, weld No: SEG3001H-246. The welder is identified as #050232. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2212-TC-U4B-FCM-1. Please see the attached picture.

Bay #14

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment 13BE Bottom Panel, weld No: SEG3009A-005. The welder is

identified as #044771. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed the following work in progress:
FCAW in the 1G position for the OBG Segment 13AE Side Panel, weld No: SEG3015A-007. The welder is identified as #217805. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the OBG Segment 13BW, weld No: CA3015-009. The welder is identified as #202122. ZPMC QC is identified as Mr. Xia Chuan hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4B-F.

This QA Inspector observed the following work in progress:
FCAW in the 2F position for the OBG Segment 13CW, weld No: CA3016C-163/164. The welder is identified as #047866. ZPMC QC is identified as Mr. Xia Chuan hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132-F.

This QA Inspector observed the following work in progress:
FCAW in the 3F position for the OBG Segment 13BW, weld No: CA3015C-082/083. The welder is identified as #201215. ZPMC QC is identified as Mr. Xia Chuan hui. The welding variables recorded by QC appear to comply with WPS-B-T-2133-F. Please see the attached picture.

Visual Inspection after Blast

CROSSBEAM 11

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Side panels and Bottom panel of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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

WELDING INSPECTION REPORT

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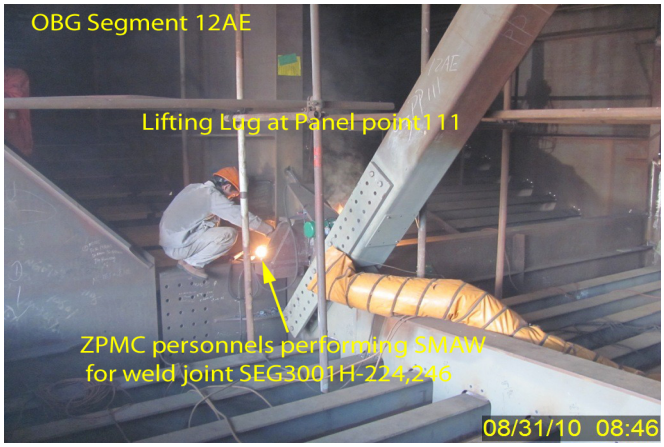

Summary of Conversations:

No Relevant Conversation.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer