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

Bay Area Branch
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Contract #: 04-0120F4
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-017395
Date Inspected: 21-Sep-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:	Mr.Wang Jie/Lv Li Qing	**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

OUTSIDE YARD

This QA Inspector observed the following work in progress:
SMAW in the 2F position for the OBG Segment 12CE, weld No: SEG3003B-021/022. The welder is identified as #068501. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2132.

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the OBG Segment 12AE X3S Plate, weld No: SEG3012-053. The welder is identified as #044772. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-4213-TC-U4B-2.

Bay #19

This QA Inspector observed the following work in progress:
FCAW in the 3F position for the Bike Path, weld No: BK004A6-008-032/033. The welder is identified as #062806.

ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

This QA Inspector observed the following work in progress:
FCAW in the 3G position for the Bike Path, weld No: BK004A6-003-082. The welder is identified as #062755. ZPMC QC is identified as Mr.Guo Xing Hui.The welding variables recorded by QC appear to comply with WPS-B-T-2333-TC-P4-F.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the Suspender Bracket, weld No: SB017-086-001. The welder is identified as #062786. ZPMC QC is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the Suspender Bracket, weld No: SB020-088-008. The welder is identified as #062783. ZPMC QC is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

Bay #16

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: LD3031-001-033 located on OBG Segment 13 . Welder is identified as #045143. ZPMC CWI is identified as Mr. Wang Jie. Welding was performed according to the weld repair report B-WR15167.The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G(2F)-FCM-Repair.

Bay #14

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: KP3001-001-007 located on OBG Segment 13AE Bottom Plate. Welder is identified as #200113. ZPMC CWI is identified as Mr. Lv Li Qing. Welding was performed according to the weld repair report B-WR15182 and UT report number: B787-UT-15318.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)- FCM -Repair.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the OBG Segment 13AE, weld No: VP3002A-001-004. The welder is identified as #067079. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F. Please see the attached picture.

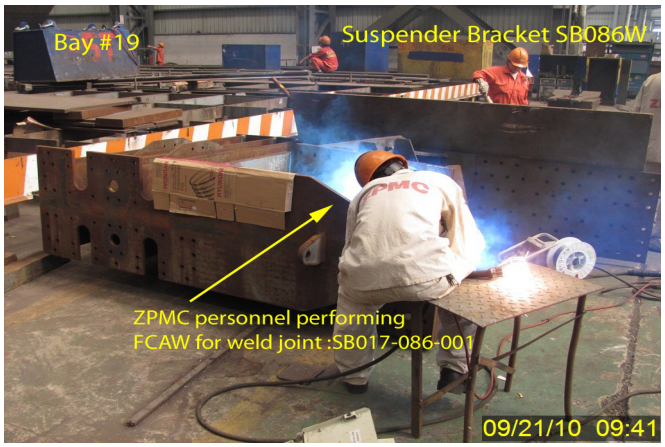
This QA Inspector observed the following work in progress:
FCAW in the 2G position for the OBG Segment 13BE, weld No: VP3004-001-006. The welder is identified as #066439. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

Visual Inspection after Blast

Segment 11CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Deck panel and Corner Assembly 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.



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