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-019802
Date Inspected: 27-Oct-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: 1900
OSM Departure Time: 700
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:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 14
Shielded Metal Arc Welding (SMAW) in the flat (1G) position for the OBG segment 13BW, weld No. SEG3014L-193. The welders are identified as #047866, 201215 and 202122. Welder direct current amp reading was 290, 300, and 305. Welder direct current voltage reading was 29.5, 29.5, and 30.2. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2232-TC-U4B-F.

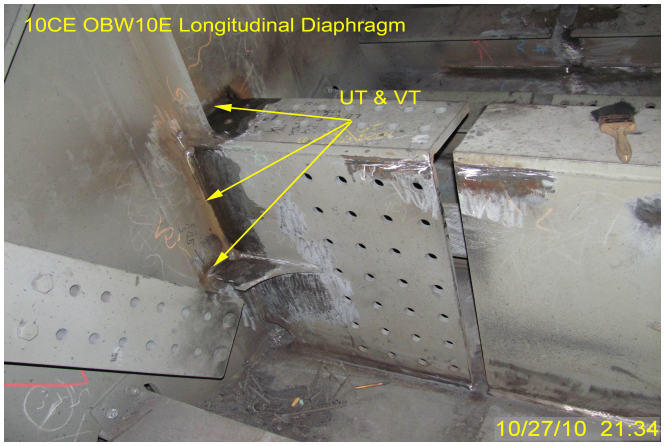
This QA Inspector performed VT and assisted in the performance of UT testing on approximately 20% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 VT and UT requirements. The member(s) is/are identified as 10CE Longitudinal Diaphragm, weld #SEG68C-057, OBE10E-009 and OBE10E-030.

This QA Inspector performed VT and assisted in the performance of UT testing on approximately 20% of the areas previously tested and accepted by ZPMC Quality Control personnel. The items observed by this Inspector, appears to comply with AWS D1.5 VT and UT requirements. The member(s) is/are identified as 10CE Longitudinal Diaphragm, weld #SEG68B-057, OBE10E-018, and OBE10E-025.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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



Summary of Conversations:

No significant conversations

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.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer