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 #: 99.28

WELDING INSPECTION REPORT

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

Report No: WIR-025164
Date Inspected: 10-Nov-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

CWI Name:	Tian Lei			**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 R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) Traveler Rail component identified as 20TR2-032. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR1(B)-362.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1-039 weld number(s) 001~012, 032~043, & 063~074. Welder is identified as welder no. 064571. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB5-021 weld number(s) 001~012, 032~043, & 063~074. Welder is identified as welder no. 215397. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

FCAW welding of fillet welds located on Barrier Rails components identified as E2-SB1-030 weld number(s) 026~031, 057~062, 088~093, 106, 108, 122, & 124.. Welder is identified as welder no. 068916. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

Bay Number 2

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Anchorage Plate component identified as AP3032-001 weld number(s) 614 & 615. Welder is identified as welder no. 068294. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Anchorage Plate component identified as AP3032-001 weld number(s) 1006 & 1007. Welder is identified as welder no. 066359. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Anchorage Plate component identified as AP3032-001 weld number(s) 299 & 300. Welder is identified as welder no. 067500. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Anchorage Plate component identified as AP3032-001 weld number(s) 352 & 353. Welder is identified as welder no. 066673. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Anchorage Plate component identified as AP3032-001 weld number(s) 1031 & 443. Welder is identified as welder no. 066041. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS-B-T-2233-TC-U4b-F.

Bay Number 3

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3286-001 weld number(s) 275. Welder is identified as welder no. 064949. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4c-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3286-001 weld number(s) 095. Welder is identified as welder no. 067036. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4c-F .

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3286-001 weld number(s) 383. Welder is identified as welder no. 068501. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4c-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3286-001 weld number(s) 294. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4c-F.

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3315A-001. This QA inspector signed green tag #15330.

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3315C-001. This QA inspector signed green tag #15331.

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3315B-001. This QA inspector signed green tag #15332.

Bay Number 4

This QA inspector assisted in the performance MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector assisted in the generation an MT report for this date by inspector lot no. All components were as listed on NWIT notification no. 07300. The member(s) is/are identified as OBG Sub Assembly component. The weld designations reviewed are as follows:

1. SA3364-001-002~005, 009, 010, 012, 013, 018, & 019.
2. SA3365-001-002~005, 009, 010, 012, 013, 018, & 019.
3. SA3358-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.
4. SA3359-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.
5. SA3360-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.
6. SA3361-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.
7. SA3362-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.
8. SA3363-001-003, 005, 007, 009, 013, 014, 016, 017, 022, & 023.

Performed verification VT for the component(s) and corresponding welds for component on OBG Sub Assembly component listed as SA3326A, SA3326B, SA3327A, SA3327B, SA3328A, SA3328B, SA3329A, & SA3329B. This QA inspector signed green tag #15348.

Performed verification VT for the component(s) and corresponding welds for component on OBG Sub Assembly component listed as SA3330A, SA3330B, SA3331A, SA3331B, & SA3332A. This QA inspector signed green tag #15349.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the 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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer