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-023823
Date Inspected: 10-Jan-2011

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, Liu Fa Wen

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

CWI Present: ☑ Yes ☐ No

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 components identified as 9TR2-002, 9TR2-001, 9TR1-001, & 9TR1-002. 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. HSR(B)-404.

Bay Number 3

FCAW welding of complete join penetration welds located on Architectural Housing component identified as AH3152 for weld no. 001. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

SMAW welding of complete join penetration welds located on Side Plate component identified as SP3083-001 for weld no. 001 & 003. Welder is identified as welder no. 050359. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2213-TC-U4b.

SMAW welding of complete joint penetration welds located on Traveler Rail component identified as 20TR2-032 as identified on weld repair data sheet B-WR-20048 for welds identified as weld no.(s): 009. Welder is identified as welder no. 058102. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-repair.

SMAW welding of complete joint penetration welds located on Traveler Rail component identified as 20TR2-032 as identified on weld repair data sheet B-WR-20049 for welds identified as weld no.(s): 013. Welder is identified as welder no. 037997. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-repair.

Bay Number 8

FCAW welding of complete join penetration welds located on Bike Path component identified as BK004A8-064 for weld no.(s) 001, 002, 007, & 130. Welder is identified as welder no. 500405. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2232-ESAB.

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

WELDING INSPECTION REPORT

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Reviewed By: Hall,Steven QA Reviewer