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-021863
Date Inspected: 20-Mar-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			**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

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 062810. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 20TR2-038 for weld(s) 009, 011, 013, 015, & 017. 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)-461.

Bay Number 8

This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. All components were as listed on NWIT notification no. 08583. The member(s) is/are identified as OBG Bike Path as component BK4A-062.

SMAW welding of plug welds located on Bike Path component identified as BK004A2-060 weld no.(s) 014, 015, 017, 019, & 020. Welder is identified as welder no. 037840. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2112-plug.

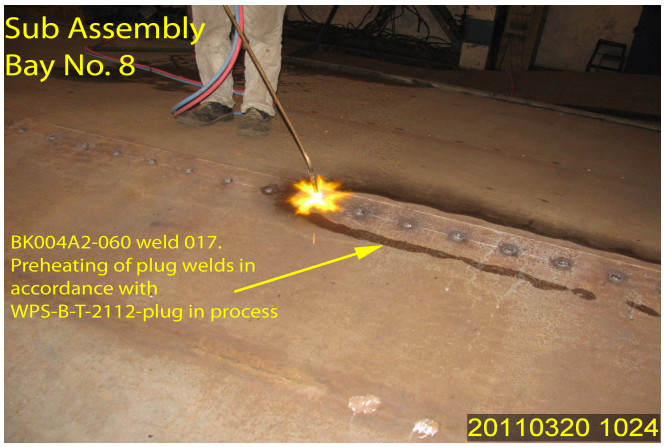
FCAW welding fillet welds located on Saddle Housing component identified as SH3000 weld no.(s) 001, 002, 003, 004, 005, & 006. Welder is identified as welder no. 054459. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

FCAW welding fillet welds located on Saddle Housing component identified as SH3005 weld no.(s) 002, 003, 004, & 005. 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-2132-ESAB.

FCAW welding fillet welds located on Saddle House component identified as SH3012 weld no.(s) 002, 003, 004, 005, & 006. Welder is identified as welder no. 500479. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

This inspector observed ZPMC QC personnel conducting UT testing and inspection on Sub Assembly components identified as SA7535 & SA7047.

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