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-023966
Date Inspected: 18-May-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:	Liu Fa Wen, Chen Shigang			**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

This inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

Bay Number 5

This inspector observed ABF QA personnel performing MT examination on traveler rail component identified as 29BK1-001.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 09165. The member(s) is/are identified as OBG Traveler Rail sub assembly components identified below with the following identifying weld no.(s):

1. 3023TR1-001-001~011.
2. 3025TR1-001-001~011.

3. 3026TR1-001-007~019.
4. 3007TR2-001-032, 033, 035~043.

Bay Number7

FCAW welding of complete joint penetration welds located on Cantilever Box Bracket Assembly component identified as BK3003-001 weld no.(s) 008. Welder is identified as welder no. 502818. The welding variables recorded by ZPMC QC identified as Mr. Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Bay Number 9

Performed verification VT for the component(s) identified as OBG Travelr Rail assembly for component listed as 3013TR1-002 & 3013TR2-002. This QA inspector signed green tag #16073.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09166. The member(s) is/are identified as OBG Traveler Rail sub assembly components identified below with the following identifying weld no.(s):

1. SA8015-001-001~006.
2. SA8015-002-001, 002.
3. SA7031A,B-001-001.
4. SA7026-001~005-001.
5. SA7505A-001~005-001.
6. SA7026B,C-001,002-001.
7. SA7506A~E-001-001.
8. SA3214-001-001~003.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 09165. The member(s) is/are identified as OBG Traveler Rail sub assembly components identified below with the following identifying weld no.(s):

1. 3013TR1-002-001/002.
2. 3013TR2-002-003/004.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3009TR2-001 weld no.(s) 001~011 & 3003TR2-001 weld no.(s) 001~011. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10358.

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