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-023984
Date Inspected: 05-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, China

CWI Name: An Qing Xiang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Components

Summary of Items Observed:
On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING
This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 066361, 045246 perform repair welding by Shielded Metal Arc Welding (SMAW), on vertical Anchor plate to top Anchor plate weld at panel point PP126 of OBG Segment 14W. Weld joint is identified as SEG3020U-591. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Critical Welding Repair report B-CWR2943 R0. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066479 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib to Floor beam weld at panel point PP125.5 of OBG Segment 14W. Weld joint is identified as SEG3020T-100. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

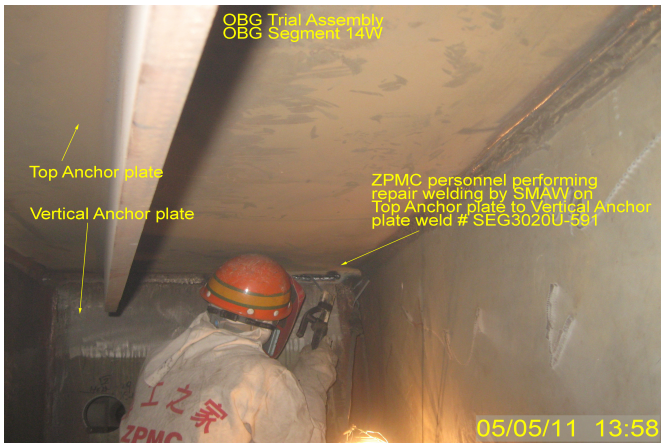
This QA Inspector observed ZPMC qualified welding personnel identified as 070432 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib to Floor beam weld at panel point PP126 of OBG Segment 14W. Weld joint is identified as SEG3020R-199. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066695 perform welding by Flux Cored Arc Welding (FCAW), on Floor beam FB3315 at panel point PP125 of OBG Segment 14W. Weld joint is identified as FB3315-001-032. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2231-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 058100 perform welding by Submerged Arc Welding (SAW), on Deck plate of OBG Segment 13AE to Deck plate of OBG Segment 13BE weld. Weld joint is identified as OBE13-002. ZPMC Quality Control (QC) Inspector identified as Wang Li Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2221-B-U2-S-4. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 045196 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as DP3147-001-223, 224. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

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



Summary of Conversations:

No significant conversations were reported on this date.

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, phone: 15000422372 , who represents the Office of Structural

WELDING INSPECTION REPORT

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Materials for your project.

Inspected By:	Upadhye,Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer