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: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012356
Date Inspected: 17-Feb-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: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Chen Xi

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 date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay breakdown
Bay#1&3
FCAW welding performed on Traveler rail at bay#1 and bay#3 by welder 219188 and 214945, One ZPMC quality control personal Yin Dong Hai and two ABF personals were present during welding. For further information, please see attached pictures.

Bay#2
No work performed by ZPMC Personal

Bay#5, 6, 7 and 8
No work performed by ZPMC Personal

Bay#1
FCAW welding of weld joint 20TR1-019-005 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-019-007 located on Traveler Rail 20TR1. Welder is identified as 219188

(1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-019-001 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

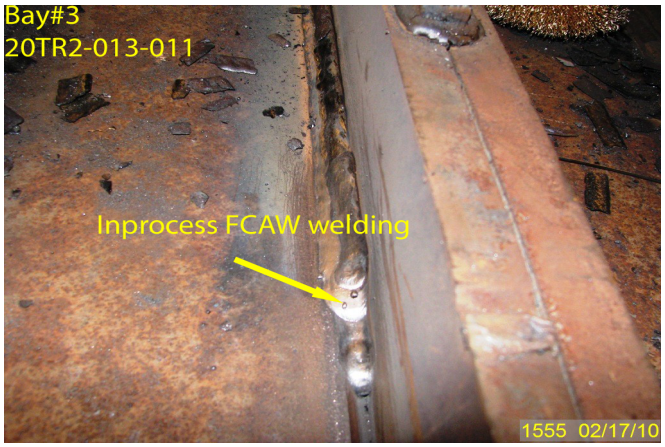
FCAW welding of weld joint 20TR1-020-003 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#3
FCAW welding of weld joint 20TR2-013-011 located on Traveler Rail 20TR1. Welder is identified as 214945 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-013-015 located on Traveler Rail 20TR1. Welder is identified as 214945 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-013-013 located on Traveler Rail 20TR1. Welder is identified as 214945 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

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



Summary of Conversations:
No relevant conversations.
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 150-0042-2372, who represents the Office of Structural Materials for

your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer