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-017119
Date Inspected: 20-Sep-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: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Chen Xi			**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 COMPONENT

Summary of Items Observed:

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

In process Inspection
Bay#1
This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG steel Barrier, weld No.E2-SB1-005-077/078. The welder is identified as #216575. ZPMC QC is identified as Mr. Xiang Feng Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

FCAW in the 1G position for the OBG Traveler rail UT repair, weld No.20TR2-032-009. The welder is identified as #203710. ZPMC QC is identified as Mr.Xiang Feng Feng. The welding variables recorded by QC appear to comply with WPS-345-FCAW-1G(1F)-REPAIR-1. Weld repair report is identified as WR14303.

FCAW in the 2F position for the OBG steel Barrier, weld No.E2-SB1-007-086/087. The welder is identified as #069043. ZPMC QC is identified as Mr. Xiang Feng Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

FCAW in the 2F position for the OBG steel Barrier, weld No.E2-SB2A-003-126/129. The welder is identified as #059450. ZPMC QC is identified as Mr. Xiang Feng Feng. The welding variables recorded by QC appear to

comply with WPS-B-T-2132-3.
Bay#2
This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG vertical Plate ,UT repair, weld No.VP3013-001-001. The welder is identified as #045276. ZPMC QC is identified as Mr.Zhu Lin. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR-1. Weld repair report is identified as WR15203.

SAW in the 1G position for the OBG Segment 14W, weld No.LD3048-001-004. The welder is identified as #250050. ZPMC QC is identified as Mr. Zhu Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 2F position for the OBG steel Barrier, weld No.W5-SB1-031-126/133. The welder is identified as #045203. ZPMC QC is identified as Mr. Zhu Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

SAW in the 1G position for the OBG Segment 14W, weld No.LD3048-001-005. The welder is identified as #250050. ZPMC QC is identified as Mr. Zhu Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Bay#3
This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG segment 14E, weld No.FB3260-001-080/081. The welder is identified as #055491. ZPMC QC is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

FCAW in the 3G position for the OBG segment 14E, weld No.LD3040-001-028/029. The welder is identified as #206623. ZPMC QC is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3G position for the OBG Floor Beam, weld No.FB3287-001-021/022. The welder is identified as #044815. ZPMC QC is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

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

WELDING INSPECTION REPORT

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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:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer