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-017167
Date Inspected: 24-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:	Mr.Xu Tao			**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, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (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. The member is identified as Bike Path 002. The weld designation reviewed is as follows:

BK004A8-002-076,082,096,090,088,072,073
BK004A5-002-003,008,005
BK004A3-002-043,044
BK004A2-002-004,005
BK004A4-002-006,007,032,033

Bay #14

This QA inspector performed Magnetic Particle Testing (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. The

member is identified as OBG 12AW. The weld designation reviewed is as follows:

SSD25-PP-112-037,038,190,187,193,196,209,218

Visual Testing:-

This QA inspector performed random visual testing of the area previously tested and accepted by ZPMC Quality Control Personnel. The member is identified as Bike Path 002. The weld designation reviewed is as follows:

BK004A4-002-080,100,083,102,082,101,085,103,086,104,087,105
BK004A3-002-065,100,067,101,068,102,069,103,070,104,071,105

In process Inspection

Bay #19

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: BK4ASD1-012-006 located Bike Path 012. Welder is identified as #062808. ZPMC CWI is identified as Mr. Xu Tao. Welding was performed with the temporary weld repair report .The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-Repair. Please see the attached picture.

This QA Inspector observed the following work in progress:
FCAW in the 1G position for the Bike Path, weld No: BK004A1-011-008. The welder is identified as #208632. ZPMC CWI is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the Suspender Bracket, weld No: SB020-086-004. The welder is identified as #062762. ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:
FCAW in the 2G position for the Suspender Bracket, weld No: SB020-090-004. The welder is identified as #062749.ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

Bay #14

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment 13BW, weld No: SEG3014*-004. The welder is identified as #045270. ZPMC QC is identified as Mr. Li Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2. Please see the attached picture.

WELDING INSPECTION REPORT

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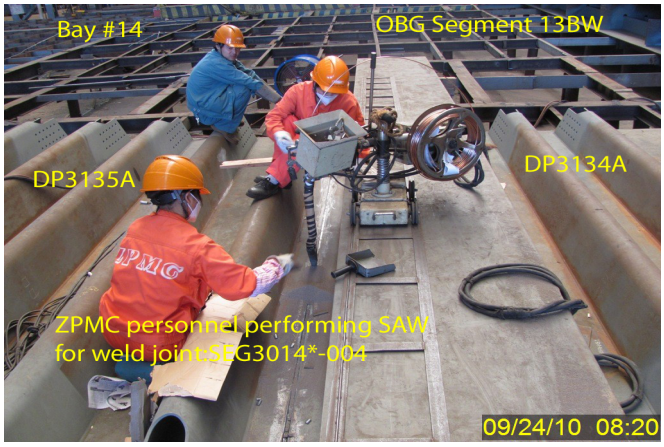
This QA Inspector observed the following work in progress:
FCAW in the 2F position for the OBG Segment 14, weld No: AP3018-062/063. The welder is identified as #201215. ZPMC QC is identified as Mr. Li Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

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



Summary of Conversations:
No Relevant Conversation.

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:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer