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-018469
Date Inspected: 03-Dec-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: 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: Orthotropic Box Girder(OBG)

Summary of Items Observed:

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

Trial assembly yard, 11EE-12AE, SP-BP-E3, hold back area.

SMAW welding of weld joint SEG074A-012, SEG3001A-011; located at Trial assembly yard. Welder is identified as 0538715; ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1.

Trial assembly yard, 11EE-12AE, SP-BP-E4, hold back area.

SMAW welding of weld joint SEG074A-011, SEG3001A-015; located at Trial assembly yard. Welder is identified as 044515; ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1. The attached photographs provide additional detail.

Trial assembly yard, 11EE-12AE, Longitudinal diaphragm to floor beam, BK side.

SMAW welding of weld joint SEG3001W-009; located at Trial assembly yard. Welder is identified as 050289; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-TC-U4B-FCM-1. The attached photographs provide additional detail.

Trial assembly yard, 11EE-12AE, Deck panel I-rib splice, BK side.

SMAW welding of weld joint DP721-001-013, 014, 015; located at Trial assembly yard. Welder is identified as 040320; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4114-1.

Trial assembly yard, 11EE-12AE, Side panel T-rib, Hold Back area.

FCAW welding of weld joint SP3002-001-022, 023, 024; located at Trial assembly yard. Welder is identified as 040367; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-ESAB.

Trial assembly yard, 11EW-12AW, Side panel T-rib, Hold Back area.

FCAW welding of weld joint SP144-001-025, 026, 027; located at Trial assembly yard. Welder is identified as 049220; ZPMC Quality Control Inspector (QC) is identified as She Li. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-ESAB.

Trial assembly yard, 11EW-12AW, Deck panel I-rib splice.

SMAW welding of weld joint DP682-001- 014, 015, 016; located at Trial assembly yard. Welder is identified as 057333; ZPMC Quality Control Inspector (QC) is identified as Wang Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4114-1.

This QA Inspector carried out NDE on following

Trail assembly yard, 11CE-11DE.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11E-076R1) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Side panel & Edge panel at the transverse splice between OBG segment 11CE-11DE. The weld designations were as;

1) CA088-001. (11CE-11DE, SP-EP-E1, Hold back area);
2) CA090-005. (11CE-11DE, SP-EP-E1, Hold back area).

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer