**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-018547
**Date Inspected:** 06-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:** Zhu Zhong Hai.

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| **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, EP-F9, I-rib hold back area.

SMAW welding of weld joint EP161-001-009, EP3001-001-024; located at Trial assembly yard. Welder is identified as 040320; ZPMC Quality Control Inspector (QC) is identified as Zhu zhong hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1. The attached photographs provide additional detail.

Trial assembly yard, 12AW, Longitudinal diaphragm to Floor beam, CB side.

FCAW welding of weld joint SEG3004T-017; located at Trial assembly yard. Welder is identified as 040759; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-ESAB.

Trial assembly yard, 12AW, Longitudinal diaphragm to Floor beam, CW side.

FCAW welding of weld joint SEG3004W-017; located at Trial assembly yard. Welder is identified as 049220; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-ESAB.

Trial assembly yard, 11EE-12AE, SP-EP-E6, hold back area.

SMAW welding of weld joint CA093-005, SEG3001AA-002; located at Trial assembly yard. Welder is

identified as 050289; 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-TC-U4B-FCM-1. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following
Subassembly, Bay 14, 13CW.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-13W-006R1) 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 Deck panel & Edge panel at OBG segment 13CW. The weld designations were as;

CA3016-100. (13CW, DP-EP-E5).

Unless otherwise noted, all work 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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