DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019053
Date Inspected: 01-Jan-2011

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:	Li Yang			**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 Segment

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 1

This QA Inspector performed dimensional survey inspection on the traveler rail to verify the thickness of flange, flange width, web to flange offset, rail length, rail sweep, depth between the flanges and flange tilt using vernier caliper, measuring tape, right angle and string line. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The traveler rail designations were as follows:

20TR2-047
20TR2-029

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) horizontal position on side panel piece mark no. OBE12D. The location was the complete joint penetration groove weld joining the side panel of segment 12AE and 12BE at work point E4 to E6. The welder ID was 044515. The welding was performed against welding repair report B-WR19739. The ZPMC CWI was identified as Li Yang.

The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) horizontal position on side panel piece mark no. OBE12D. The location was the complete joint penetration groove weld joining the side panel of segment 12AE and 12BE at work point E4 to E6. The welder ID was 050284. The welding was performed against welding repair report B-WR19739. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (12AW-12BW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) horizontal position on bottom panel piece mark no. OBW12B. The location was the complete joint penetration groove weld joining the bottom panel of segment 12AW and 12BW at work point W3 to W4. The welder ID was 040611. The welding was performed against welding repair report B-WR19714. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (12AE)

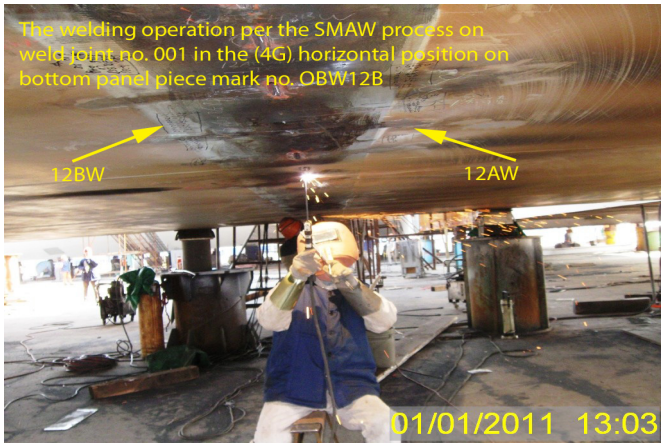
The QA Inspector observed the buttering operation per the SMAW process on ‘I’ stiffener, RS3035D in the (3G) vertical position on deck panel of segment 12AE. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR19617. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-3G (3F)-Repair.

The QA Inspector observed the buttering operation per the SMAW process on ‘I’ stiffener, RS3035D in the (3G) vertical position on deck panel of segment 12AE. The welder ID was 040270. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR19617. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-3G (3F)-Repair.

The QA Inspector observed the buttering operation per the SMAW process on ‘I’ stiffener, RS3035D in the (3G) vertical position on deck panel of segment 12AE. The welder ID was 044515. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR19617. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-3G (3F)-Repair.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations were reported on this date.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer