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-019485
Date Inspected: 22-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:	Liu Hua Jie			**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 day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection
Trial Assembly
This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12CW weld No.SEG3006A-012. The welder is identified as #040611. ZPMC QC is identified as Mr.Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG Segment 12BW weld No.SEG3005A-003. The welder is identified as #040611. ZPMC QC is identified as Mr.Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 3G position for the OBG Segment 12BW to 12CW weld No.SP3039-001-049. The welder is identified as #041713. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 4G position for the OBG Segment 12BE weld No.DP3016-001-021. The welder is identified as #050289. ZPMC QC is identified as Mr.Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 12CE weld No.DP3029-001-009. The welder is identified as #050289. ZPMC QC is identified as Mr.Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 2F position for the OBG Segment 12CW weld No.SP3044-001-015/016. The welder is identified as #053486. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-T-2132-ESAB.

FCAW in the 2F position for the OBG Segment 12BW weld No.SP3040-001-031/032. The welder is identified as #053486. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-T-2132-ESAB.

SMAW in the 4G position for the OBG Segment 12BW to 12CW weld No.DSP3052-001-048. The welder is identified as #046709. ZPMC QC is identified as Mr. Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

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:	Dsouza,Christopher	QA Reviewer